

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151541-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151541-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151541-2	J	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS ⁹
7-2151541-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151541-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151541-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.05-3.35 mm [.120-.132 IN]		Ø1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18021		
	(B)114-61024		
TERMINALS APPLIED			
GROUP 1 ⁷		GROUP 2 ⁸	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 5-928999-5	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 5-928999-6	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 6-928999-5	(A) 1394702-2	(B) 2005119-1	(A) 1241918-1
(A) 928918-1	(A) 5-1394702-1		
(A) 928918-2	(A) 5-1394702-2		
(A) 1-928918-1	(A) 968893-1		
(A) 1-928918-2	(A) 5-968893-1		

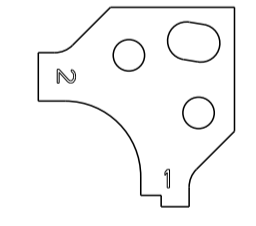
TERMINAL DATA: TE TERMINAL		TE SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
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TERMINAL APPLICATION SPECIFICATION	(A)114-18021		
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TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
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(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
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(A) 5-928999-6	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 6-928999-5	(A) 1394702-2	(A) 1241918-1	
(A) 928918-1	(A) 5-1394702-1		
(A) 928918-2	(A) 5-1394702-2		
(A) 1-928918-1	(A) 968893-1		
(A) 1-928918-2	(A) 5-968893-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm ²	0.82 +/- 0.03 [.032 +/- .001]	9.3
0.25mm ²	0.76 +/- 0.03 [.030 +/- .001]	10.0
0.20mm ²	0.72 +/- 0.03 [.028 +/- .001]	10.4

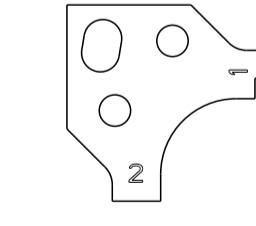
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	0.92 +/- 0.03 [.036 +/- .001]	8.3

- 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 REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm² WIRE.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

⁷ POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS. REFER TO SHEET 2.



⁸ POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS. REFER TO SHEET 2.



⁹ THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.

***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.

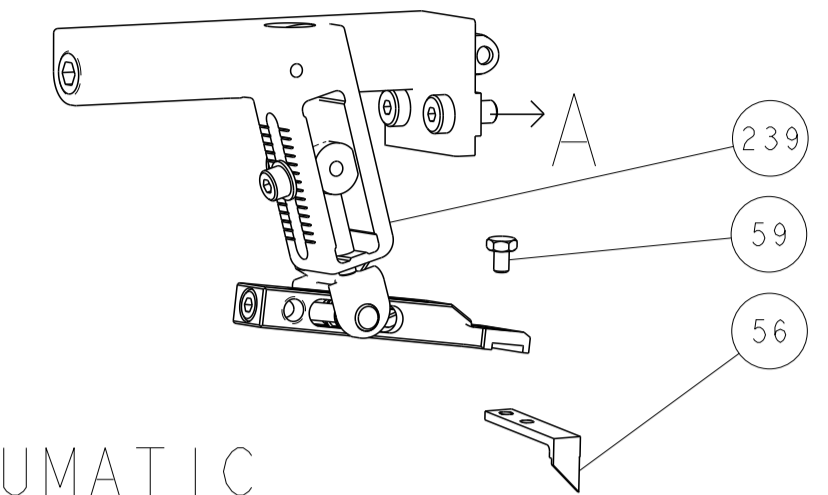
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		G		ECR-19-012198	02AUG2019	FZ	RK
		G1		ECR-20-011856	21AUG2020	FZ	RK
		H		ECR-21-005128	05MAY2021	TB	RK
		J		ECR-21-006572	28JUN2021	JWC	TE

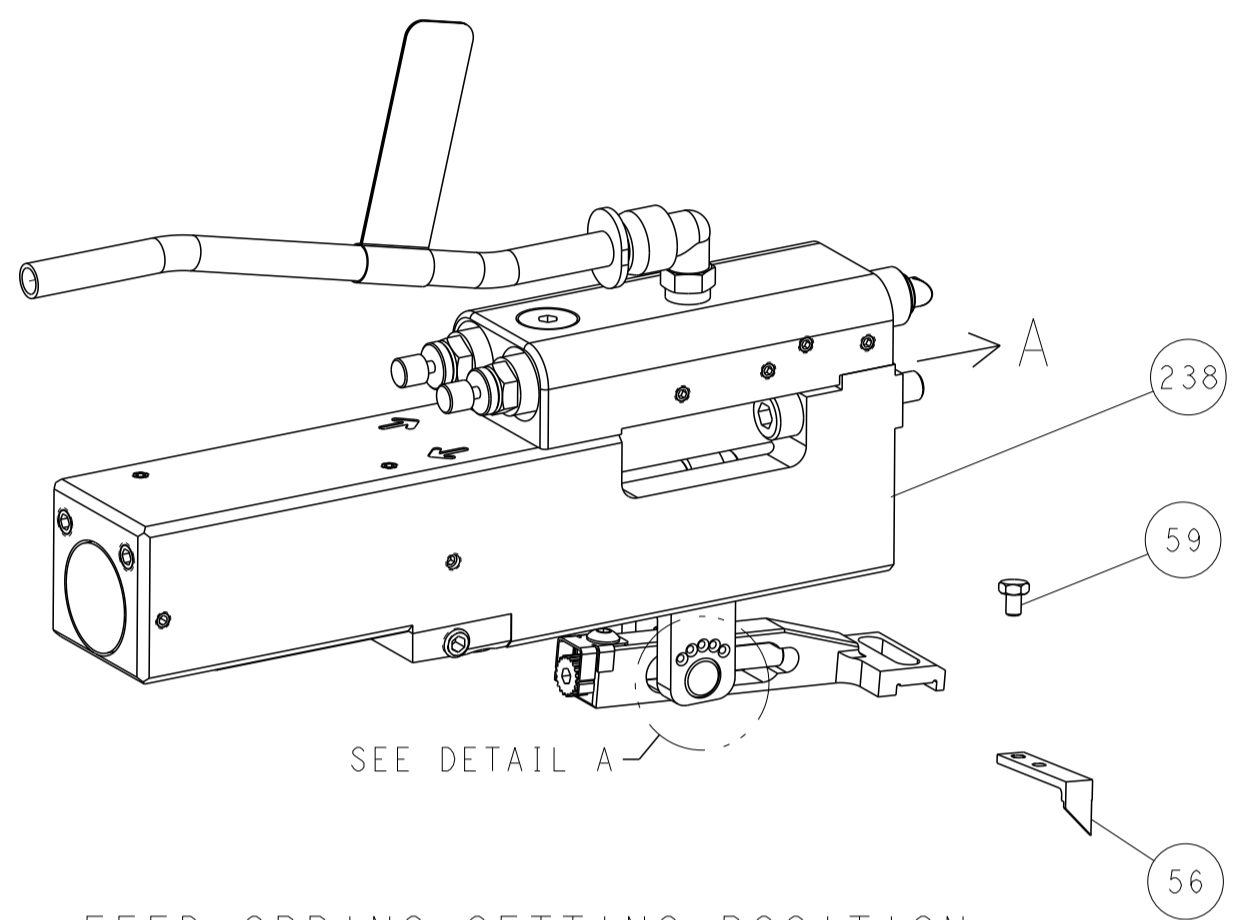
-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1-240641-3	SPACER	81
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1	1	1633782-2	FENCE	78
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	2119740-1	TAG IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	1	2	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2217529-1	TERMINAL HOLD DOWN	18
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1333233-1	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	1	1	4-240641-2	SPACER	7
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	1	5-568176-3	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		CUSTOMER DRAWING:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH				

