

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151493-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151493-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151493-2	J	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
5-2151493-1	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151493-2	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151493-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151493-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151493-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: MICRO QUADOCK SYSTEM			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.45-3.75 mm [.136-.148 IN]	Ø 1.10-1.60 mm [.043-.063 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)	(B)	
	(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) 968893-1	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 928918-1	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 928918-2	(A) 1394702-2	(B) 2005119-1	(A) 1241918-1
(A) 1-928918-1	(A) 5-928999-5		
(A) 1-928918-2	(A) 5-928999-6		
(A) 5-1394702-1	(A) 6-928999-5		
(A) 5-1394702-2	(A) 5-968893-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
Ø 0.50mm2	0.86 +/- 0.03 [.034 +/- .001]	9.0
Ø 0.35mm2	0.76 +/- 0.03 [.030 +/- .001]	9.9
Ø 22 AWG	0.76 +/- 0.03 [.030 +/- .001]	9.9
Ø 0.25mm2	0.72 +/- 0.03 [.028 +/- .001]	10.4

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm² WIRE.
- POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS. REFER TO SHEET 2.
- POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS. REFER TO SHEET 2.

- 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. **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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.

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	OWN	APVD
		H2		ECR-20-013038	15SEP2020	FJ	TE
		H3		ECR-20-013836	28SEP2020	JWC	TE
		H4		ECR-21-000640	19JAN2021	FJ	YY
		J		ECR-21-109886	11AUG2021	JWC	RK

-	-	-	1	1	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	-	1-1752354-7	STANDOFF, HOLD-DOWN	180
-	-	-	1	1	-	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	1	1	-	-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1	1-240641-3	SPACER	81
-	2	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1	1	1	1	1633782-2	FENCE	78
-	1	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	1	2	1	2	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	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
-	2	2	1	1	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	1	1803155-1	HOLD DOWN, TERMINAL	18
-	1	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1	1-1338690-2	ANVIL, COMBINATION .055	8
-	1	1	1	1	1	1	1	4-240641-2	SPACER	7
-	1	1	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1	1-562108-5	CRIMPER, WIRE, F	1

ITEM NO	PART NO	DESCRIPTION
-77	-72	-71
-52	-51	-32
-2	-1	

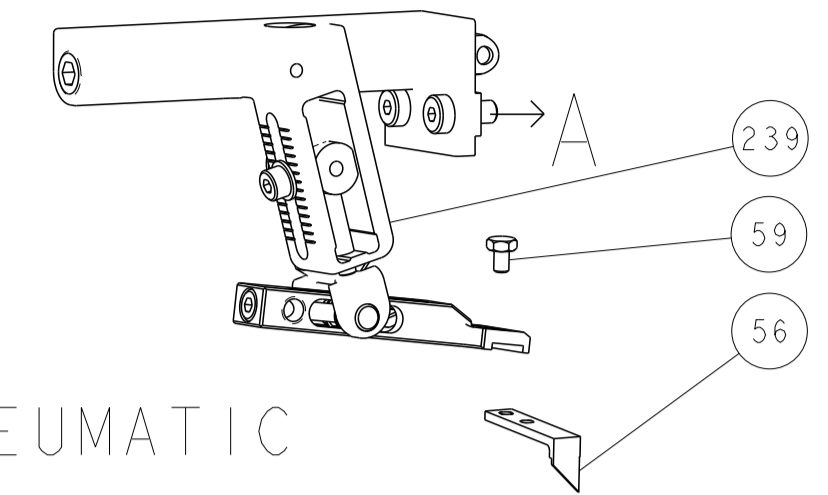
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC	±	1 PLC	±
2 PLC	±	3 PLC	±
4 PLC	±	5 PLC	±
ANGLES	±	FINISH	±
MATERIAL		WEIGHT	

TE Connectivity Harrisburg, PA 17105-3608	NAME: Ocean Side Feed Applicator
SIZE: A1	CAGE CODE: 00779
DRAWING NO: C=2151493	RESTRICTED TO: -
Customer Accessible Production Drawing	
SCALE: 1:2	SHEET 1 OF 4
REV: J	

