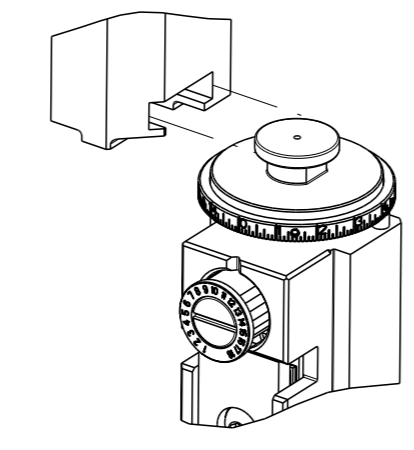


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151029-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151029-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151029-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	.278 [7.06 mm]	D
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: FULLY INSULATED FASTON

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
.296-.328 IN [7.52-8.33 mm]	∅ .320 [8.13mm] MAX

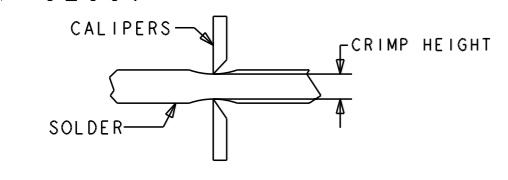
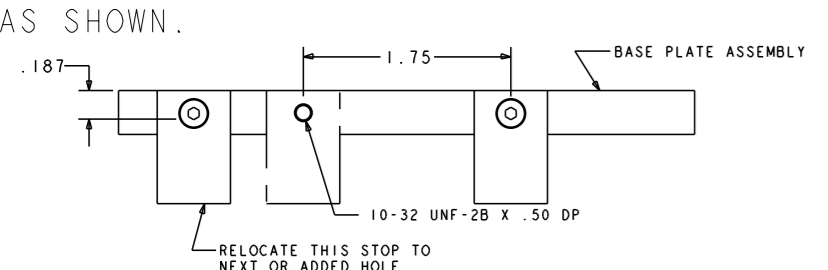
TERMINAL APPLICATION SPECIFICATION 114-2123

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
4-520447-2	9-520447-2	4-521097-2	

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
10	0.100+/-0.002 [2.54+/-0.05]	5.1	.25 IN [6.35mm]
12	0.095+/-0.002 [2.41+/-0.05]	6.3	.25 IN [6.35mm]



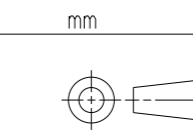
- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 4 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 5 ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- 6 ITEM 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- 7 FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- 8 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.25 IN [6.35mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
 
- 9 IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
 
- 10 ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- 11 ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- 12 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 13 CONSULT PRODUCT ENGINEERING BEFORE USING 10AWG WIRE
- 14 ITEMS NOT SHOWN.
- 15 ITEM 261 REQUIRED WHEN APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN AMP-O-LECTRIC TERMINATING UNIT.

***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.

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66	C	13APR2017	TB	GB	
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		E	14NOV2018	JAH	CT	
		F	03APR2019	JAH	CT	