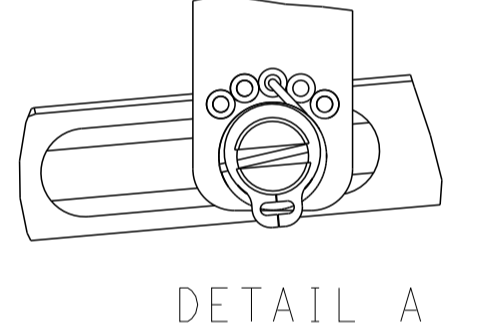
FEED TYPE MECHANICAL



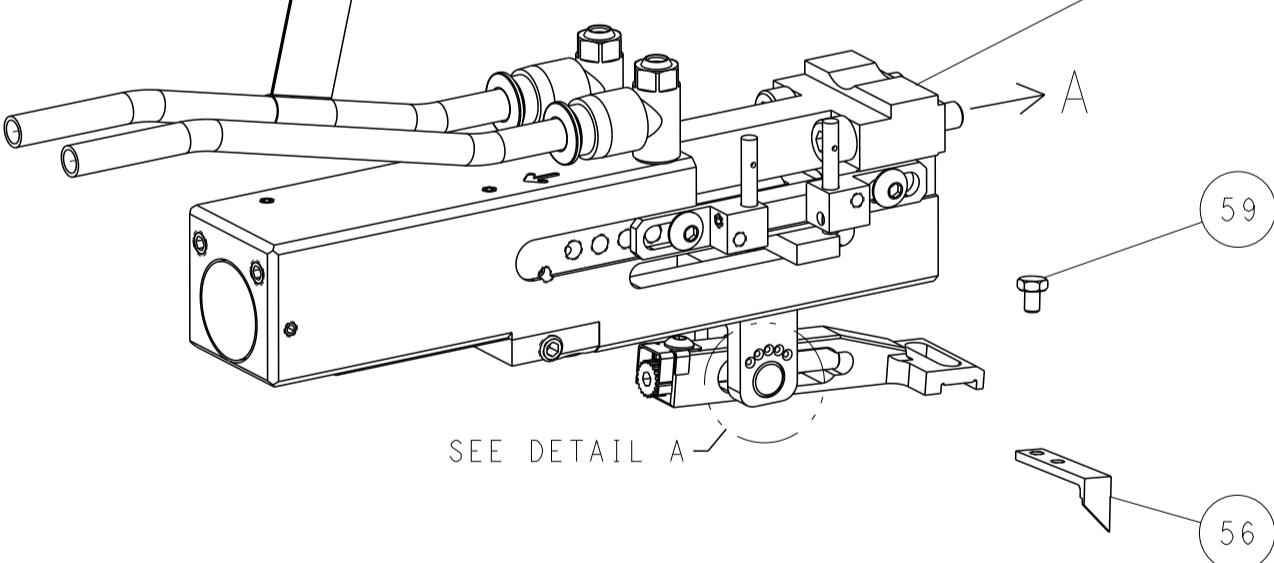
PNEUMATIC



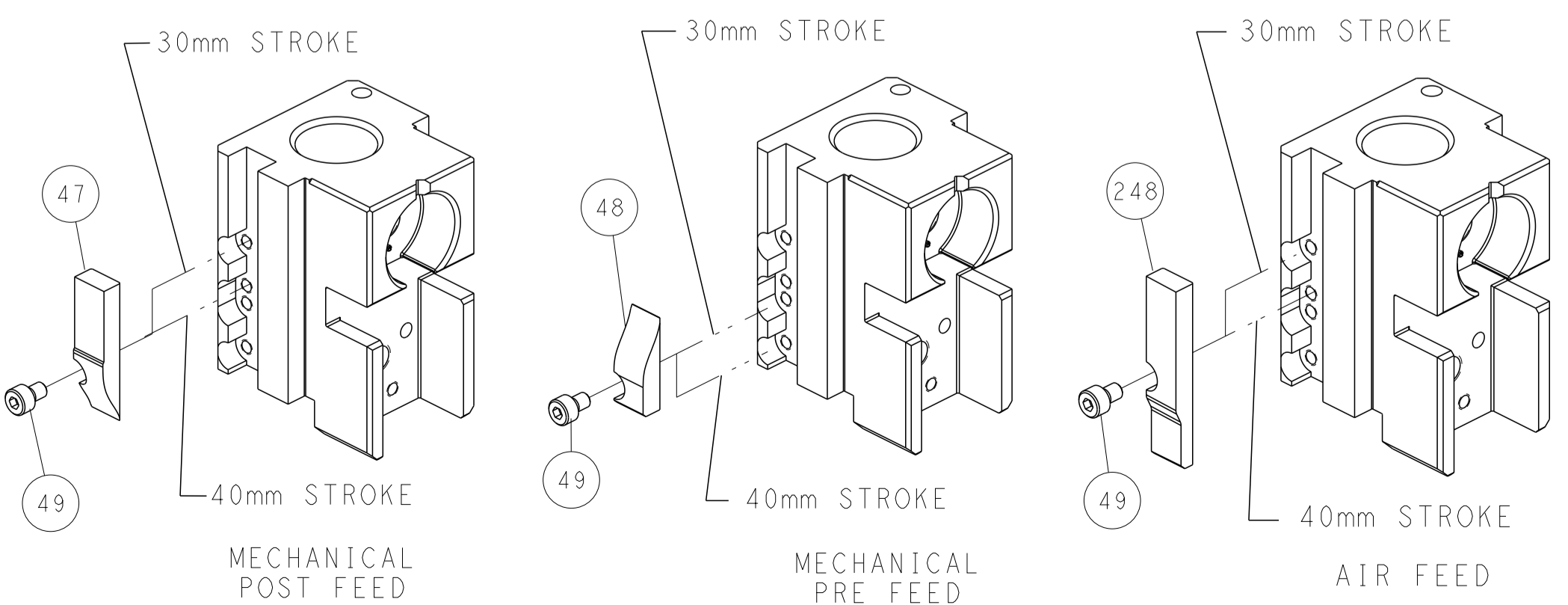
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DOUBLE ACTING PNEUMATIC WITH SENSORS