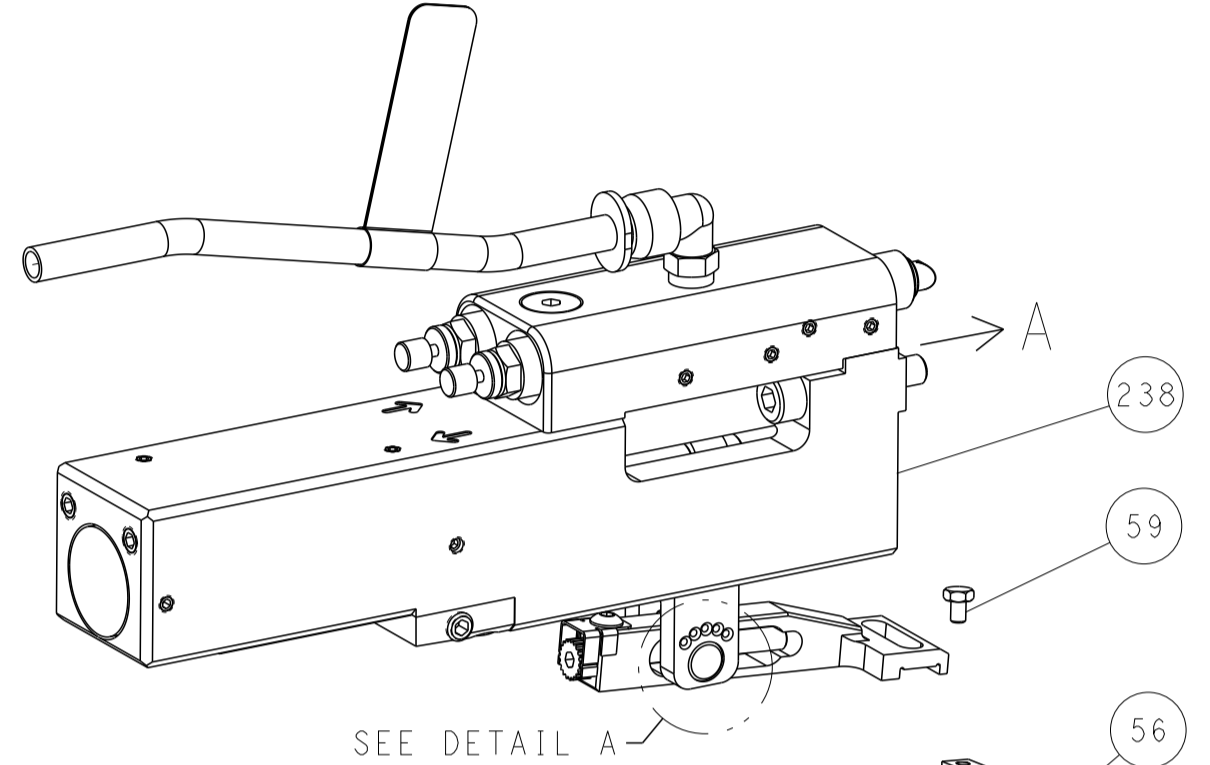
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS			
NO.	DESCRIPTION	DATE	BY
-	SEE SHEET 1	-	-

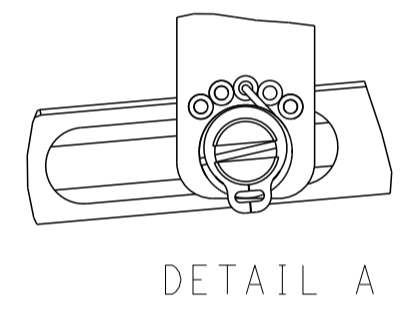
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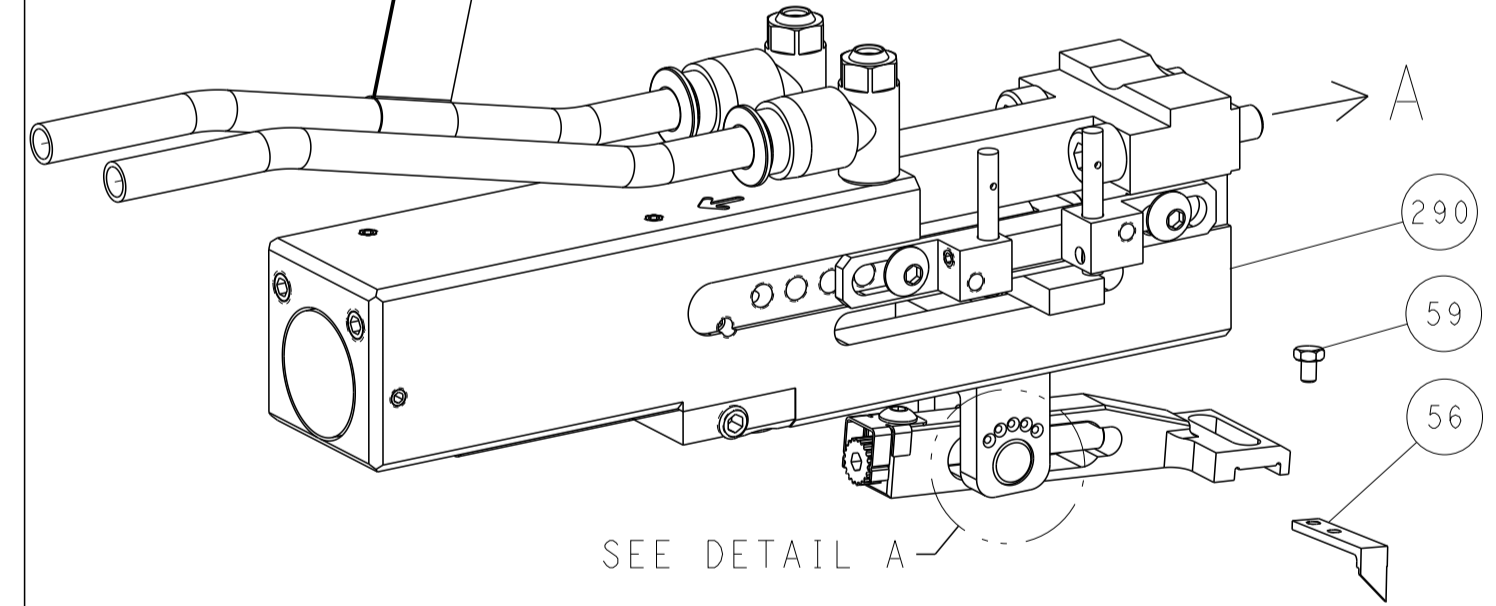
PNEUMATIC



SEE DETAIL A
 FEED SPRING SETTING POSITION
 (SHOWN FROM REAR SIDE)

