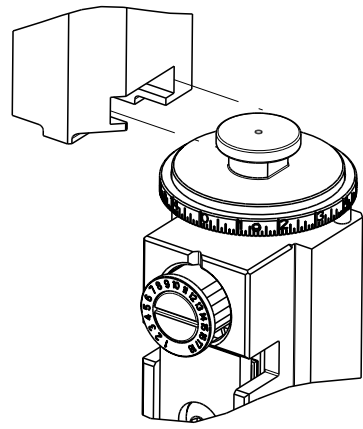


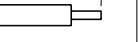
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THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151449-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151449-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151449-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151449-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151449-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	3.40 mm [.134]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: FEMALE RECEPTACLE TERMINAL			
WIRE STRIP LENGTH 4.20-5.00 mm [.165-.197 IN]		INSULATION DIAMETER RANGE Ø2.36-2.74 mm [.093-.108 IN]	
TERMINAL APPLICATION SPECIFICATION		MOLEX 63900-8400-C	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949997-1	19420-0002	1949997-2	19420-0004

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: FEMALE RECEPTACLE TERMINAL			
WIRE STRIP LENGTH 4.20-5.00 mm [.165-.197 IN]		 INSULATION DIAMETER RANGE Ø 1.00 mm NOMINAL	
TERMINAL APPLICATION SPECIFICATION 		MOLEX 63900-8400-C - - -	
TERMINALS APPLIED 			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949997-1	19420-0002	1949997-2	19420-0004

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.20+/-0.05 [.047+/- .002]	6.3
20 AWG	1.15+/-0.05 [.045+/- .002]	7.0
22 AWG	1.10+/-0.05 [.043+/- .002]	7.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	1.05+/-0.05 [.041+/- .002]	7.6



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

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

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			2	REVISED	19DEC2014	XZ	UG
			A	RELEASED	28OCT2014	YY	UG
			B	ECR-18-016124	11OCT2018	FZ	KZ
			C	ECR-19-006982	01MAY2019	LG	TE

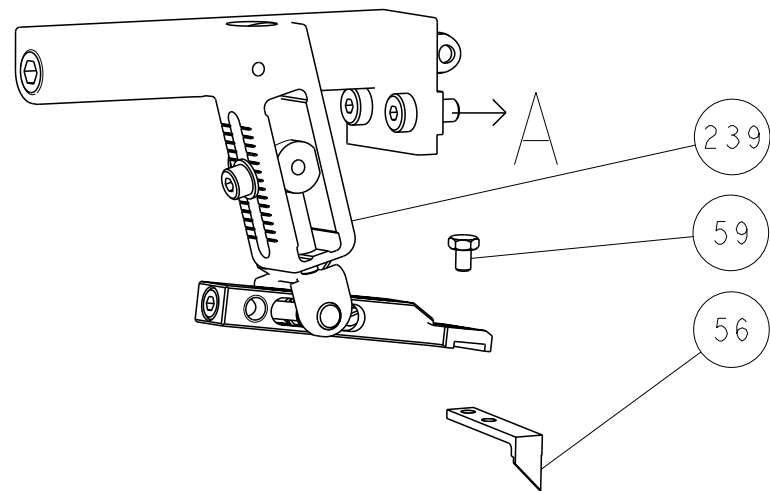
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	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	1803607-1	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	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-0	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	1320928-1	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	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	1-1633620-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	3-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	2	2	1	4-1673600-5	CRIMPER, WIRE	1
-	77-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN C. CHEN 06 JUN 2012	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm				CHK S. XI 06 JUN 2012	NAME Ocean Side Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD J. CRUZ 06 JUN 2012	PRODUCT SPEC		
MATERIAL -				FINISH -	APPLICATION SPEC		
				WEIGHT -	SIZE A1		
				Customer Accessible Production Drawing			RESTRICTED TO -
				SCALE 1:2			SHEET 1
				DRAWING NO 00779			OF 4
				REV C			REV C