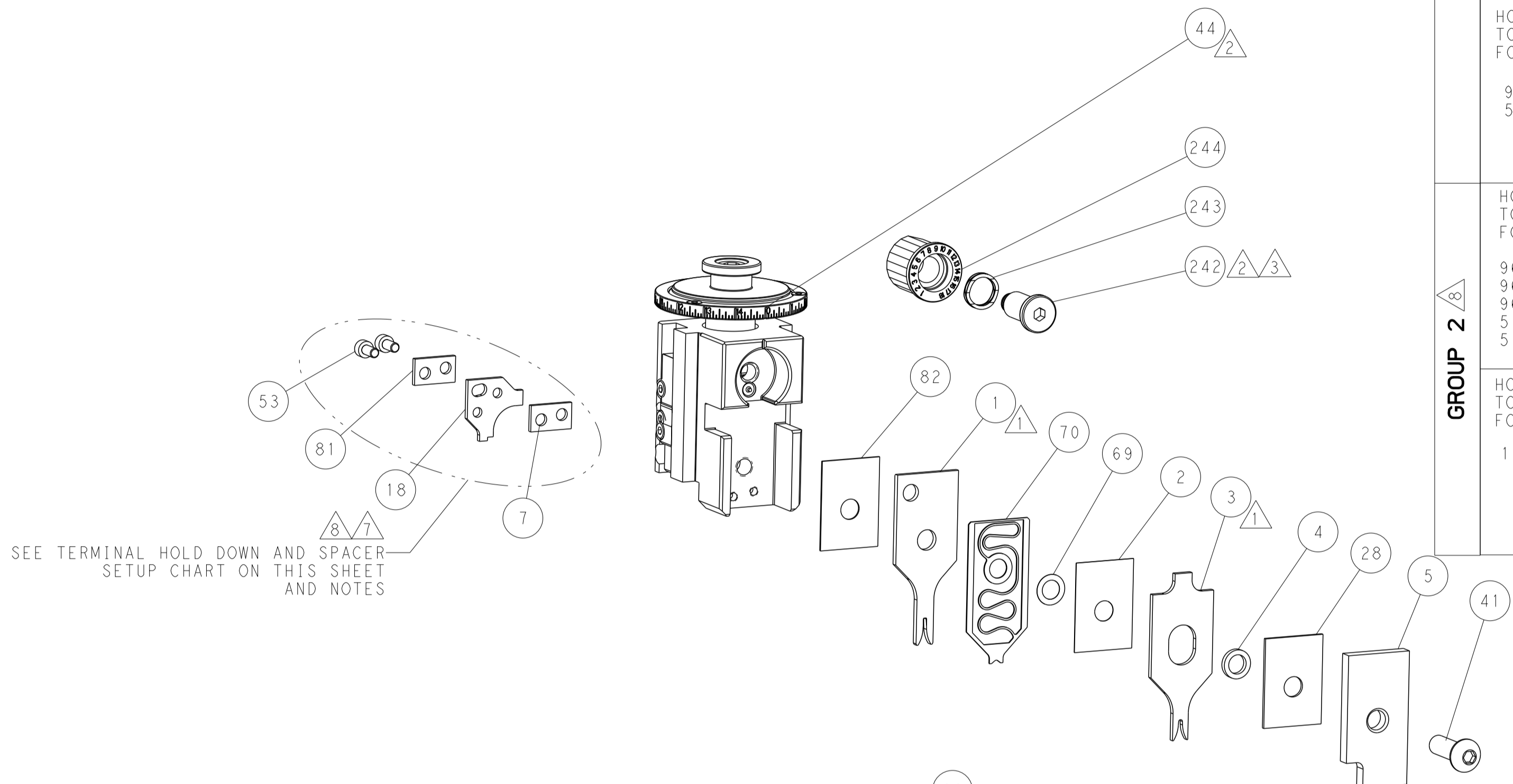
CAM POSITIONS



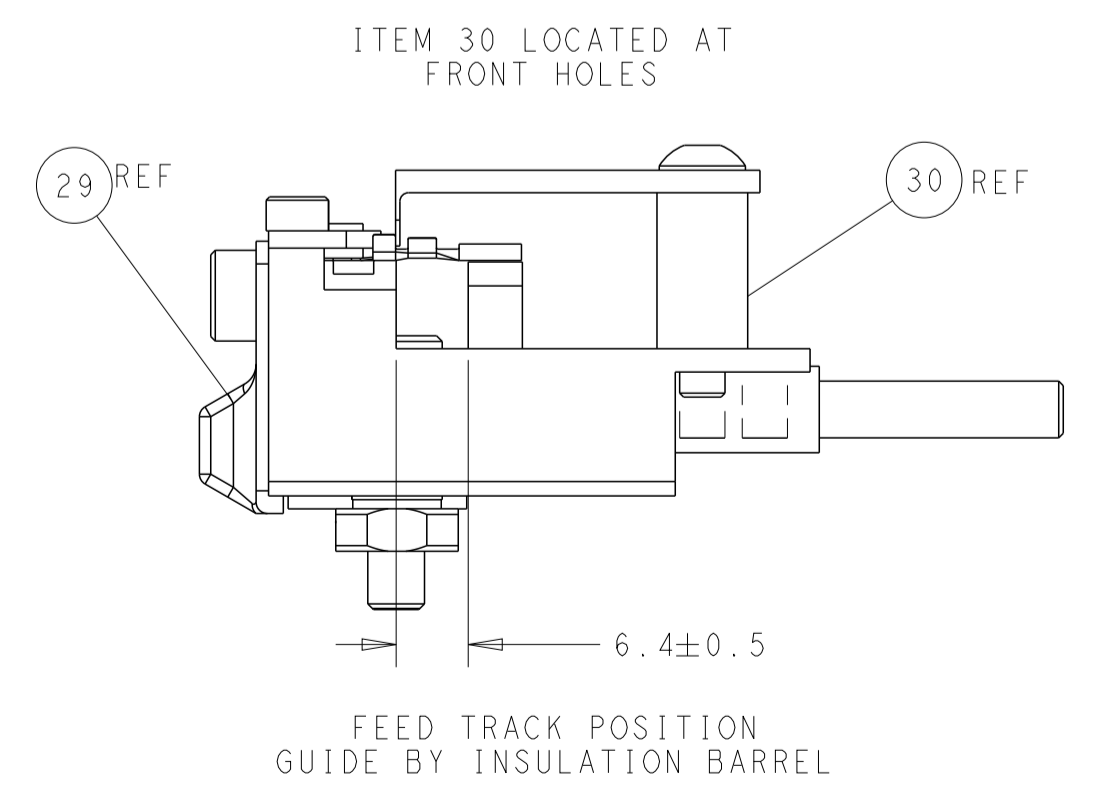
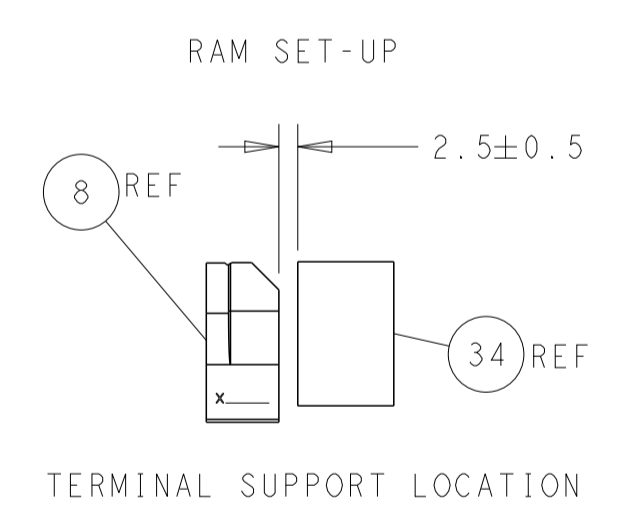