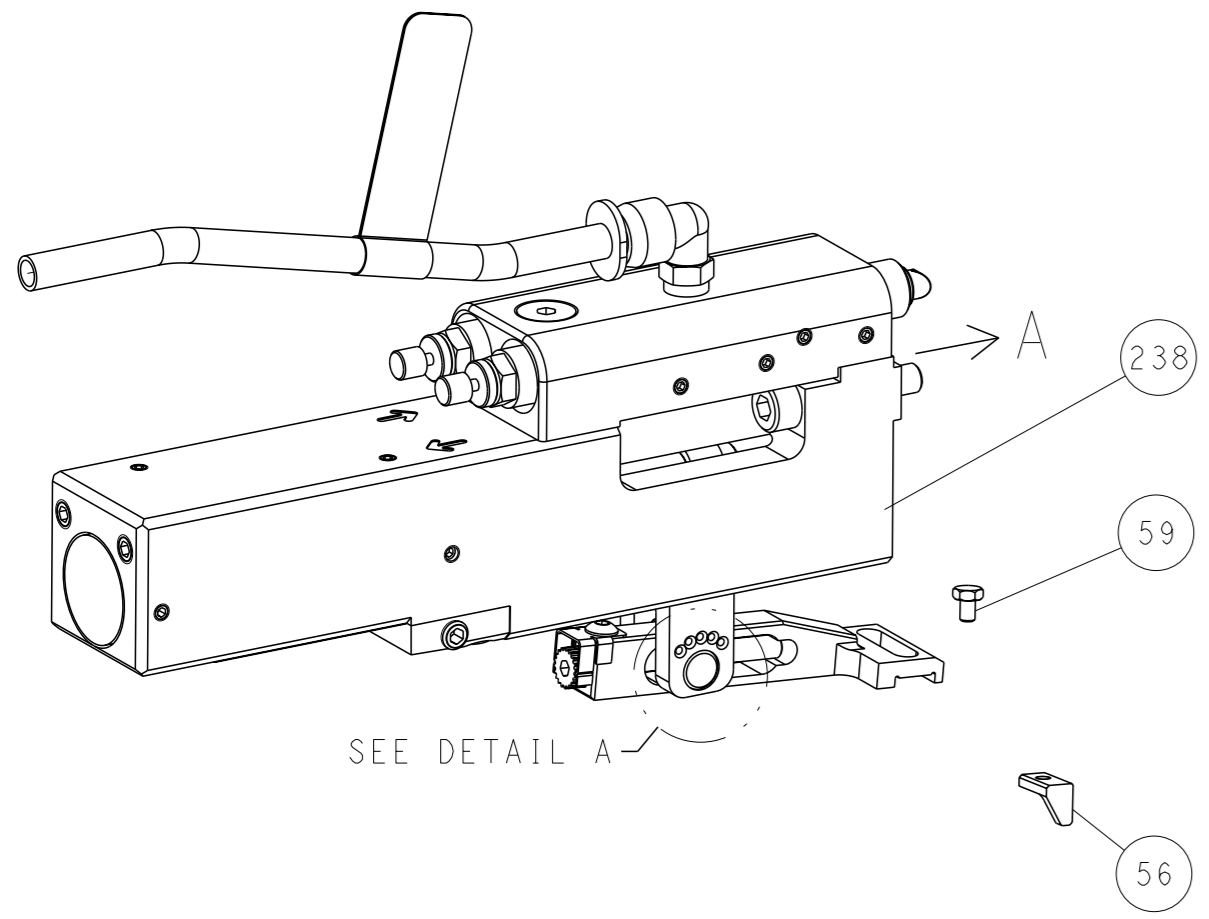
REV	DATE	BY	CHK	APPV	DESCRIPTION	ITEM NO	
-	1	1			1-18023-1 SCR, SHC, M4x10	262	
-	1	1			803931-1 BRACKET, HOLD DOWN	261	
-	REF	REF			462992-5 GUARD ASSY	257	
-	REF	REF			679532-1 INSERT, GUARD	256	
-	1	1			189728-1 BRACKET, SPACER	255	
-	1	1			568681-1 SPACER, BASE PLATE	253	
-	1	1			2119641-1 FEED CAM, AIR FEED	248	
-	1	1			7-18023-7 SCR, SKT HD CAP M3 X 4.0	241	
-	1	1			2844940-2 AIR FEED MODULE	238	
-	1	1			1-18028-0 WASHER, FLAT, REG M8	192	
-	REF	REF			994970-2 COUNTER, MAGNETIC	164	
-	1	1			1-22281-8 SPRING, COMPRESSION	121	
-	1	1			2844908-1 SCREW, LOCKING	99	
-	1	1			2844907-1 POST, LOCKING	98	
-	1	1			1-690438-0 FRONT STRIP GUIDE	96	
-	6	6			2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1			2168083-6 SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1			455888-4 SPACER, CRIMPER	82	
-	1	1			240641-6 SPACER	81	
-	1	1			1803607-3 DOCUMENTATION PACKAGE	71	
-	1	1			2161332-2 DEPRESSOR, WIRE FUNNEL	70	
-	1	1			2161331-1 SPACER, WIRE FUNNEL DEPRESSOR	69	
-	2	2			1-18028-4 WASHER, FLAT, REG M3	68	
-	1	1			2119740-1 TAG, IDENTIFICATION	67	
-	2	2			2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2			2-18032-5 SCR, SET, FLT PNT, M5 X 20.0	61	
-	1	1			2079383-4 SCR, BHSC, RoHS (M4 X 8)	60	
-	1	1			5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1			462427-2 FINGER, FEED	56	
-	4	4			2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12	54	
-	2	2			2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	53	
-	1	1			18023-9 SCR, SKT HD CAP M4 X 6.0	49	
-	1	1			1-1803583-9 APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1			1803515-1 RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1			462433-8 SUPPORT, INSULATION	42	
-	1	1			1803602-1 SCR, BHSC, RoHS (M8 X 25)	41	
-	2	2			5-22278-1 SPRING, COMPRESSION	33	
-	2	2			1-2168083-4 SCR, SKT HD CAP, RoHS, M4 X 5	30	
-	1	1			2161336-2 PLATE, REAR STRIP GUIDE	29	
-	2	2			22281-9 SPRING, COMPRESSION	27	
-	1	1			356835-1 LEVER, DRAG RELEASE	26	
-	1	1			240792-1 DRAG, TERMINAL	25	
-	1	1			684042-5 GUIDE, STRIP, FRONT	24	
-	1	1			980371-4 SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	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			463460-3 HOLD DOWN, TERMINAL	18	
-	1	1			469542-3 REAR FLOATING SHEAR	17	
-	2	2			1-2168083-1 SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1			2161335-2 SHEAR PLATE, REAR	15	
-	1	1			2119862-2 SHEAR HOLDER, REAR	14	
-	1	1			2280441-1 INSERT, SHEAR	13	
-	1	1			3-22280-3 SPRING, COMPRESSION	12	
-	1	1			356885-4 STOP, SHEAR	11	
-	1	1			462843-7 TERMINAL SUPPORT	9	
-	1	2			464291-5 ANVIL, SAND-BLASTED 22-18	8	
-	1	1			803925-2 GUIDE, CARRIER SCRAP	7	
-	1	1			690468-6 DEPRESSOR SHEAR, REAR	6	
-	1	1			462431-5 WIRE FUNNEL	5	
-	1	1			238011-1 BLOCK, CRIMPER SPACER	4	
-	1	2			464290-3 CRIMPER, SEMI-FLAT 22-18	1	
-77-72-2					PART NO	DESCRIPTION	ITEM NO

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: B. WEAVER 12JUN2012 CHK: G. HOFENER 12JUN2012 APPV: T. ELBIN 12JUN2012		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151029 RESTRICTED TO: -	
MATERIAL: -		WEIGHT: -		SCALE: 1:1		SHEET 1 OF 4	

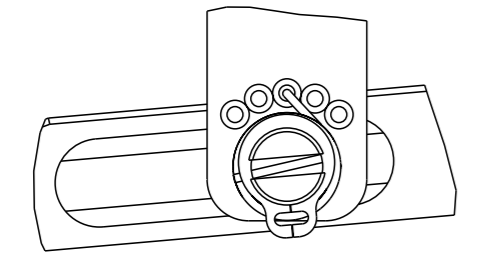
LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC