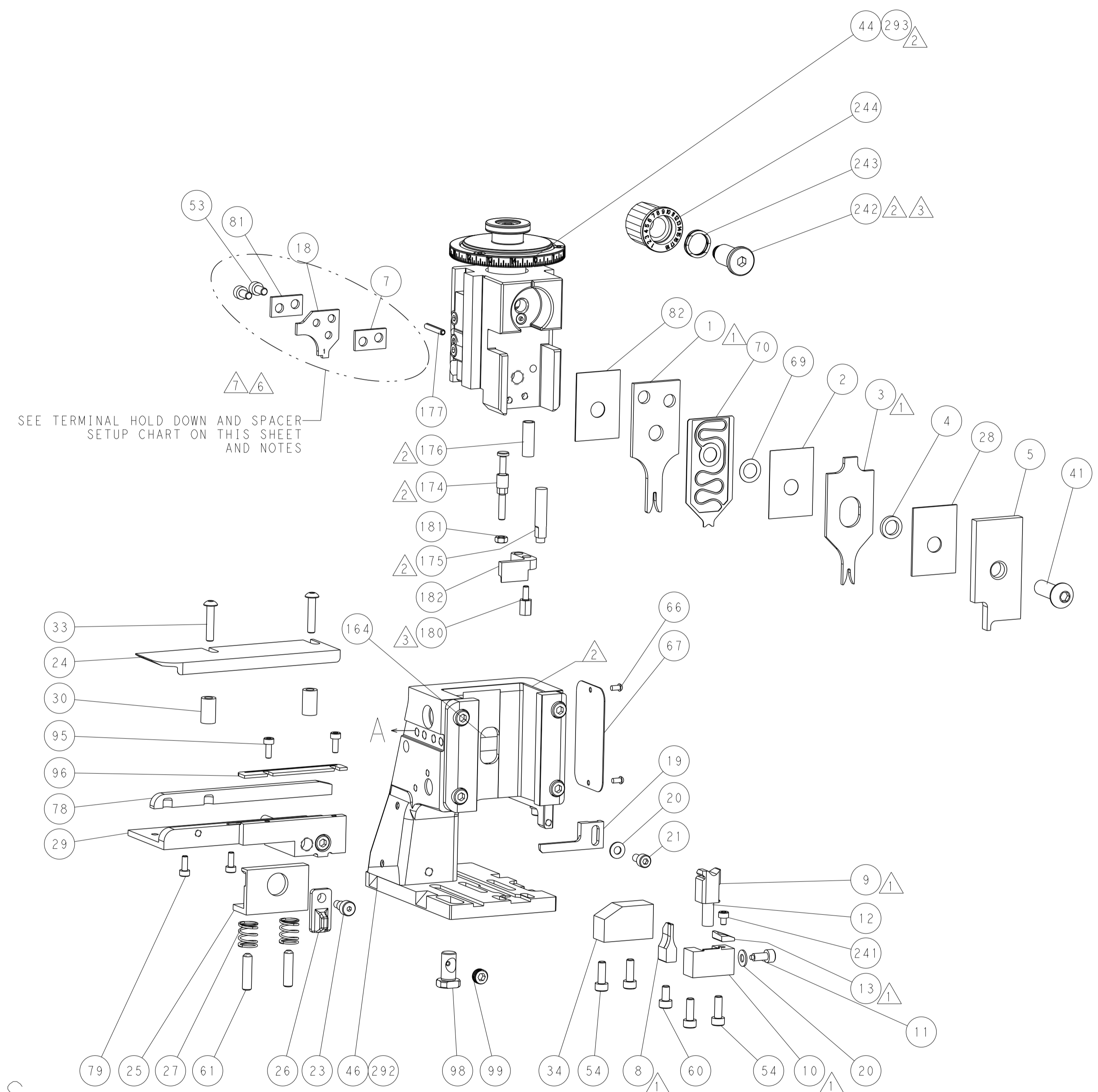
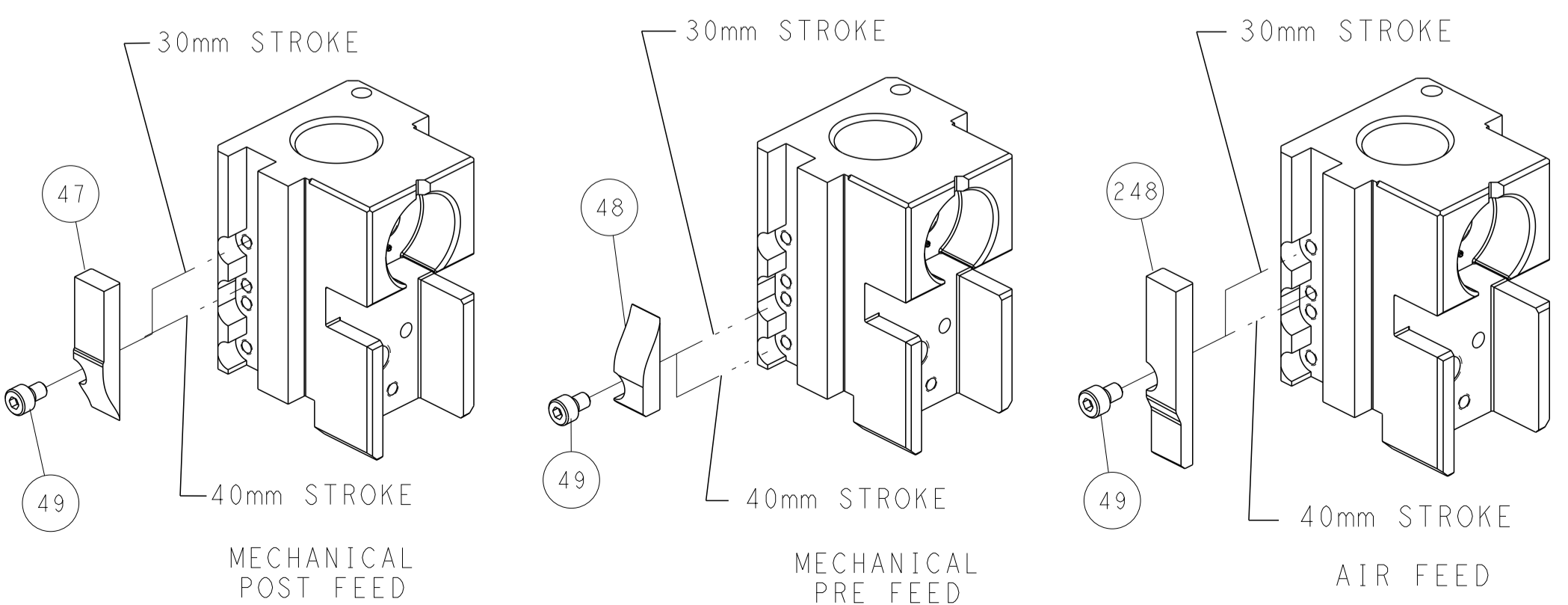