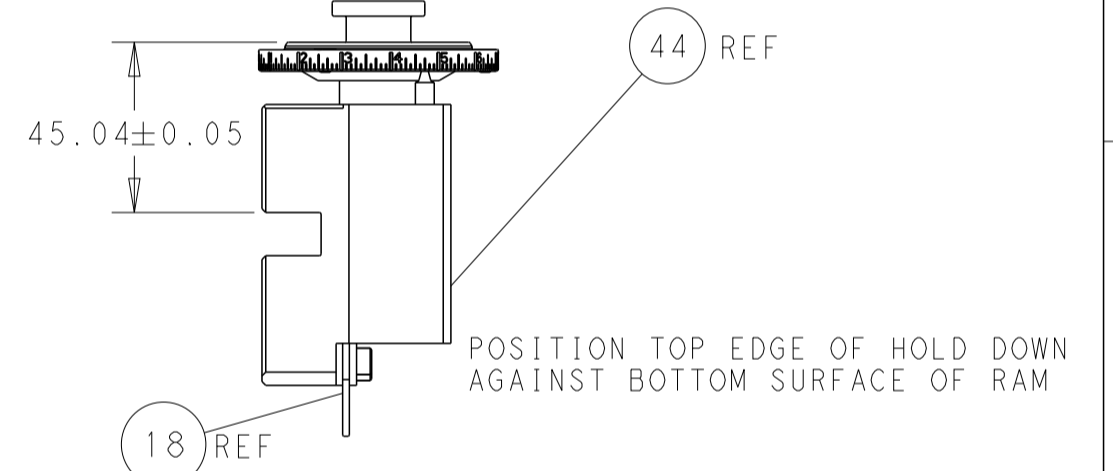
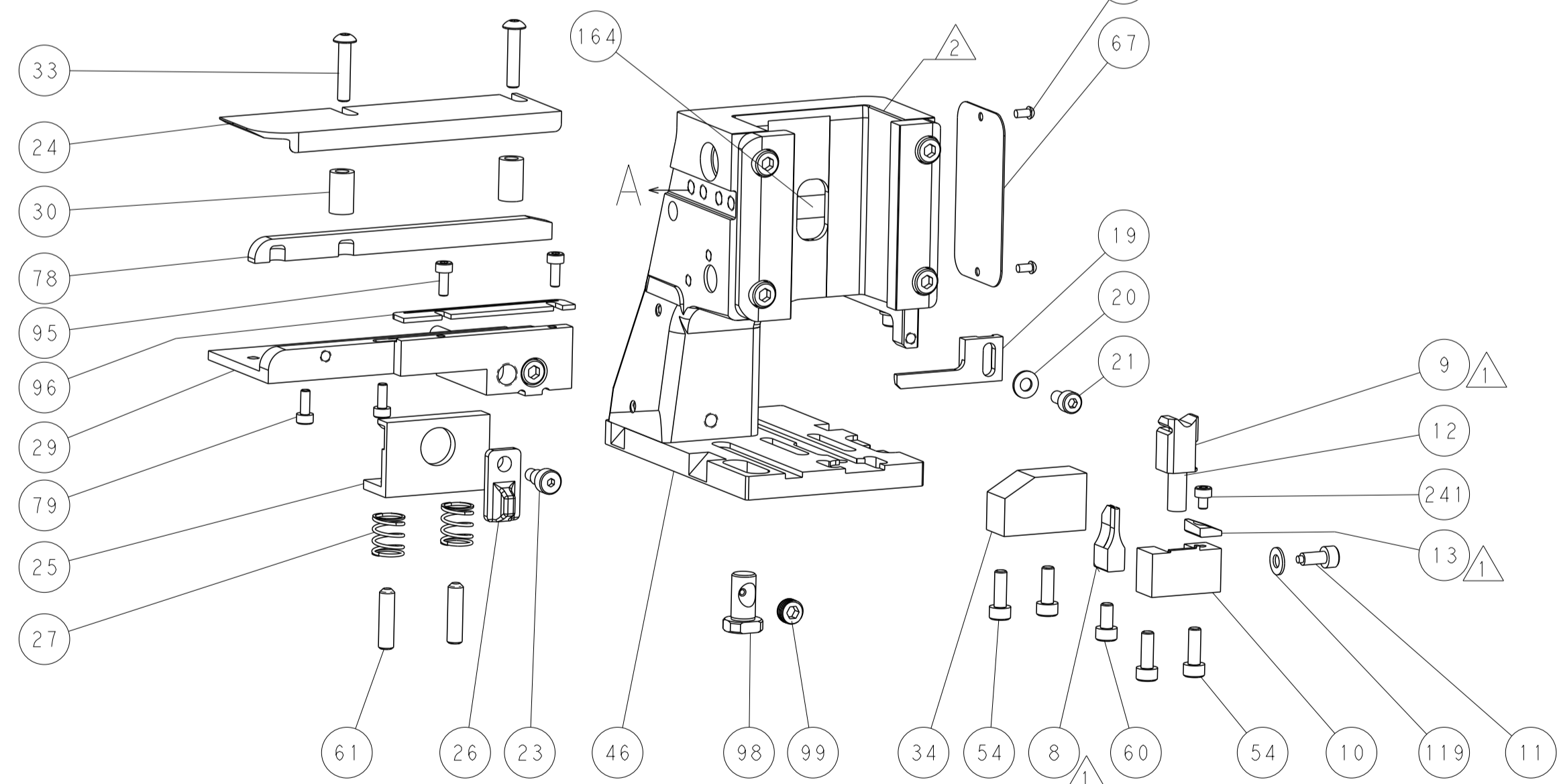
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66	-	SEE SHEET 1	-	-	-