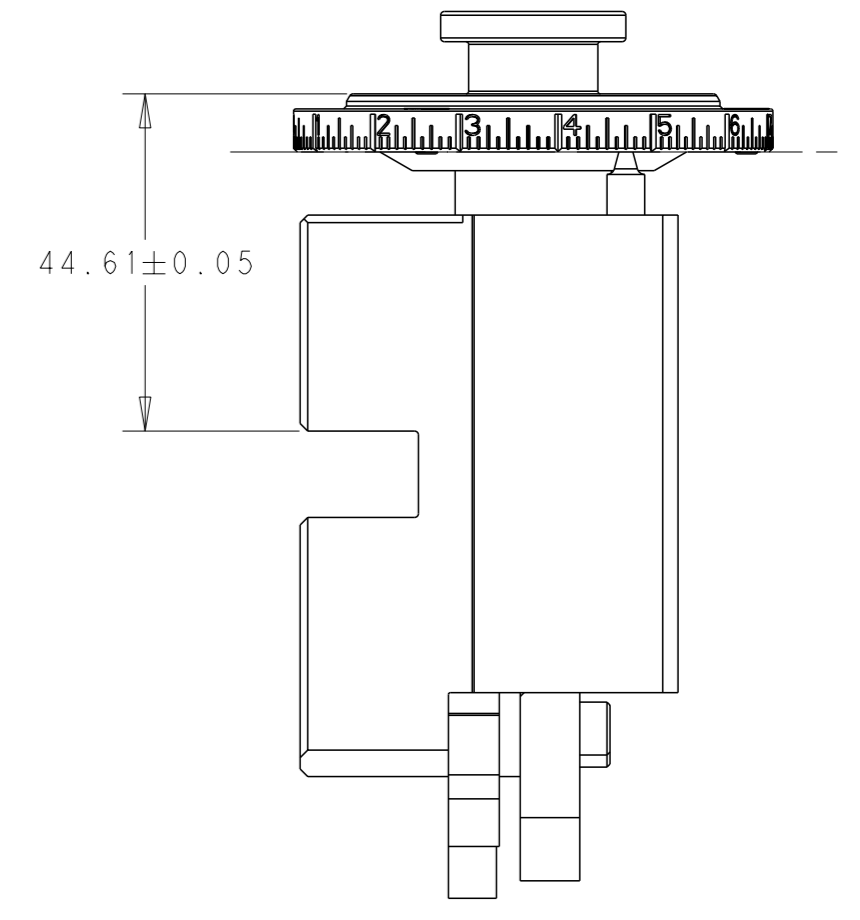
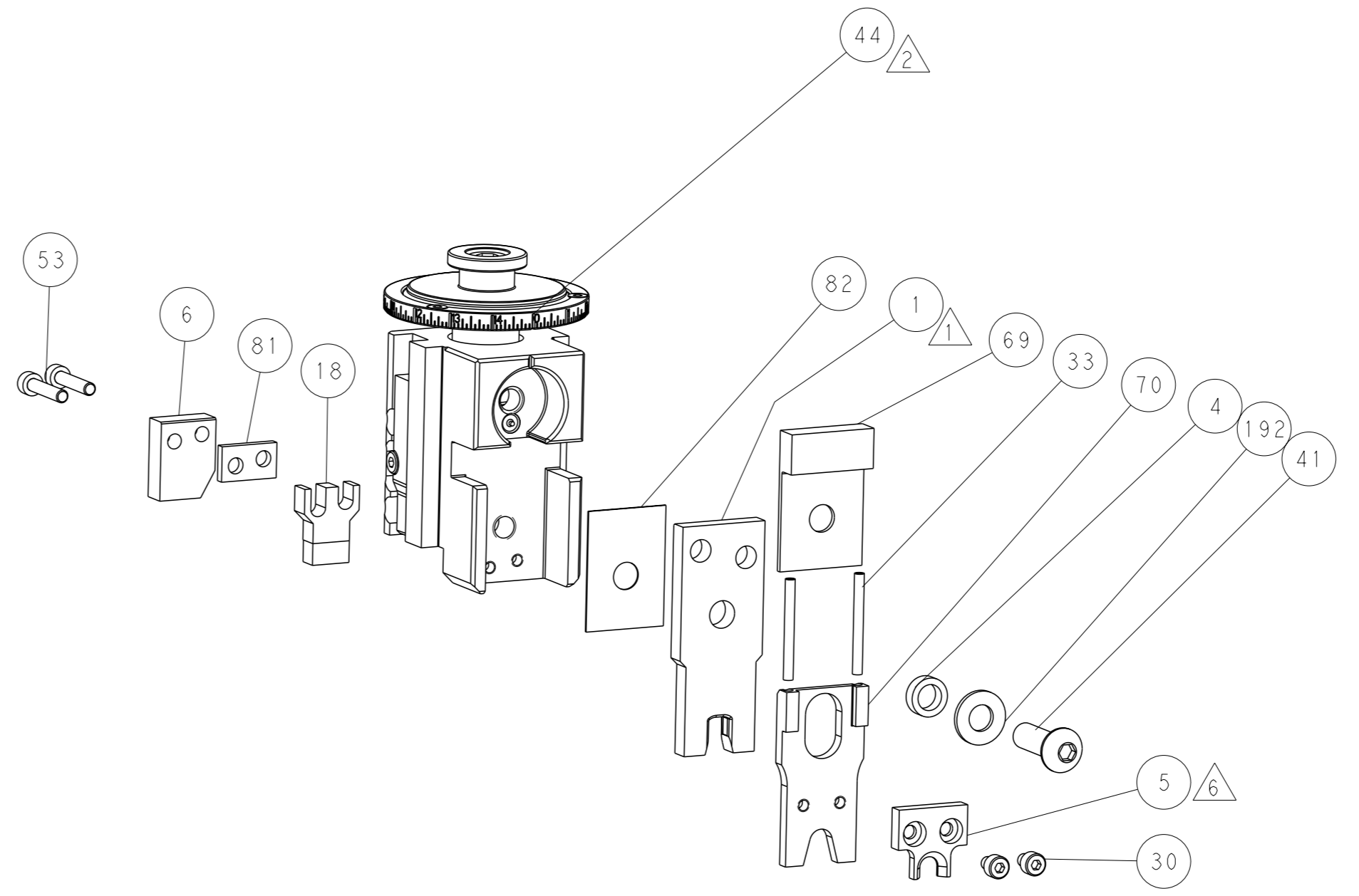
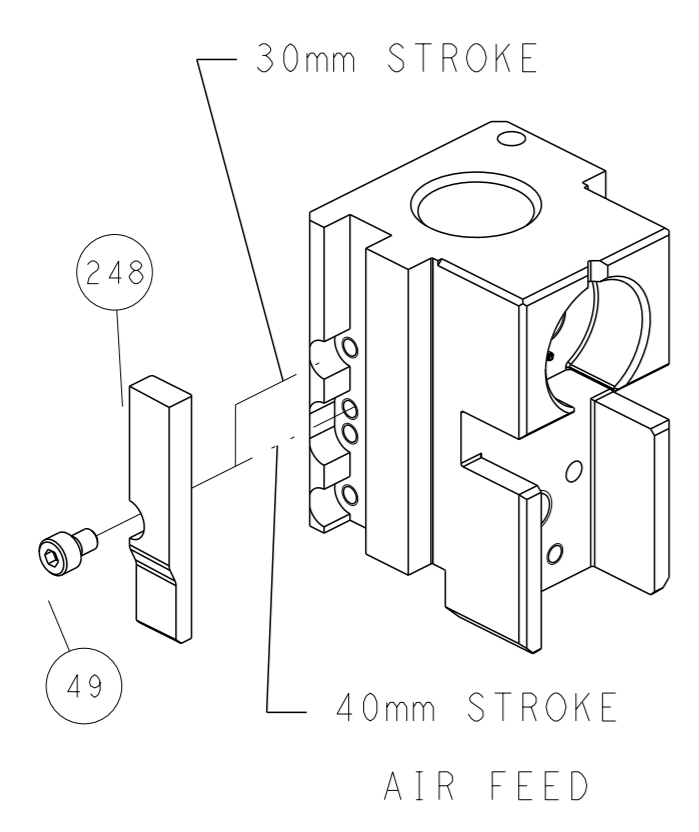
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