DOUBLE ACTING PNEUMATIC WITH SENSORS



SEE DETAIL A

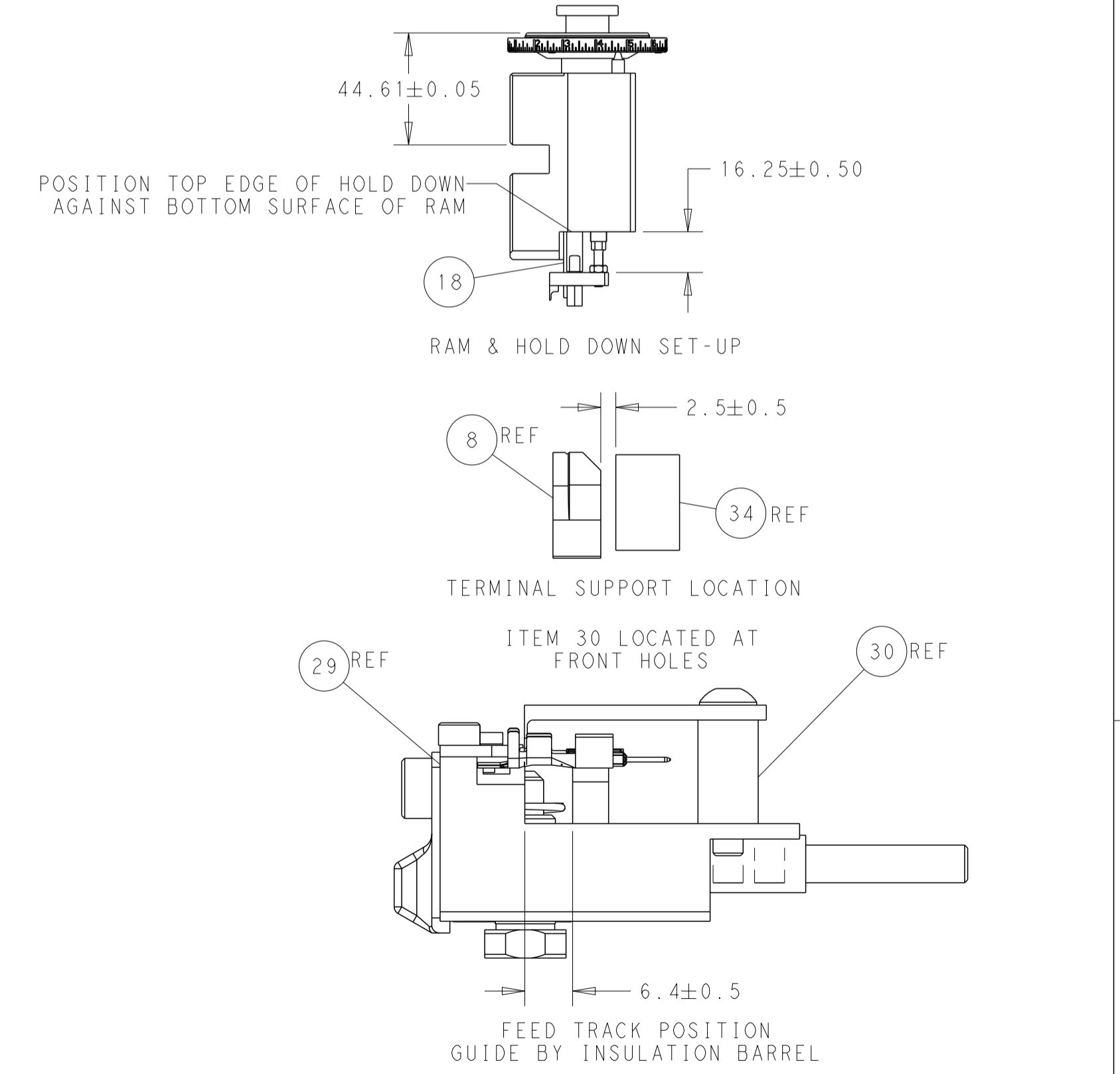
CAM POSITIONS



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

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 6-928999-5 6-928918-2 928918-1 6-928918-3 928918-2 1394702-1 1-928918-1 1394702-2 1-928918-2 5-1394702-1 5-1394702-2	POSITION 1
	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 5-968220-5 5-1534116-1 5-1534116-2	POSITION 2
	1241918-1	POSITION 2