TERMINAL HOLD DOWN & SPACER SETUP CHART

GROUP	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	POSITION	
GROUP 1	928999-1 928999-5 928999-6 5-928999-1 5-928999-5 5-928999-6 6-928999-5 928918-1 928918-2 1-928918-1 1-928918-2	2-928918-2 3-928918-2 5-928918-1 6-928918-2 6-928918-3 1394702-1 1394702-2 5-1394702-1 5-1394702-2	POSITION 1
	968893-1 5-968893-1		POSITION 1
GROUP 2	968220-1 968220-5 968220-6 5-968220-1 5-968220-5	5-968220-6 1703296-1 1703296-5 1534116-1 1534116-2 5-1534116-1	POSITION 2
	1241918-1		POSITION 2



SEE TERMINAL HOLD DOWN AND SPACER SETUP CHART ON THIS SHEET AND NOTES



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:		OWN: HOFFNER 07DEC2001	TE Connectivity
0 PLC	±	1 PLC	±	CHE: T. ELBIN 08DEC2011	Harrisburg, PA 17105-3608
2 PLC	±	3 PLC	±	APVD: T. ELBIN 08DEC2011	
4 PLC	±	ANGLES	±	NAME: Ocean Side Feed Applicator	
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2	SIZE: A1	CAGE CODE: 00779
CUSTOMER DRAWING		DRAWING NO: C=2151541		RESTRICTED TO:	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151541-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151541-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151541-2	J	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151541-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS 408-35042

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TERMINAL NAME: MICRO QUADLOK SYSTEM			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.05-3.35 mm [1.120-1.132 IN]	Ø1.15-1.60 mm [1.045-.063 IN]		
TERMINAL APPLICATION SPECIFICATION (A)114-18021			
(B)114-61024			

TERMINALS APPLIED			
GROUP 1		GROUP 2	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 5-928999-5	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 5-928999-6	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 6-928999-5	(A) 1394702-2	(B) 2005119-1	(A) 1241918-1
(A) 928918-1	(A) 5-1394702-1		
(A) 928918-2	(A) 5-1394702-2		
(A) 1-928918-1	(A) 968893-1		
(A) 1-928918-2	(A) 5-968893-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.82 +/- 0.03 [0.032 +/- .001]	9.3
0.25mm2	0.76 +/- 0.03 [0.030 +/- .001]	10.0
0.20mm2	0.72 +/- 0.03 [0.028 +/- .001]	10.4

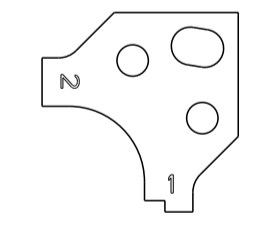
- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 5 REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm² WIRE.
- 6 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

TERMINAL DATA: TE TERMINAL		TE SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.05-3.35 mm [1.120-1.132 IN]	Ø1.15-1.60 mm [1.045-.063 IN]		
TERMINAL APPLICATION SPECIFICATION (A)114-18021			
(B)114-61024			

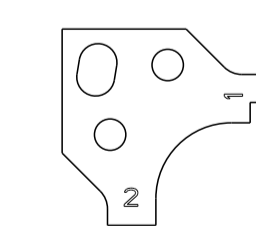
TERMINALS APPLIED			
GROUP 1		GROUP 2	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 5-928999-5	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 5-928999-6	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 6-928999-5	(A) 1394702-2		(A) 1241918-1
(A) 928918-1	(A) 5-1394702-1		
(A) 928918-2	(A) 5-1394702-2		
(A) 1-928918-1	(A) 968893-1		
(A) 1-928918-2	(A) 5-968893-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.92 +/- 0.03 [0.036 +/- .001]	8.3

1 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS, REFER TO SHEET 2.



2 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS, REFER TO SHEET 2.



3 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.

***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	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1-240641-3	SPACER	81
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1633782-2	FENCE	78
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	-	1	2	18023-9	SCR, SKT HD CAP, M4 X 6.0	49
-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	2217529-1	TERMINAL HOLD DOWN	18
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1333233-1	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	4-240641-2	SPACER	7
-	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	5-568176-3	CRIMPER, WIRE	1

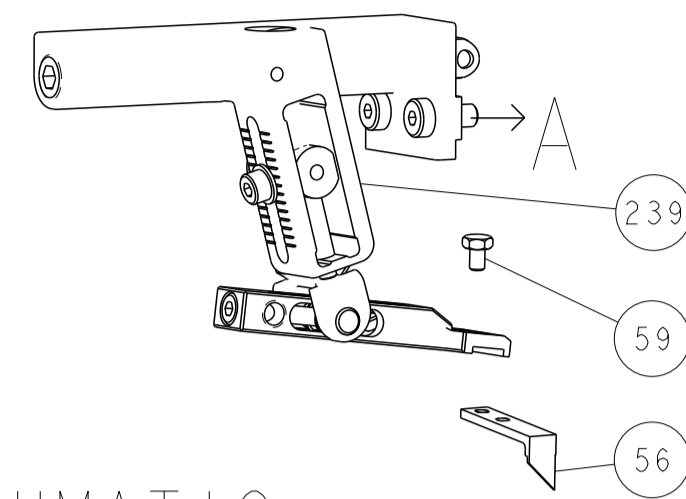
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±	FINISH			