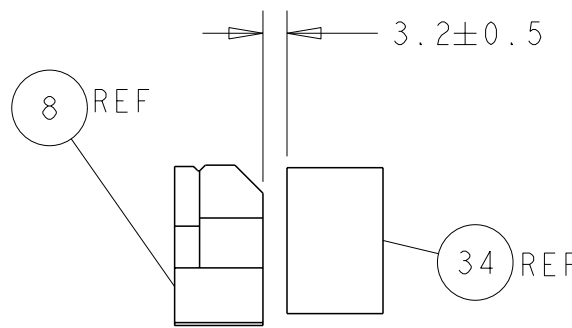
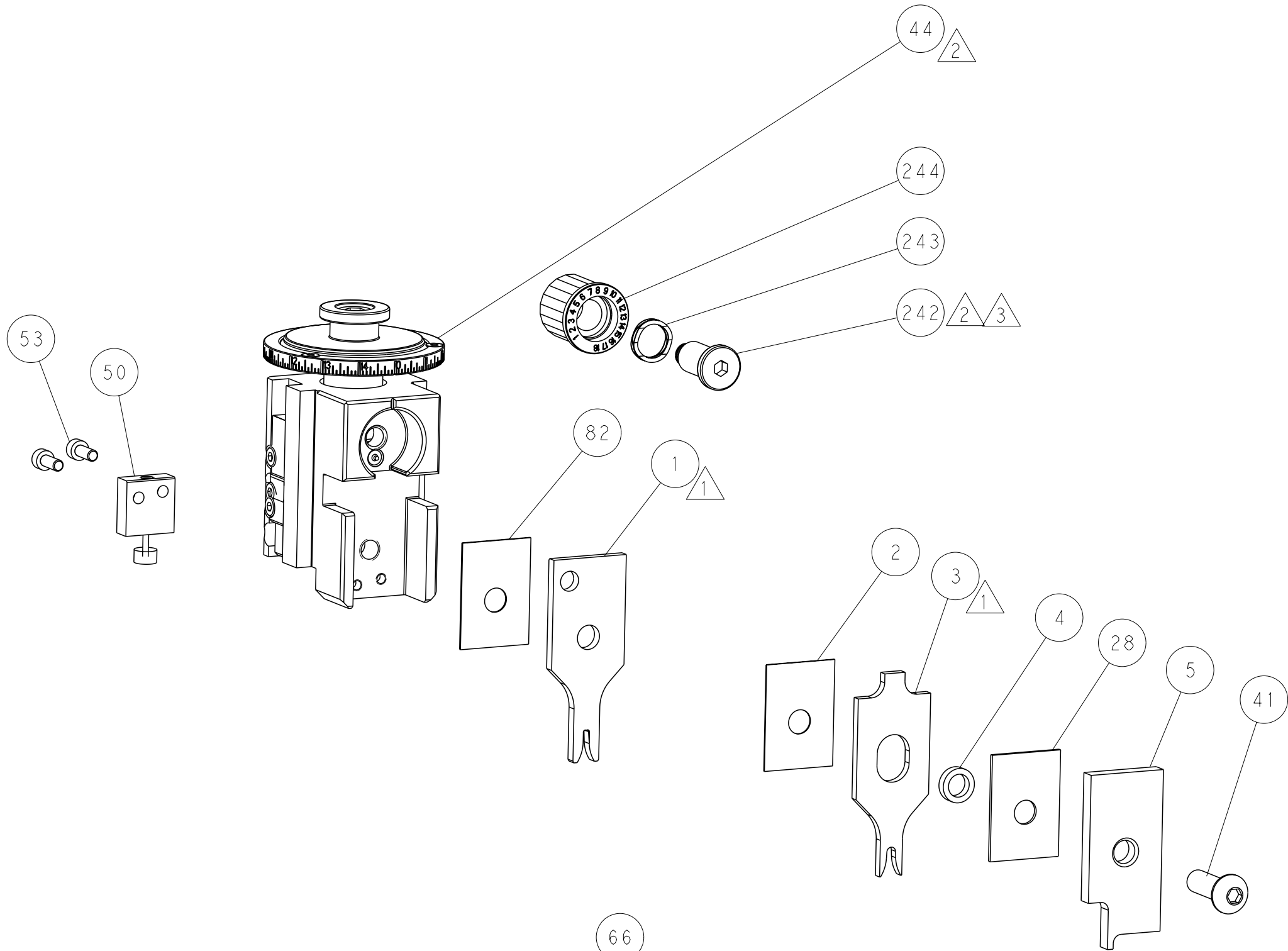
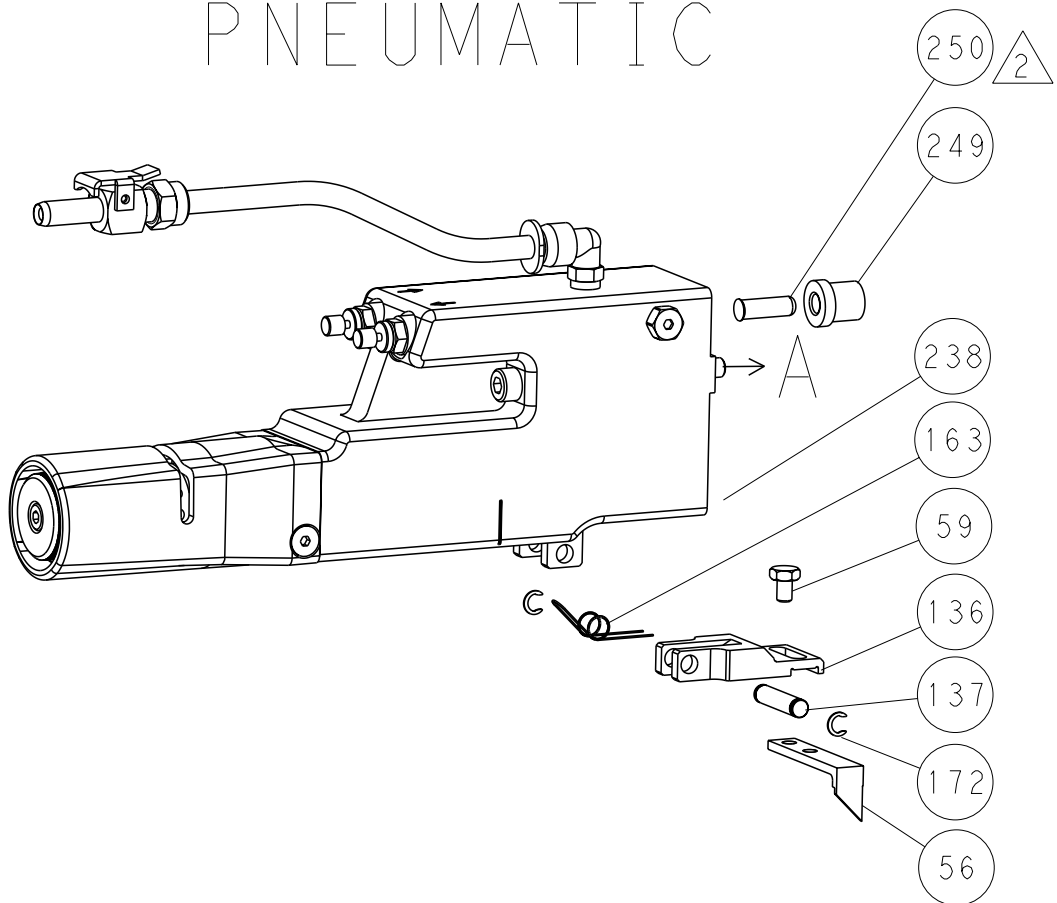
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