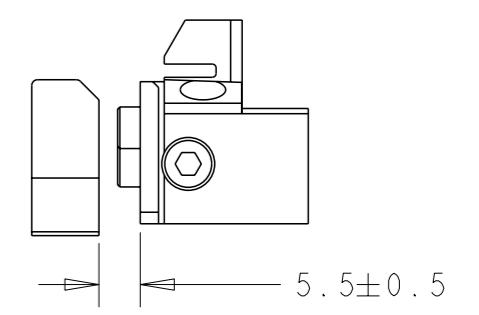


DETAIL A

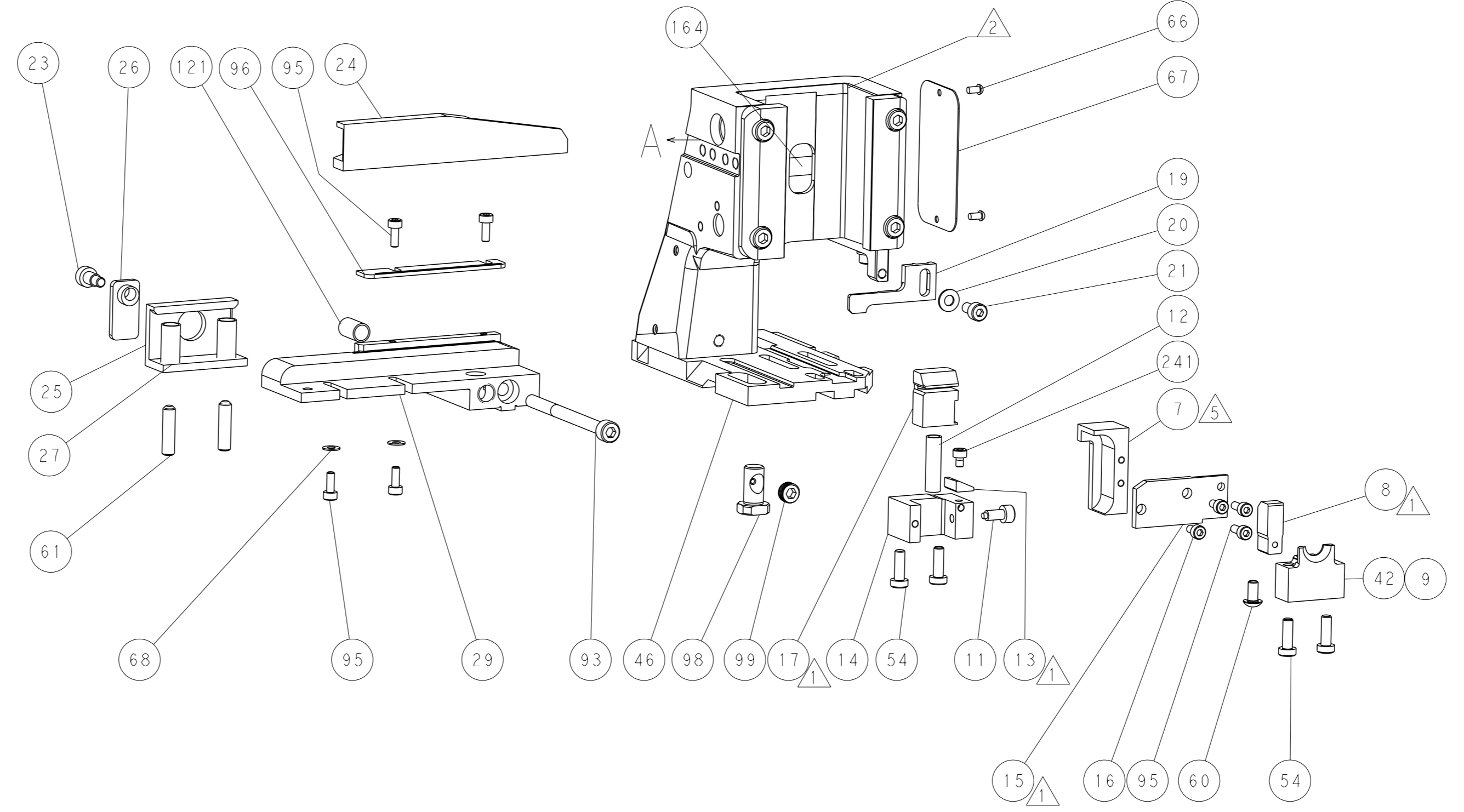
CAM POSITION



RAM SET-UP



LOWER TOOLING SET-UP

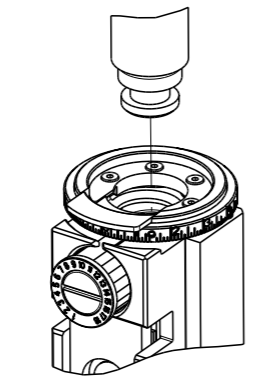


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND RESTRICTION DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN B. WEAVER 12JUN2012 CHK G. HOFNER 12JUN2012 APVD T. ELBIN 12JUN2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151029 RESTRICTED TO:
MATERIAL:		SCALE: 1:1 SHEET 2 OF 4 REV F	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151029-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151029-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.278 [7.06 mm]	D
INSUL	-	-