ITEM NO	PART NO	DESCRIPTION		
-77	-42	-22	-21	APPLICATOR

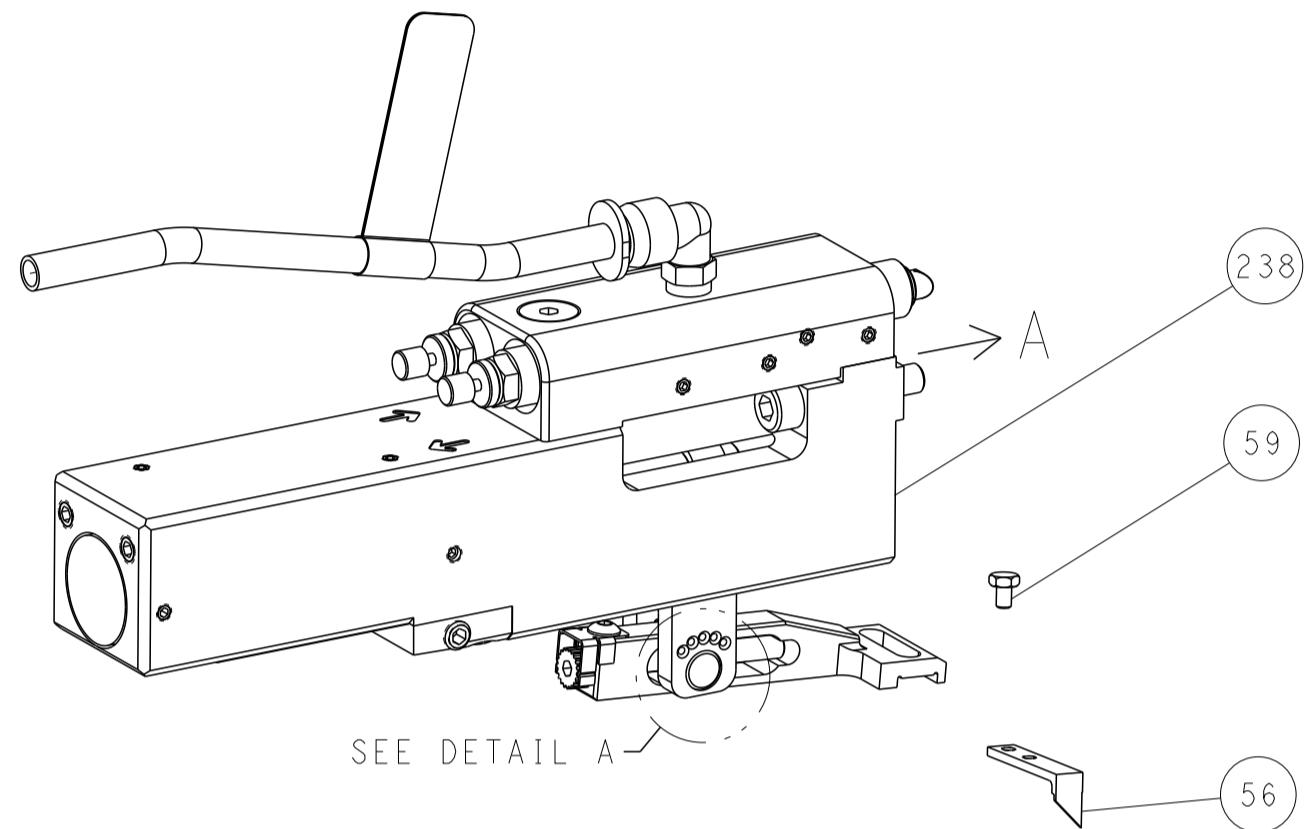
DATE	07DEC2001	BY	HOFFNER
DATE	08DEC2011	BY	ELBIN
DATE	08DEC2011	BY	ELBIN

SCALE	1:2	SHEET	3	OF	4
REV	J				

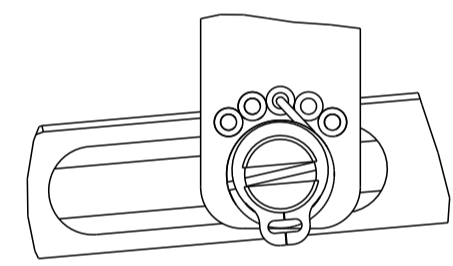
FEED TYPE MECHANICAL



PNEUMATIC

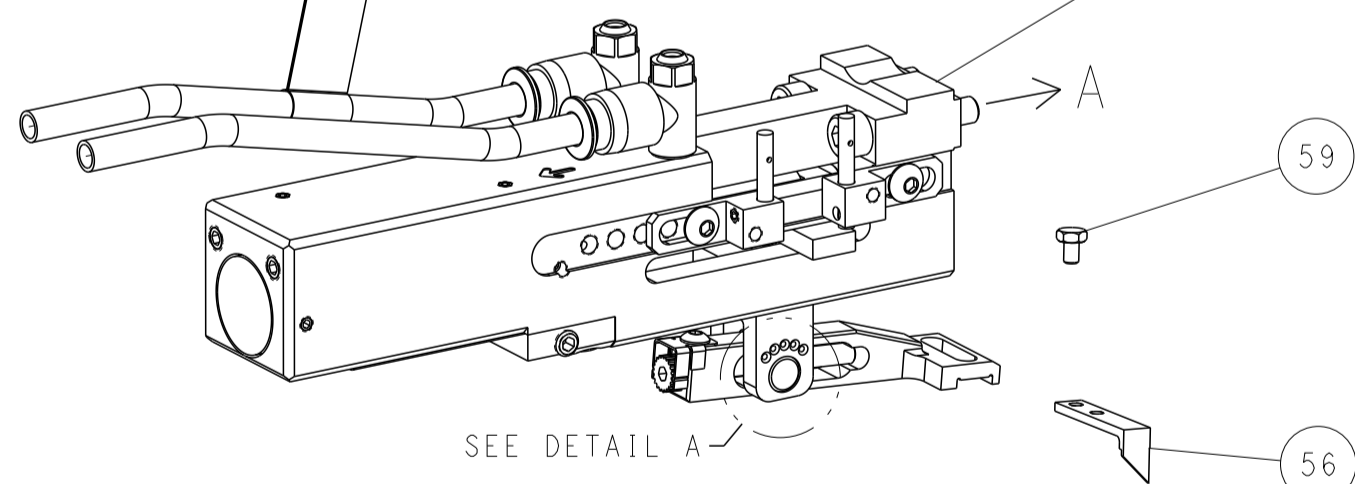


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



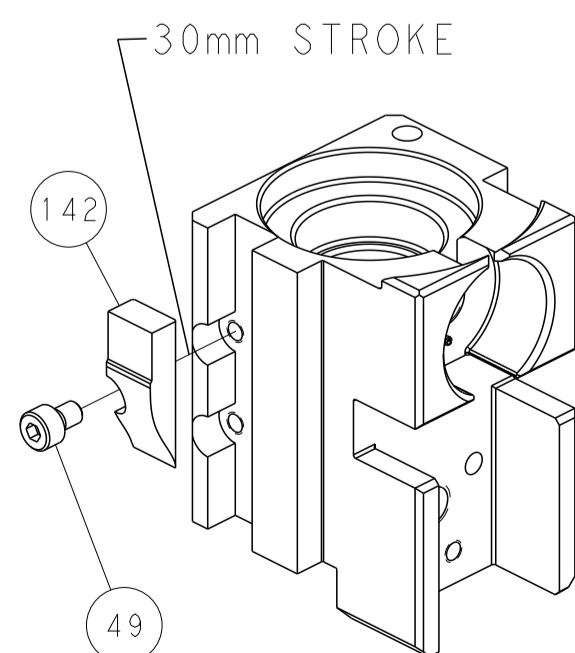
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