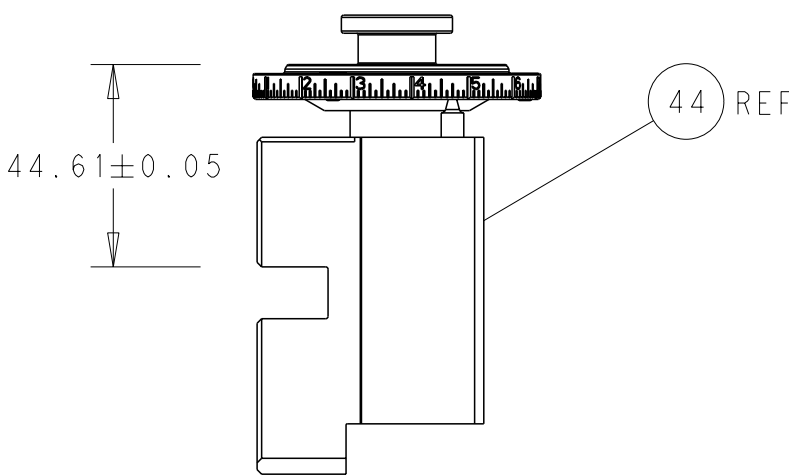
FEED TYPE
MECHANICAL



PNEUMATIC

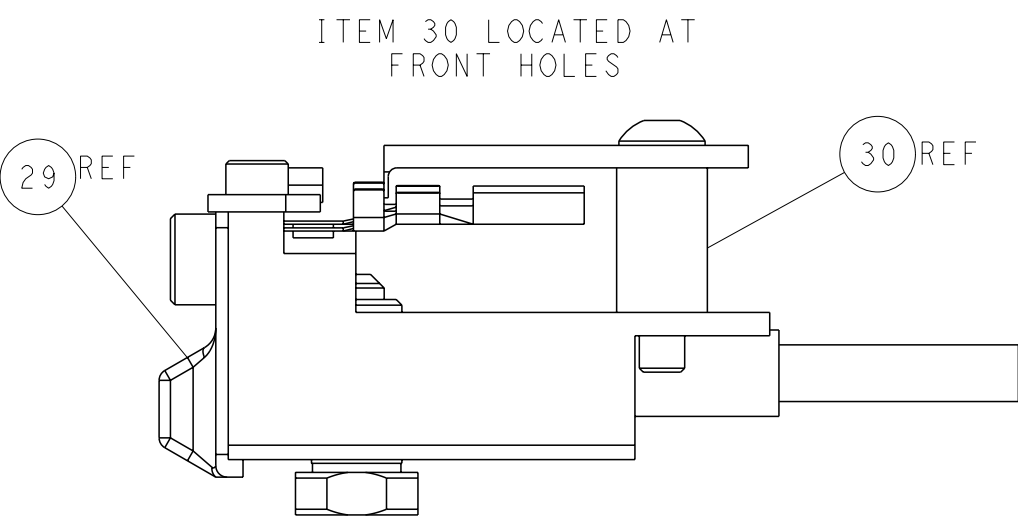
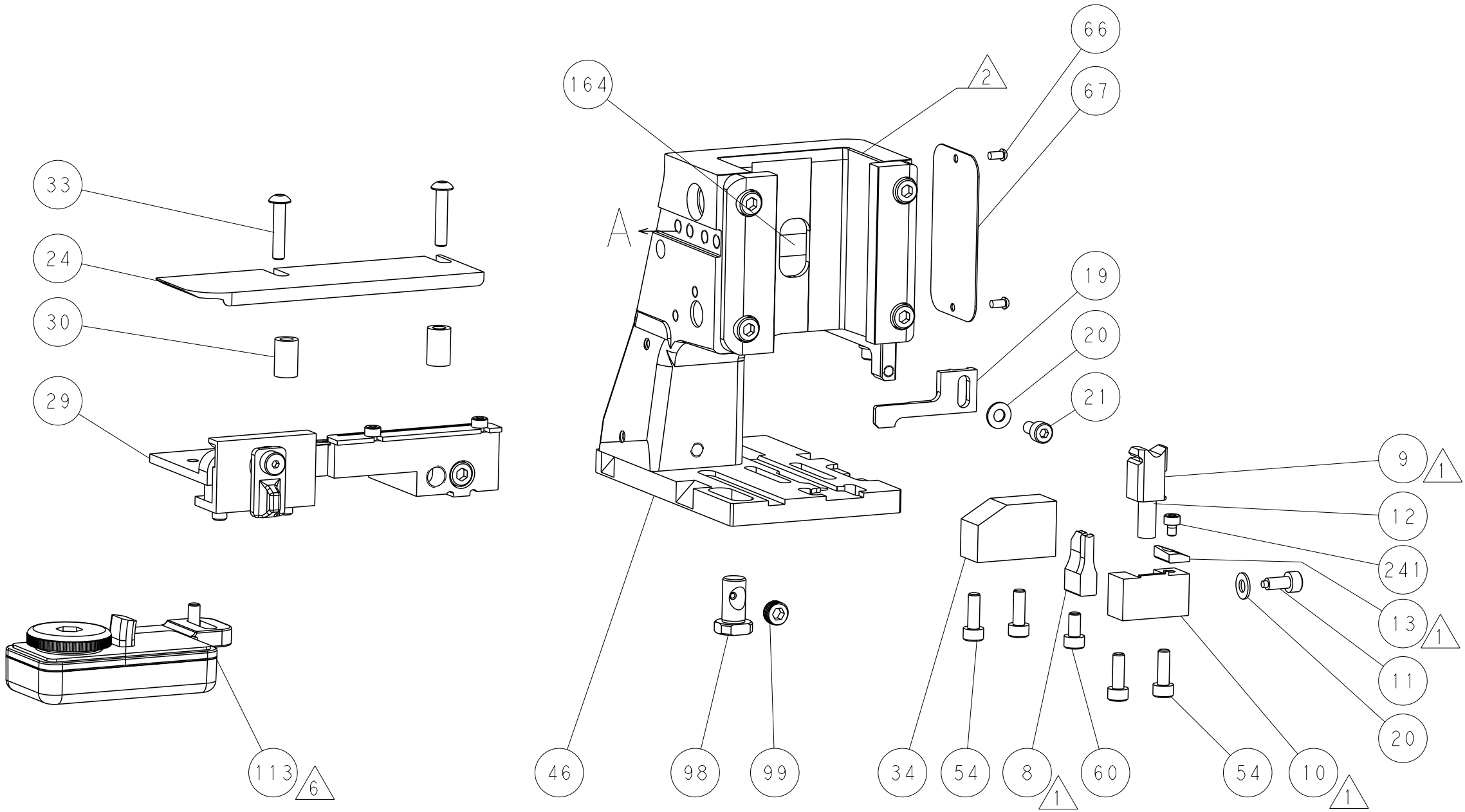
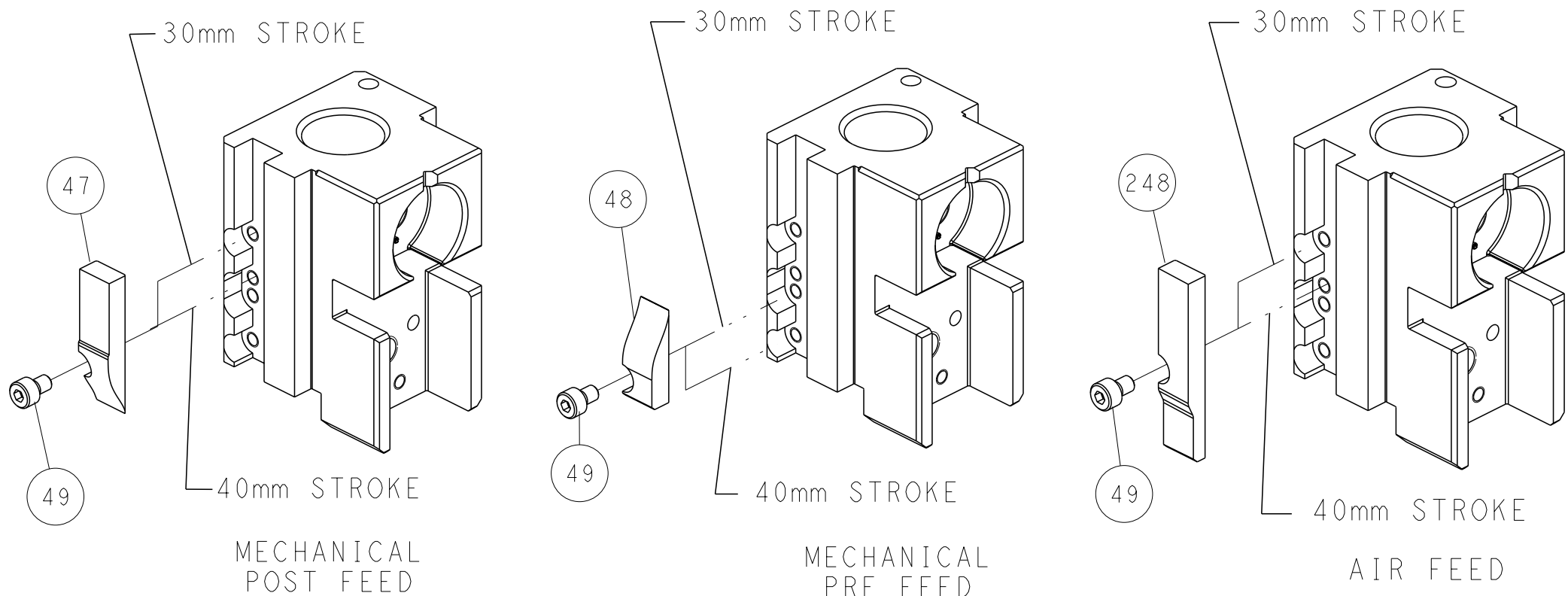


TERMINAL SUPPORT LOCATION



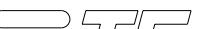
RAM SET-UP

CAM POSITIONS



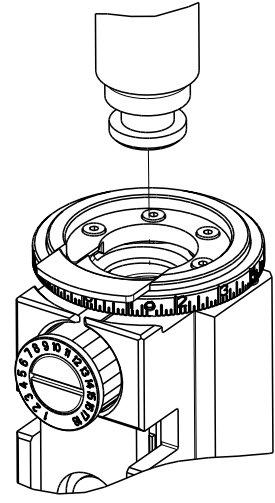
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