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.296-.328 IN [7.52-8.33 mm]		∅ .320 [8.13mm] MAX	
TERMINAL APPLICATION SPECIFICATION	114-2123		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
4-520447-2	9-520447-2	4-521097-2	

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
10	0.100+/-0.002 [2.54+/-0.05]	5.1	.25 IN [6.35mm]
12 OR (4)18	0.095+/-0.002 [2.41+/-0.05]	6.3	.25 IN [6.35mm]

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- ITEM 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.25 IN [6.35mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
- IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
- ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- CONSULT PRODUCT ENGINEERING BEFORE USING 10AWG WIRE
- ITEMS NOT SHOWN.
- ITEM 261 REQUIRED WHEN APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN AMP-O-LECTRIC* TERMINATING UNIT.

***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.

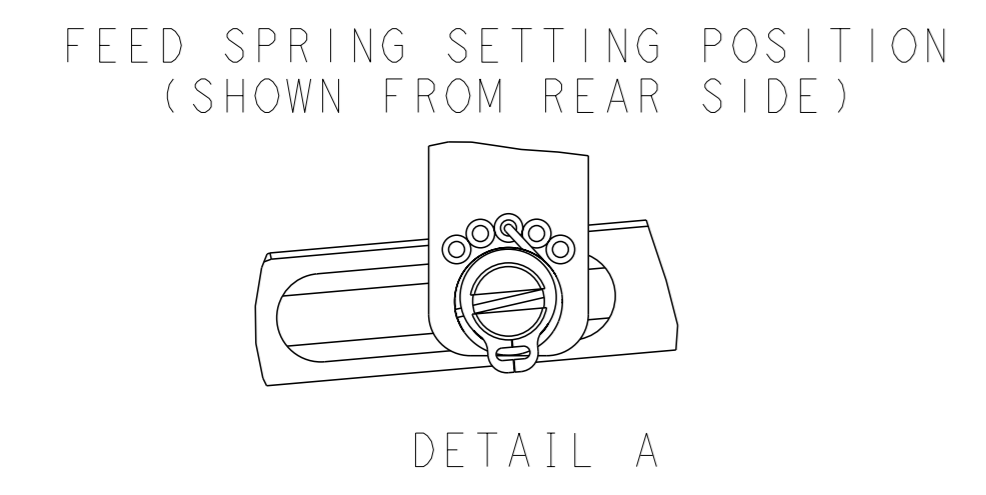
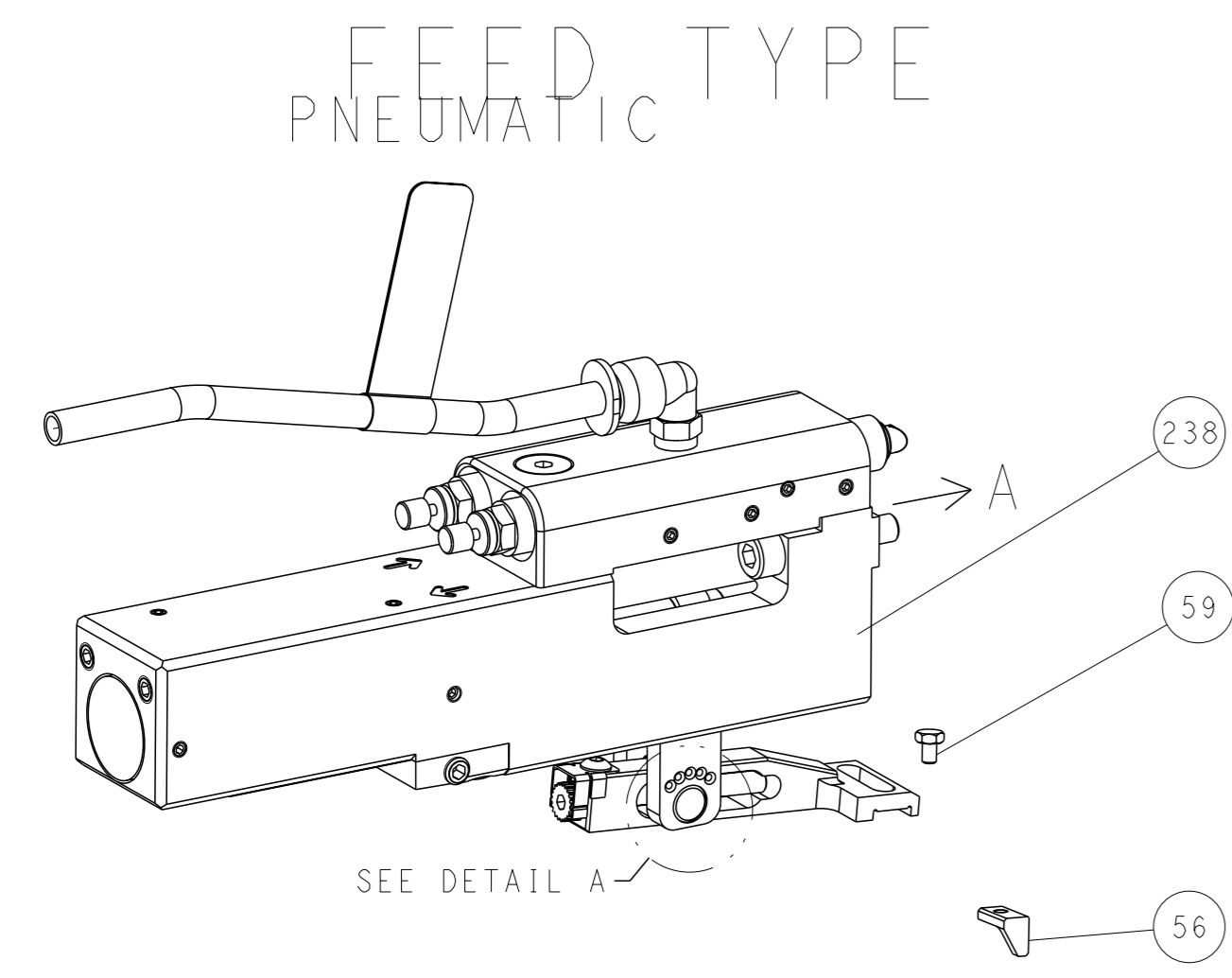
LOC	DIST	REV	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