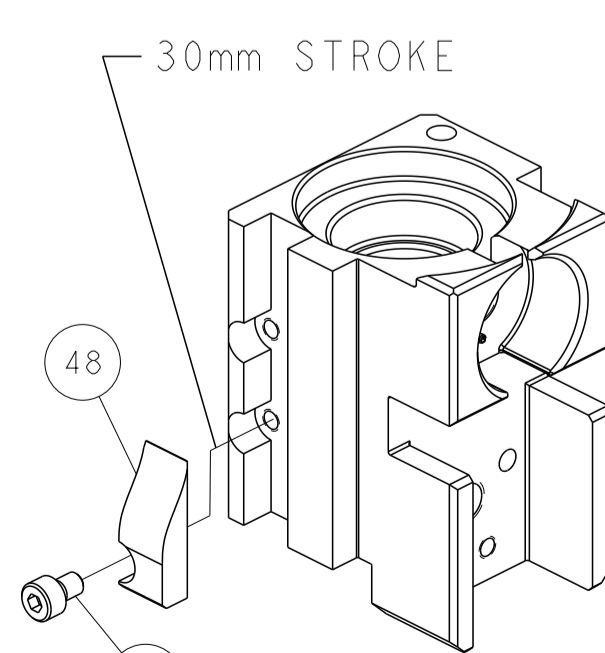


SEE DETAIL A

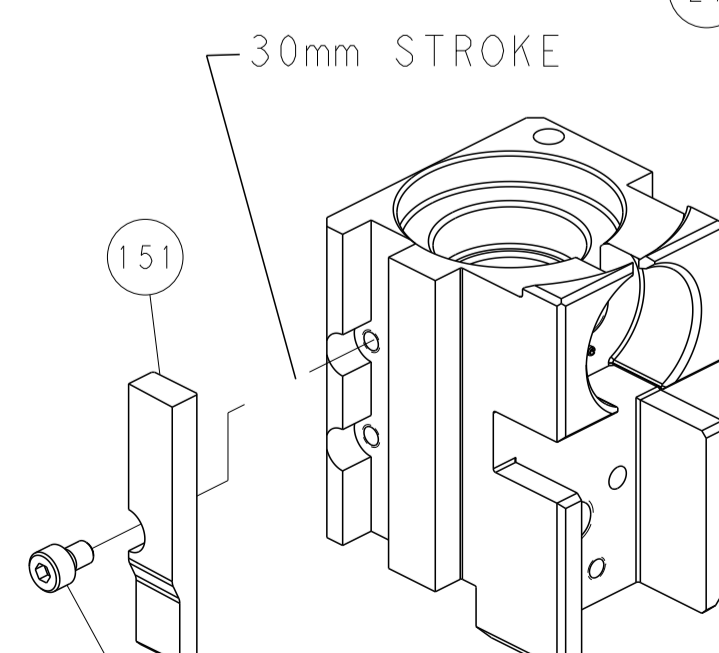
CAM POSITIONS



MECHANICAL POST FEED

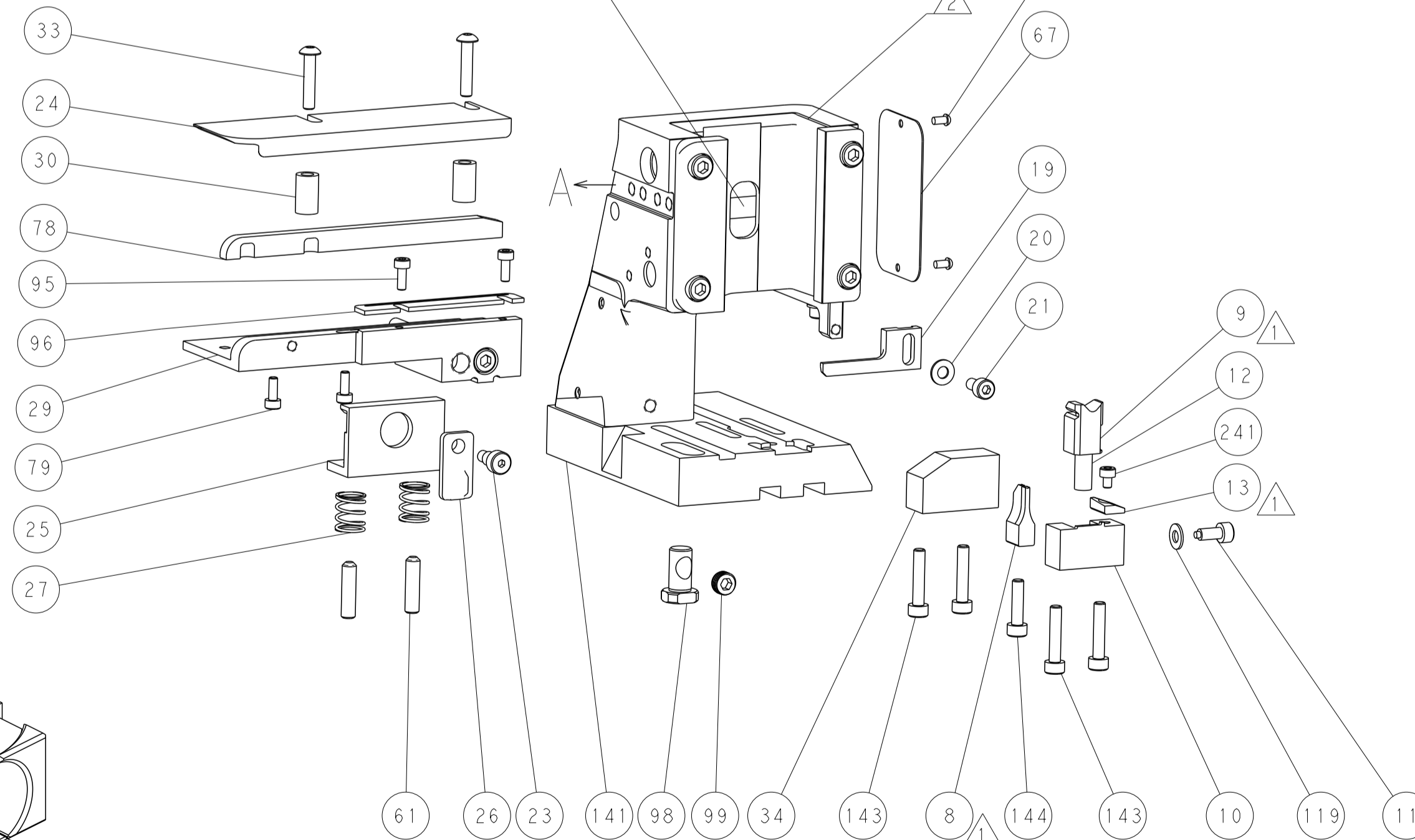


MECHANICAL PRE FEED



AIR FEED

SEE TERMINAL HOLD DOWN AND SPACER SETUP CHART ON THIS SHEET AND NOTES

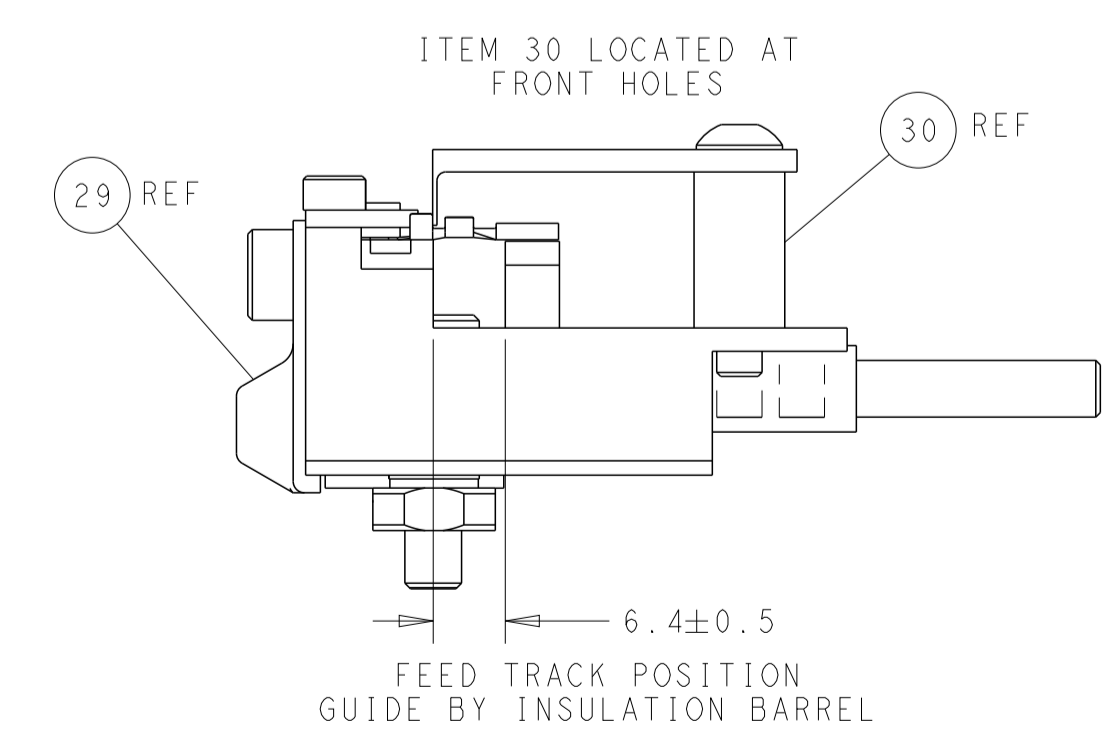
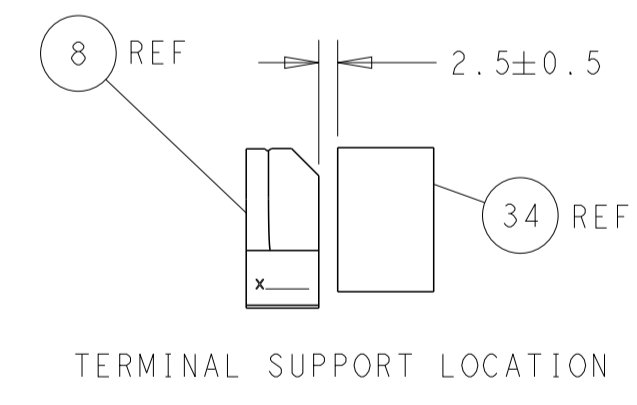
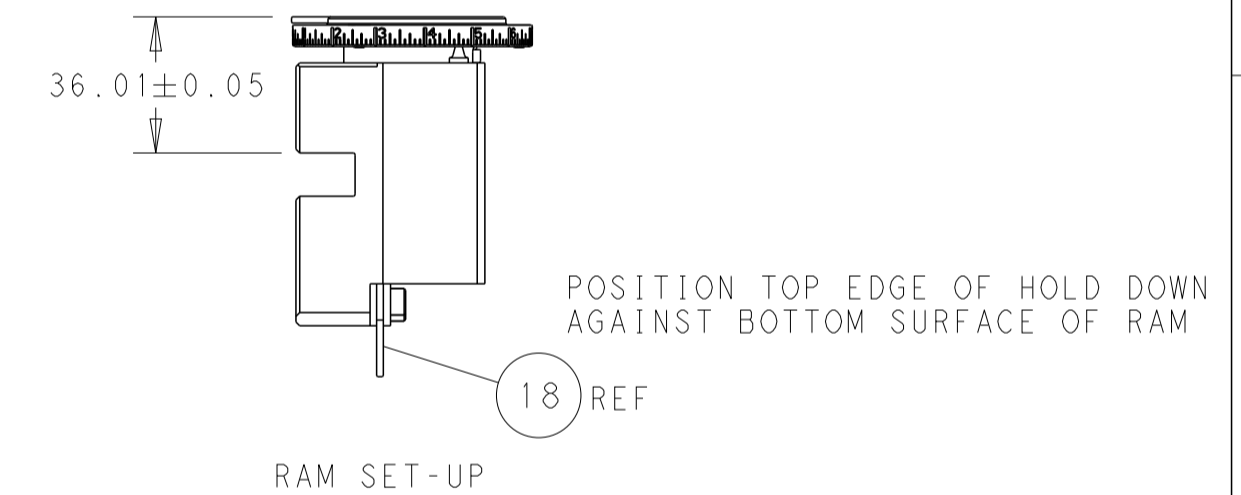


PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

TERMINAL HOLD DOWN & SPACER SETUP CHART

GROUP	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	POSITION
GROUP 1	928999-1 2-928918-2 928999-5 3-928918-2 928999-6 5-928918-1 5-928999-1 6-928918-1 5-928999-5 6-928918-2 5-928999-6 6-928918-3 6-928999-5 1394702-1 928918-1 1394702-1 928918-2 5-1394702-1 1-928918-1 5-1394702-2 1-928918-2	POSITION 1
	968893-1 5-968893-1	POSITION 1
GROUP 2	968220-1 5-968220-6 968220-5 1703296-1 968220-6 1703296-5 5-968220-1 1534116-1 5-968220-5 1534116-2 5-1534116-1	POSITION 2
	1241918-1	POSITION 2



DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: HOFFNER 07DEC2001		CHK: T. ELBIN 08DEC2011		APVD: T. ELBIN 08DEC2011		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
MATERIAL:		FINISH:		WEIGHT:		CAGE CODE: 00779		DRAWING NO: C=2151541		RESTRICTED TO:	
						CUSTOMER DRAWING		SCALE: 1:2		SHEET 4 OF 4 REV J	