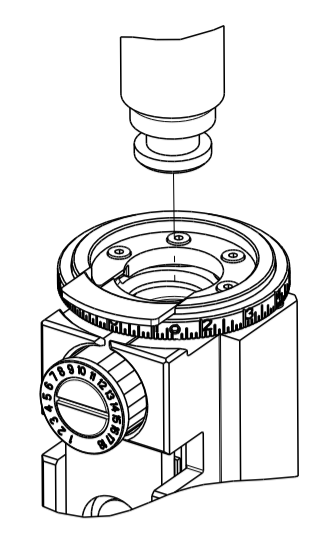


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN L.GROSS 02SEP2011 CHK G.BAILLEY 02SEP2011 APVD J.CRUZ 02SEP2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2151493 SCALE 1:2 SHEET 2 OF 4 REV J		TE Connectivity Harrisburg, PA 17105-3608	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151493-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151493-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151493-2	J	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151493-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: MICRO QUADOCK SYSTEM

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.45-3.75 mm [.136-.148 IN]	1.10-1.60 mm [.043-.063 IN]

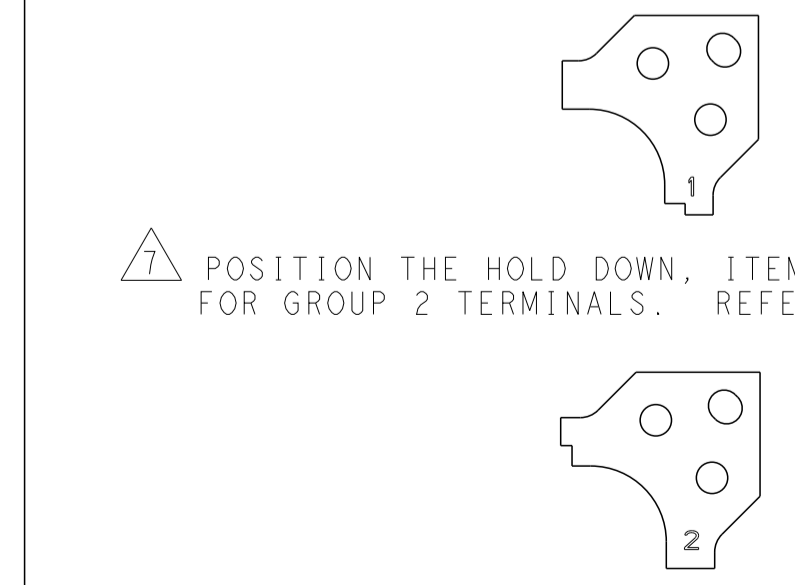
TERMINAL APPLICATION SPECIFICATION (A) 114-18021 (B) 114-61024

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) 968893-1	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 928918-1	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 928918-2	(A) 1394702-2	(B) 2005119-1	(A) 1241918-1
(A) 1-928918-1	(A) 5-928999-5		
(A) 1-928918-2	(A) 5-928999-6		
(A) 5-1394702-1	(A) 6-928999-5		
(A) 5-1394702-2	(A) 5-968893-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.86+/-0.03 [.034+/-0.001]	9.0
0.35mm2	0.76+/-0.03 [.030+/-0.001]	9.9
22 AWG	0.76+/-0.03 [.030+/-0.001]	9.9
0.25mm2	0.72+/-0.03 [.028+/-0.001]	10.4

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS. REFER TO SHEET 4.
- 7 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS. REFER TO SHEET 4.



- 8 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. **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.
- 9. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 10 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.

ENTRY LEVEL APPLICATOR ITEM SUBSTITUTION LIST

PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151493-1	2151493-1	1	WIRE CRIMPER	1-1803529-5
8-2151493-2	2151493-2	3	INSULATION CRIMPER	1803604-2
9-2151493-1	2-2151493-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151493-2	2-2151493-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

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	DATE	BY	APPD
A	66	-	-	-	-

REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-	1	-	-	2844950-1 AIR FEED MODULE	290
-	1	1	1	2119082-5 CAM, SWAIL, 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	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	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
-	2	2	2	1-18028-2 WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1 STRIPPER, SIDE FEED	19
-	1	1	1	1803155-1 HOLD DOWN, TERMINAL	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	1-1338690-2 ANVIL, COMBINATION .055	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	2119784-2 CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	455888-1 SPACER, CRIMPER	2
-	1	1	1	1-562108-5 CRIMPER, WIRE, F	1