	-	1	1-18023-1	SCR, SHC, M4x10			262
	-	1	803931-1	BRACKET, HOLD DOWN			261
	-	REF	462992-5	GUARD ASSY			257
	-	REF	679532-1	INSERT, GUARD			256
	-	1	189728-1	BRACKET, SPACER			255
	-	1	568681-1	SPACER, BASE PLATE			253
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0			241
	-	1	2844940-2	AIR FEED MODULE			238
	-	1	1-18028-0	WASHER, FLAT, REG M8			192
	-	REF	994970-2	COUNTER, MAGNETIC			164
	-	1	2119641-2	FEED CAM, AIR FEED			151
	-	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)			144
	-	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20			143
	-	1	2-1803583-0	APPLICATOR BASIC ASSEMBLY, SF			141
	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC			140
	-	1	1-22281-8	SPRING, COMPRESSION			121
	-	1	2844908-1	SCREW, LOCKING			99
	-	1	2844907-1	POST, LOCKING			98
	-	1	1-690438-0	FRONT STRIP GUIDE			96
	-	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0			95
	-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65			93
	-	1	455888-4	SPACER, CRIMPER			82
	-	1	240641-6	SPACER			81
	-	1	1803607-3	DOCUMENTATION PACKAGE			71
	-	1	2161332-2	DEPRESSOR, WIRE FUNNEL			70
	-	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR			69
	-	2	1-18028-4	WASHER, FLAT, REG M3			68
	-	1	2119740-1	TAG, IDENTIFICATION			67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188			66
	-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0			61
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0			59
	-	1	462427-2	FINGER, FEED			56
	-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20			53
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0			49
	-	1	462433-8	SUPPORT, INSULATION			42
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)			41
	-	2	5-22278-1	SPRING, COMPRESSION			33
	-	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5			30
	-	1	2161336-2	PLATE, REAR STRIP GUIDE			29
	-	2	22281-9	SPRING, COMPRESSION			27
	-	1	356835-1	LEVER, DRAG RELEASE			26
	-	1	240792-1	DRAG, TERMINAL			25
	-	1	684042-5	GUIDE, STRIP, FRONT			24
	-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0			23
	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			21
	-	1	1-18028-2	WASHER, FLAT, REG M4			20
	-	1	2119533-1	STRIPPER, SIDE FEED			19
	-	1	463460-3	HOLD DOWN, TERMINAL			18
	-	1	469542-3	REAR FLOATING SHEAR			17
	-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6			16
	-	1	2161335-2	SHEAR PLATE, REAR			15
	-	1	2119862-2	SHEAR HOLDER, REAR			14
	-	1	2280441-1	INSERT, SHEAR			13
	-	1	3-22280-3	SPRING, COMPRESSION			12
	-	1	356885-4	STOP, SHEAR			11
	-	1	462843-7	TERMINAL SUPPORT			9
	-	1	464291-5	ANVIL, SAND-BLASTED 22-18			8
	-	1	803925-2	GUIDE, CARRIER SCRAP			7
	-	1	690468-6	DEPRESSOR SHEAR, REAR			6
	-	1	462431-5	WIRE FUNNEL			5
	-	1	238011-1	BLOCK, CRIMPER SPACER			4
	-	1	464290-3	CRIMPER, SEMI-FLAT 22-18			1