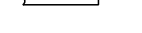
TE CONNECTIVITY IS COMMITTED TO EXCELLENCE IN DESIGN, MANUFACTURING, AND SERVICE. WE ARE PLEASED TO PROVIDE THIS INFORMATION TO YOU. IF YOU HAVE ANY COMMENTS, PLEASE CONTACT US AT 1-800-368-1344.				DWN		06JUN2012				TE Connectivity													
				CHK		C. CHEN				Harrisburg, PA 17105-3608													
				S. XI		06JUN2012																	
				I. CRUZ		06JUN2012																	
DIMENSIONS: mm  0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				NAME		Ocean Side Feed Applicator																	
				PRODUCT SPEC																			
				APPLICATION SPEC																			
				SIZE		CASE CODE		DRAWING NO		RESTRICTED TO													
MATERIAL				WEIGHT		A 00779		C=2151449		-													
Customer Accessible Production Drawing												SCALE		1:2		SHEET		2 of 4		REV		C	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151449-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151449-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151449-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	3.40 mm [.134]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: FEMALE RECEPTACLE TERMINAL			
WIRE STRIP LENGTH 4.20-5.00 mm [.165-.197 IN]		 INSULATION DIAMETER RANGE Ø2.36-2.74 mm [.093-.108 IN]	
TERMINAL APPLICATION SPECIFICATION MOLEX 63900-8400-C		- -	
TERMINALS APPLIED 			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949997-1	19420-0002	1949997-2	19420-0004

WIRE SIZE		CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.20+/-0.05 [.047+/- .002]	6.3
20 AWG		1.15+/-0.05 [.045+/- .002]	7.0
22 AWG		1.10+/-0.05 [.043+/- .002]	7.1

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: FEMALE RECEPTACLE TERMINAL			
WIRE STRIP LENGTH 4.20-5.00 mm [.165-.197 IN]		INSULATION DIAMETER RANGE Ø 1.00 mm NOMINAL	
TERMINAL APPLICATION SPECIFICATION MOLEX 63900-8400-C		-	-
TERMINALS APPLIED 		-	-
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949997-1	19420-0002	1949997-2	19420-0004

WIRE SIZE		CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG		1.05+/-0.05 [.041+/- .002]	7.6



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

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

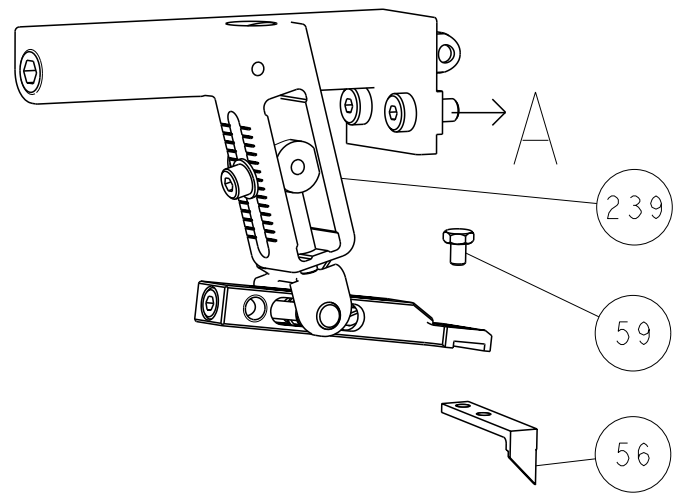
LOC	DIST	REVISONS			
A	66	P	LYR	DESCRIPTION	DATE
		-		SEE SHEET 1	-

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	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	1803607-1	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	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-1	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
-	1	1	1-1633620-4	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	3-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	4-1673600-5	CRIMPER, WIRE	1