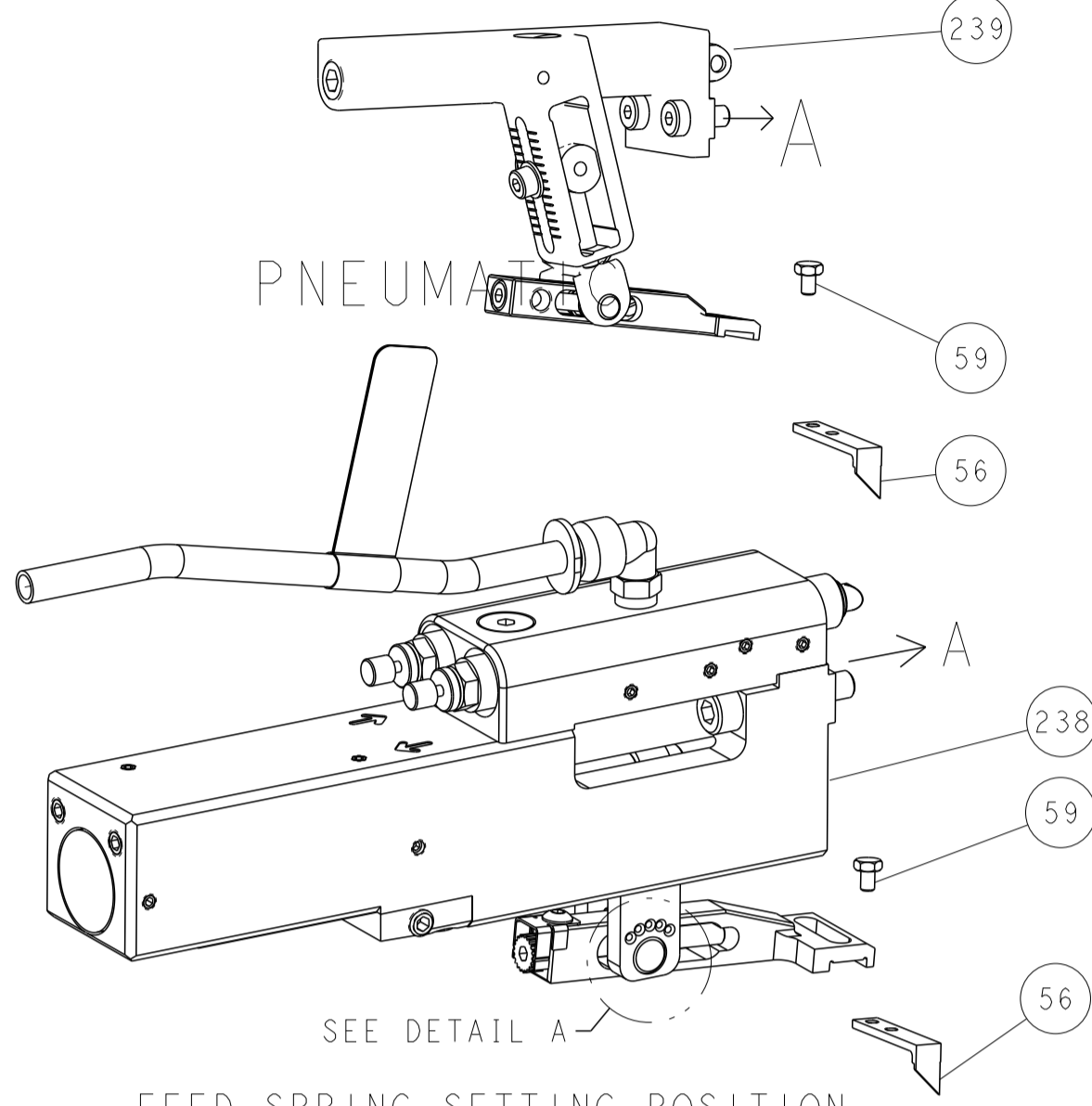
REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-77	-42	-22	-21	PART NO	
				DESCRIPTION	ITEM NO

Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV J

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

FEED TYPE

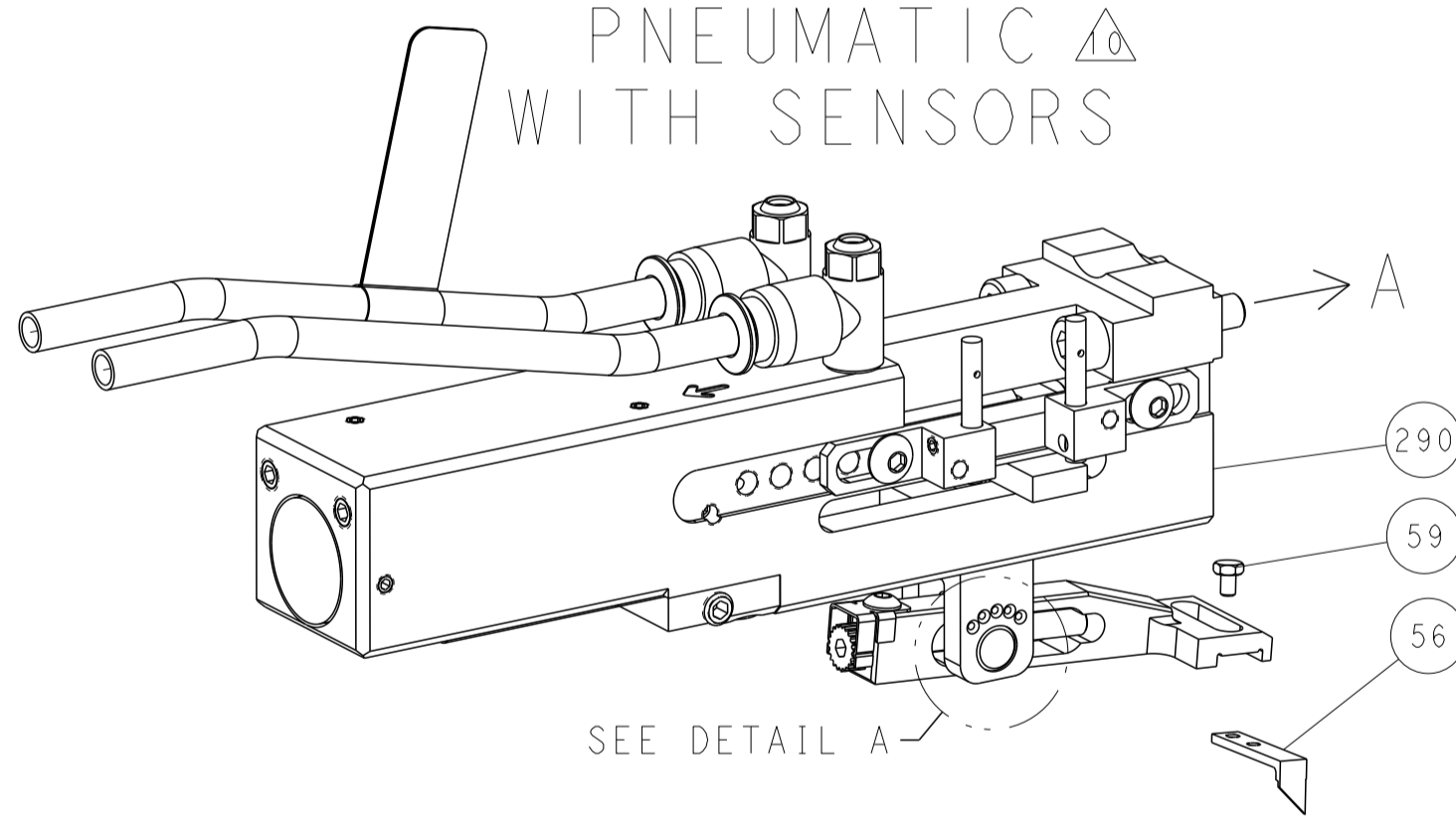
MECHANICAL



SEE DETAIL A
 FEED SPRING SETTING POSITION
 (SHOWN FROM REAR SIDE)

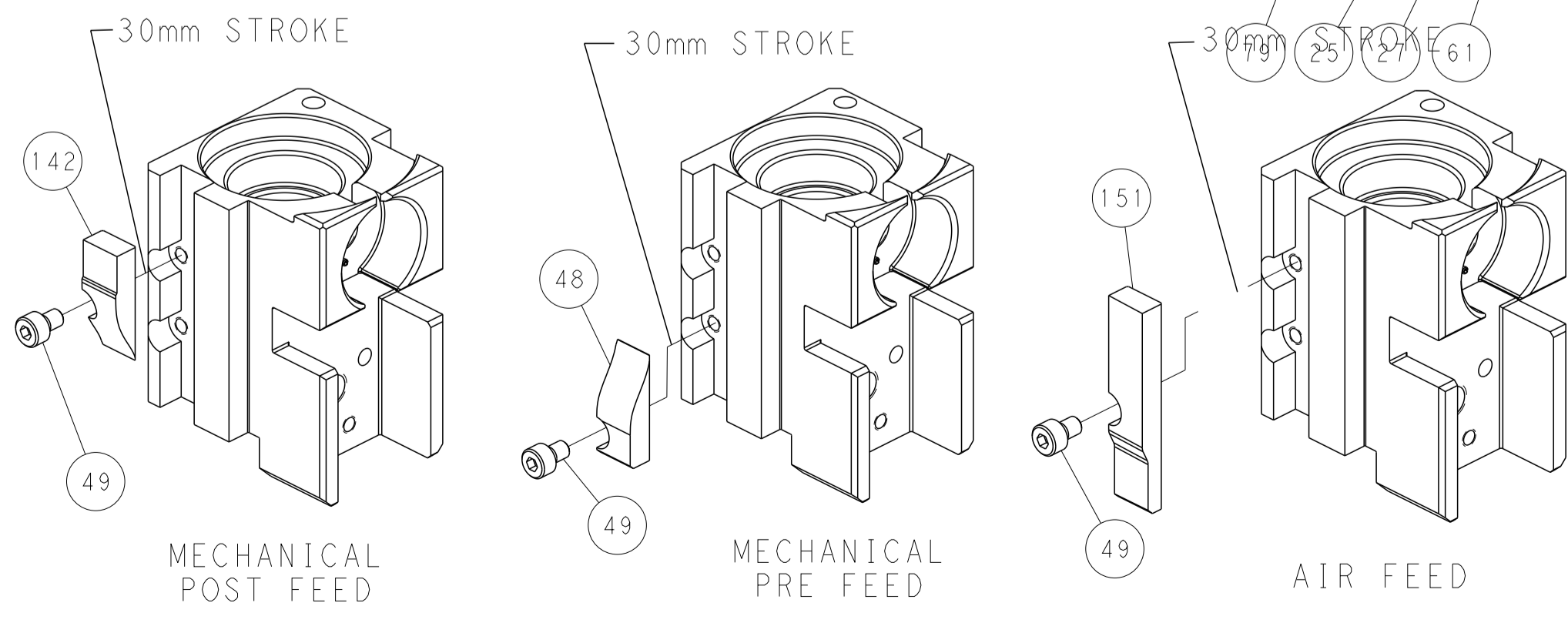
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS