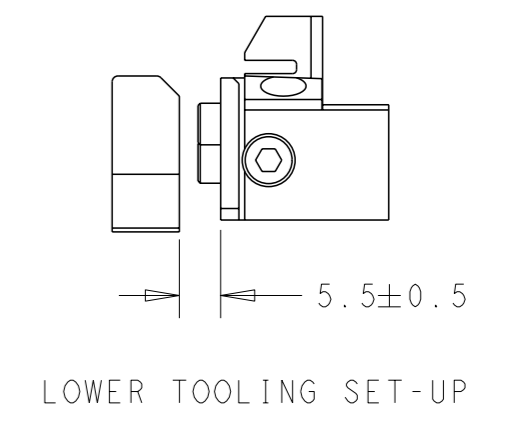
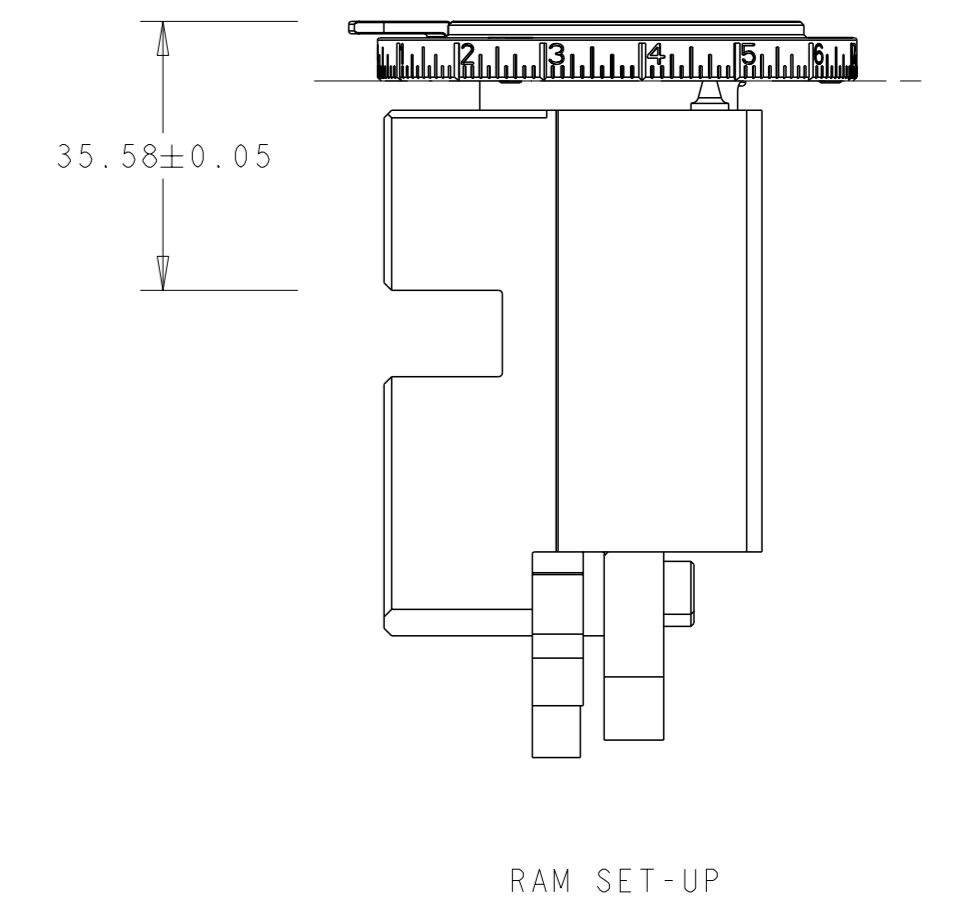
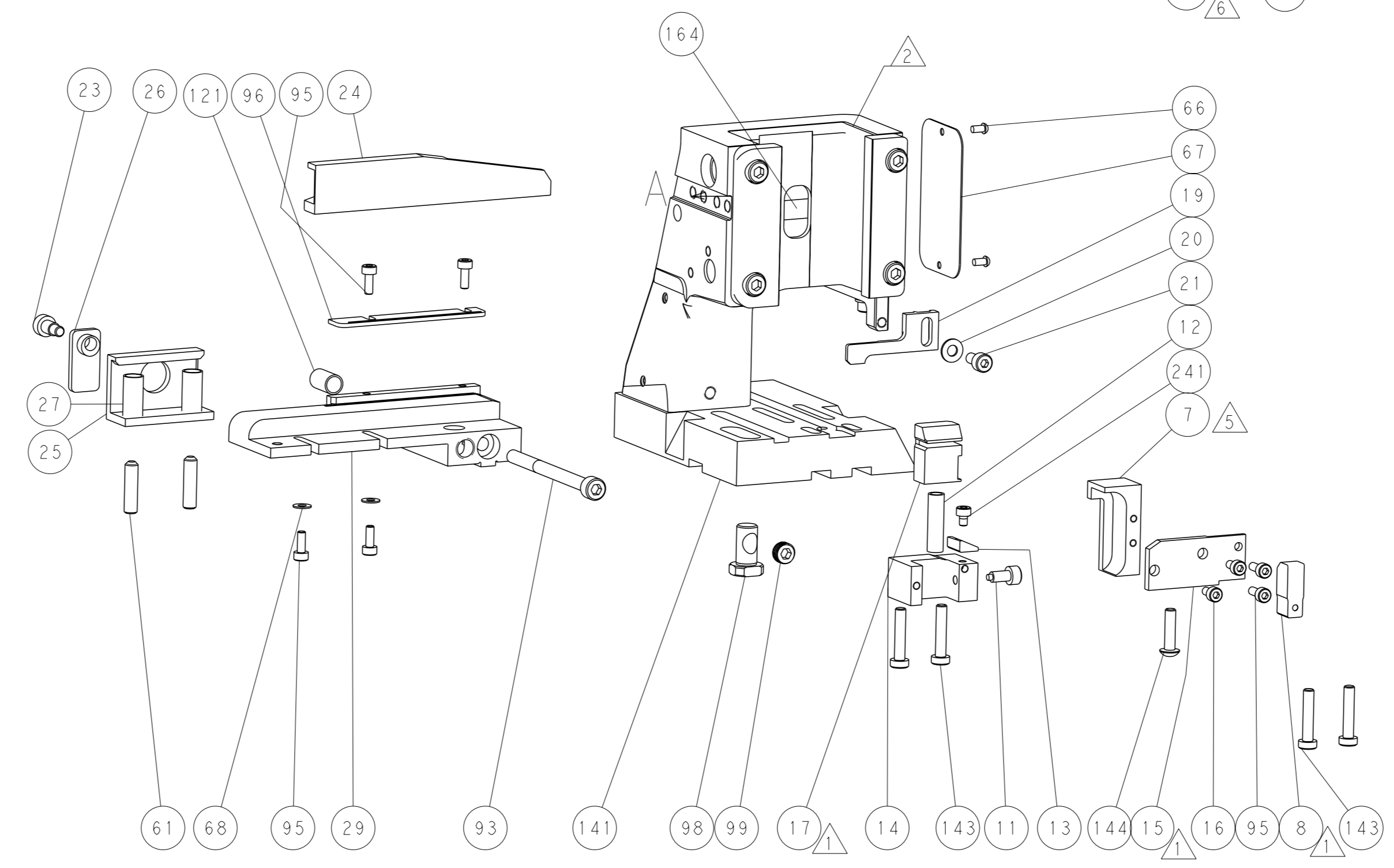
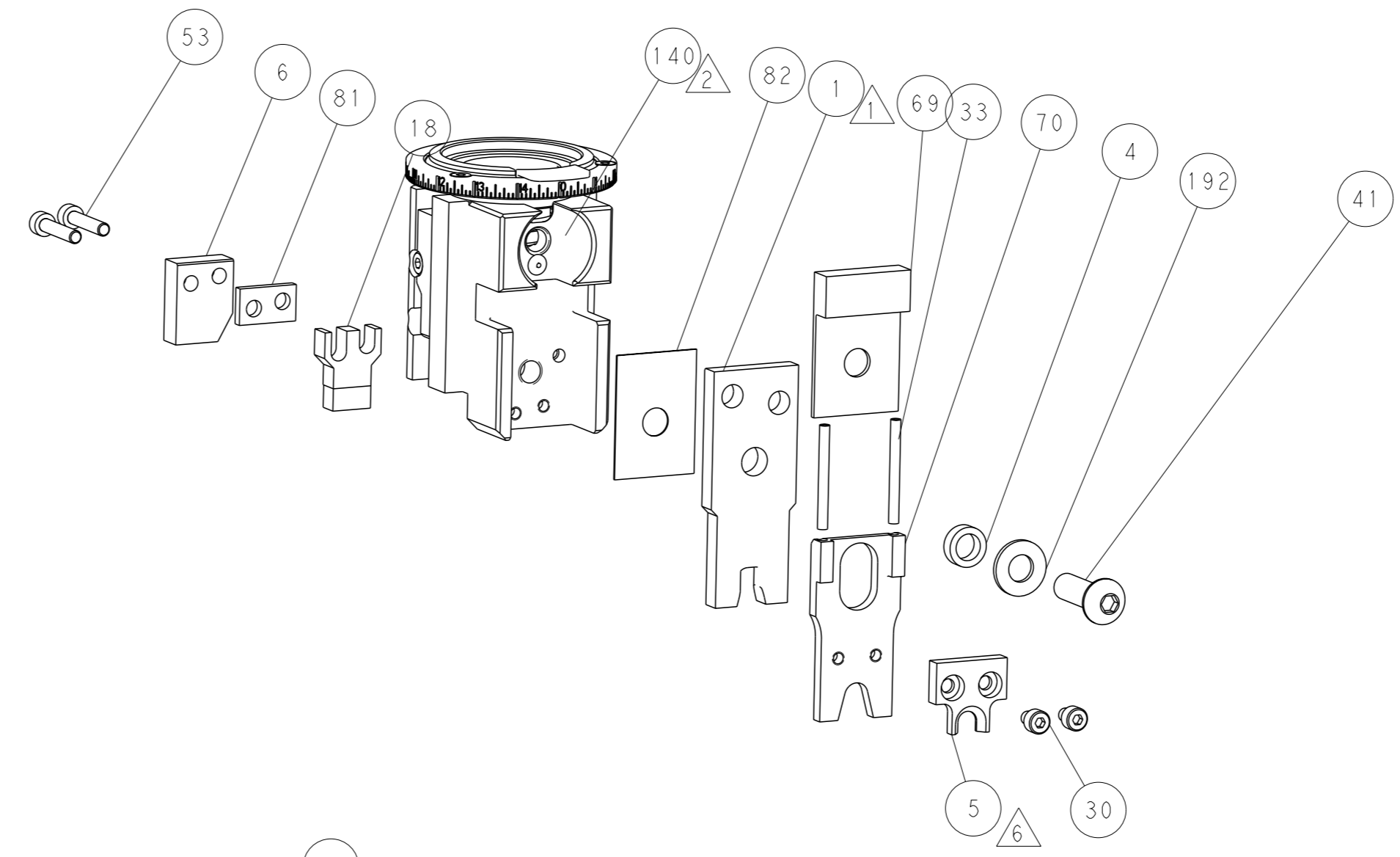
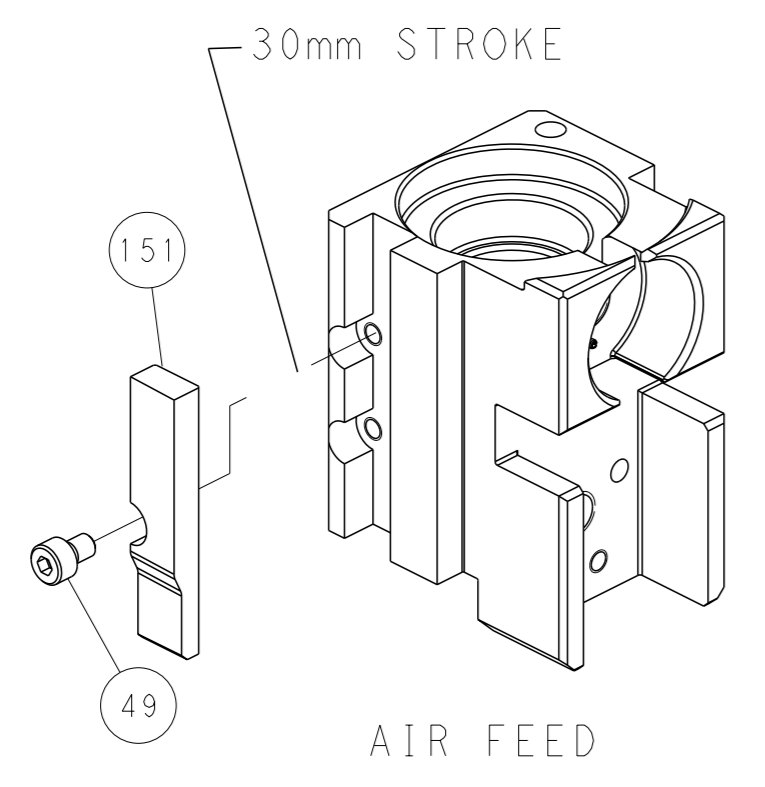
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	TE Connectivity
	ANGLES	FINISH		WEIGHT		SCALE	Harrisburg, PA 17105-3608
MATERIAL						SIZE	Ocean Side Feed
						CAGE CODE	Applicator
						DRAWING NO	
						RESTRICTED TO	
						Customer Accessible Production Drawing	
						SCALE	1:1
						SHEET	3 of 4
						REV	F

LOC		DIST		REVISIONS			
A		66		REV	DATE	OWN	APVD
-				1	SEE SHEET 1	-	-



CAM POSITION



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN B. WEAVER 12JUN2012 CHK G. HOFNER 12JUN2012 APVD T. ELBIN 12JUN2012	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 WEIGHT SCALE 1:1	SIZE CAGE CODE DRAWING NO. RESTRICTED TO A 00779 C=2151029 Customer Accessible Production Drawing SHEET 4 OF 4 REV F