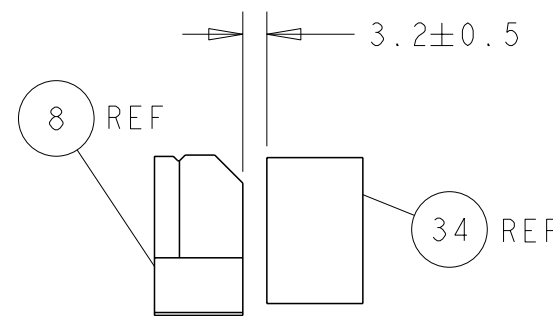
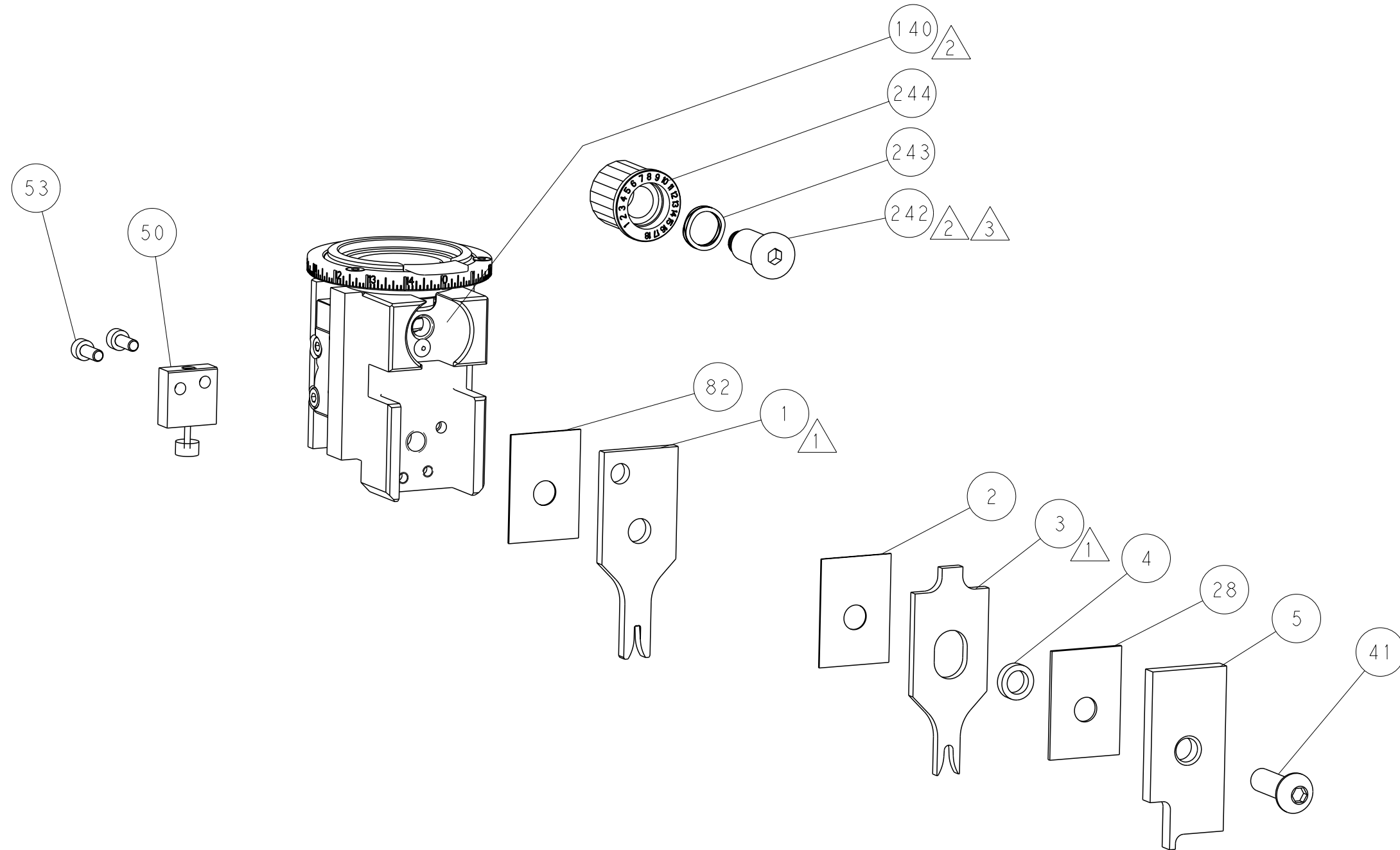
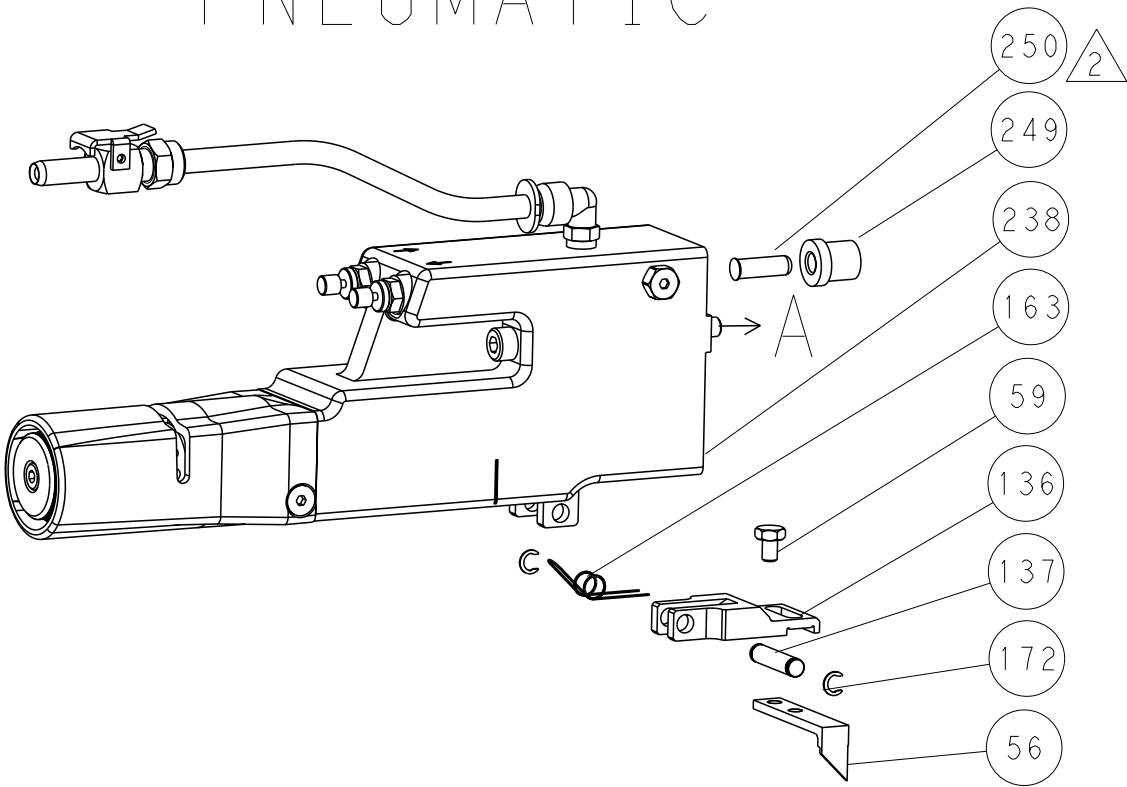
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
DIMENSIONS:			DWN C. CHEN CHK S. XI APVD J. CRUZ	TE Connectivity Harrisburg, PA 17105-3608	
TOLERANCES UNLESS OTHERWISE SPECIFIED:			PRODUCT SPEC	NAME Ocean Side Feed Applicator	
MATERIAL			APPLICATION SPEC	SIZE 00779	RESTRICTED TO
FINISH			WEIGHT	00779 ©=2151449	
Customer Accessible Production Drawing			SCALE 1:2	SHEET 3	REV C

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

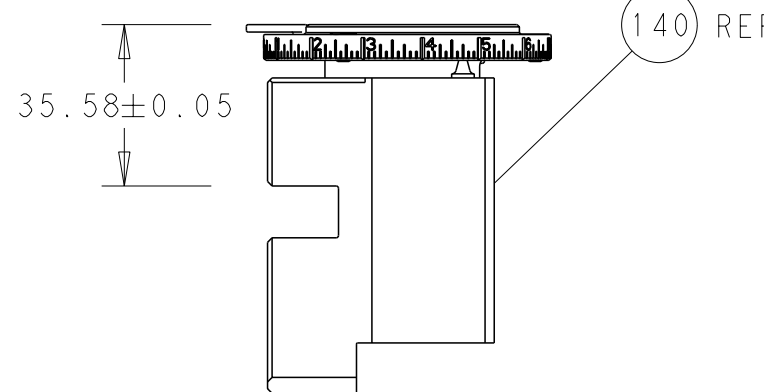
FEED TYPE MECHANICAL



PNEUMATIC

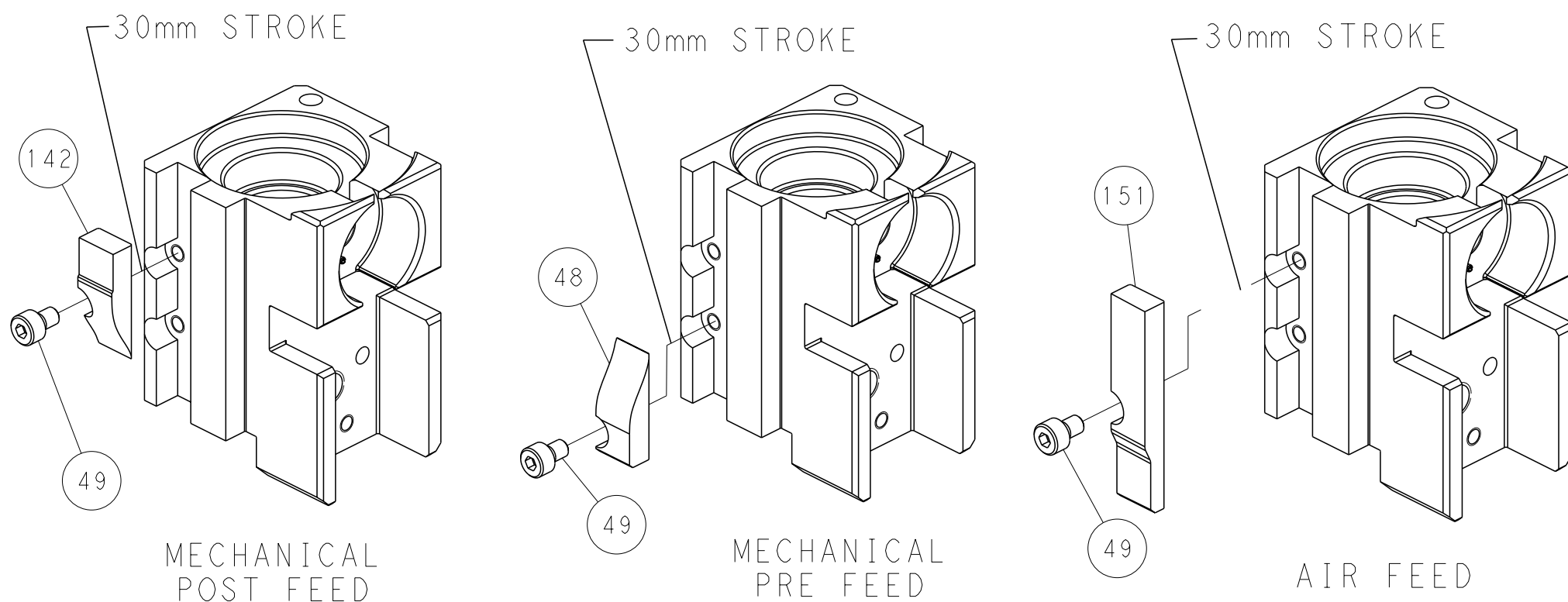


TERMINAL SUPPORT LOCATION



RAM SET-UP

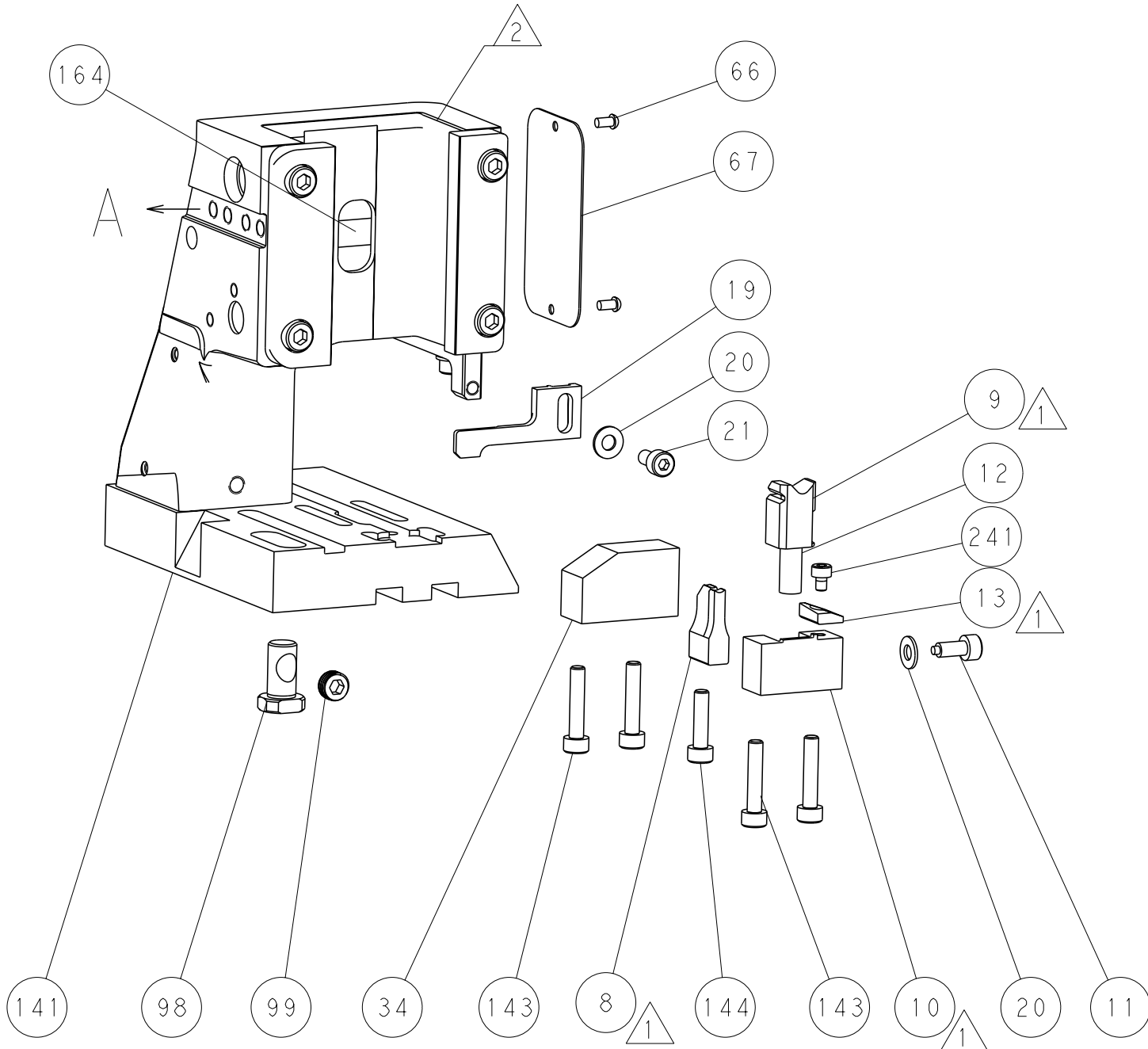
CAM POSITIONS



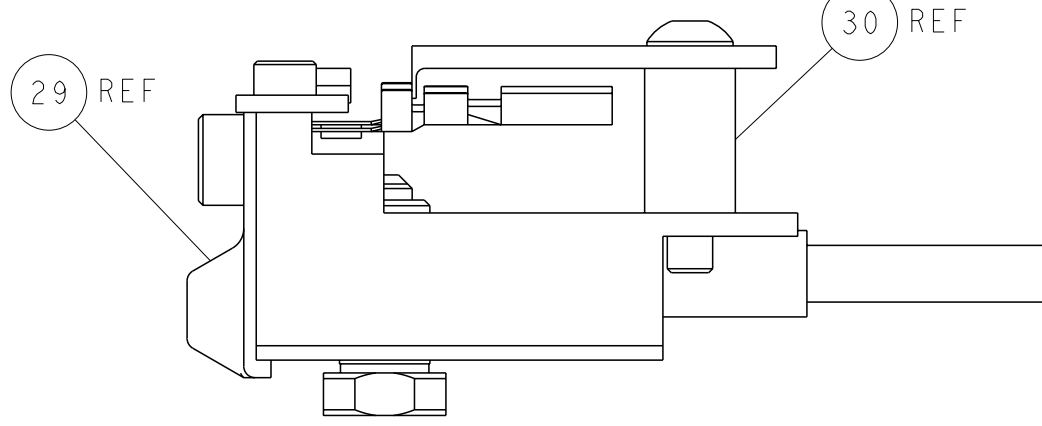
MECHANICAL
POST FEED

MECHANICAL
PRE FEED

AIR FEED



ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN C. CHEN 06JUN2012	REVISED TO: 06JUN2012		NAME Ocean Side Feed Applicator		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	PRODUCT SPEC APPLICATION SPEC		SIZE A1		
MATERIAL -		WEIGHT -		CAGE CODE 00779		DRAWING NO 2151449	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 4		REV C	