SEE DETAIL A

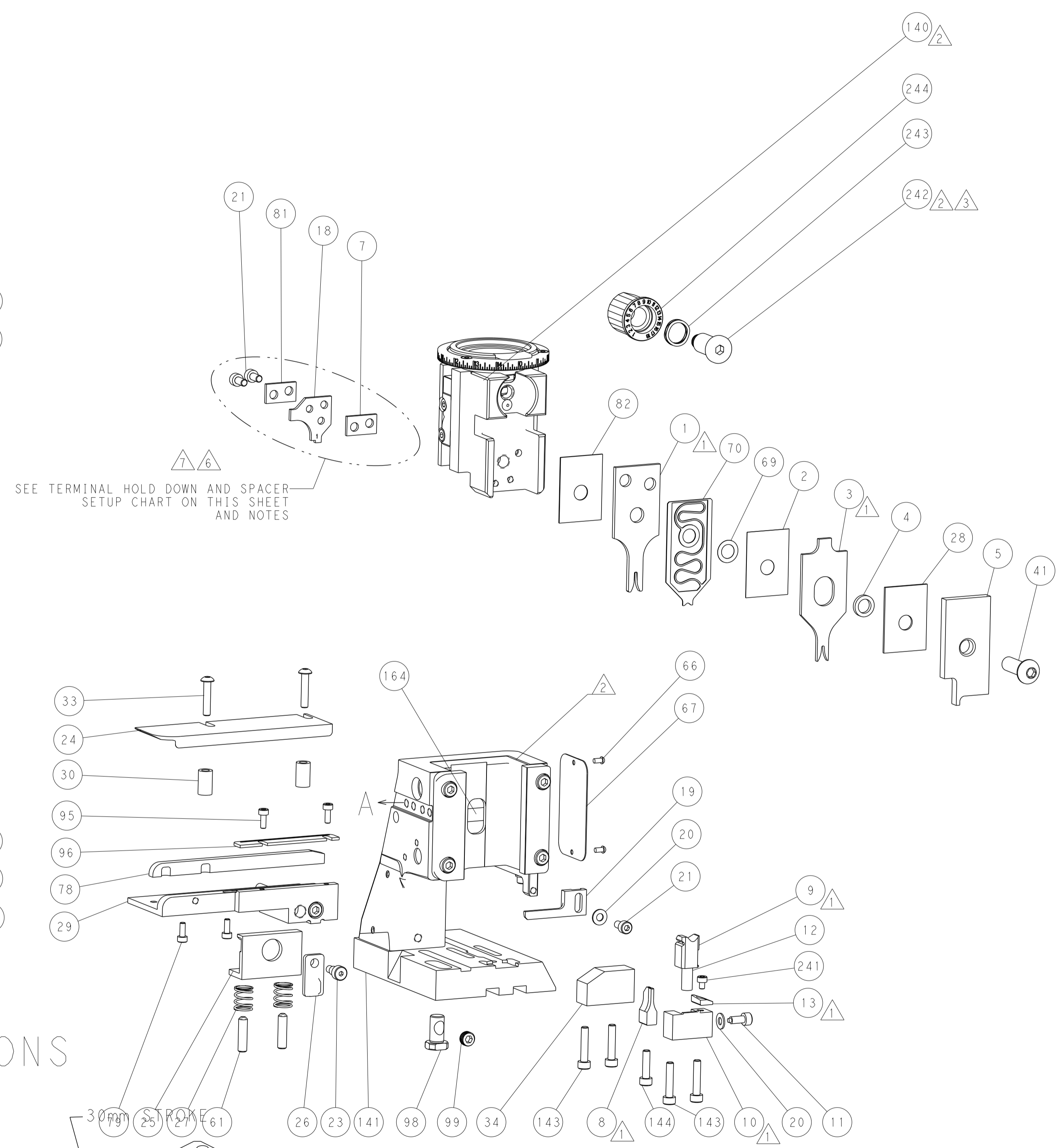
CAM POSITIONS



MECHANICAL POST FEED

MECHANICAL PRE FEED

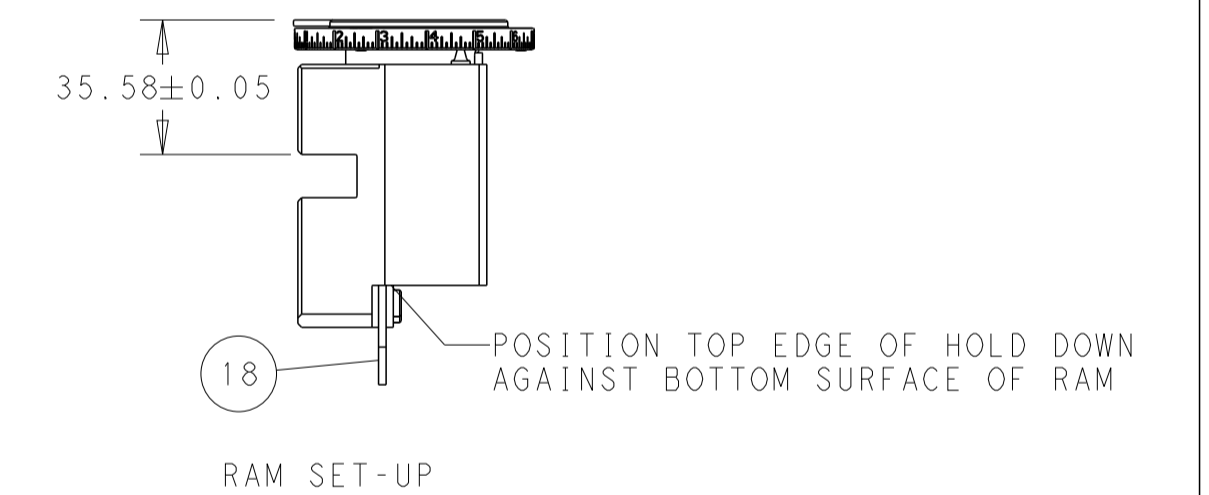
AIR FEED



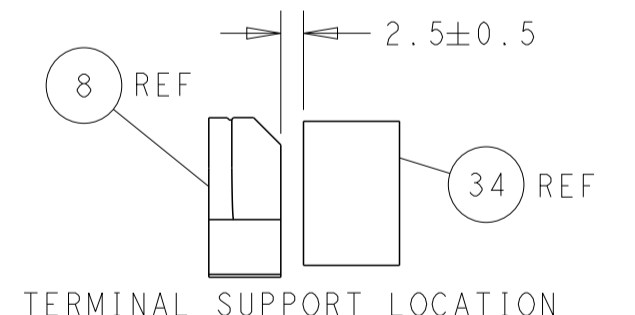
SEE TERMINAL HOLD DOWN AND SPACER
 SETUP CHART ON THIS SHEET
 AND NOTES

TERMINAL HOLD DOWN AND SPACER SETUP CHART

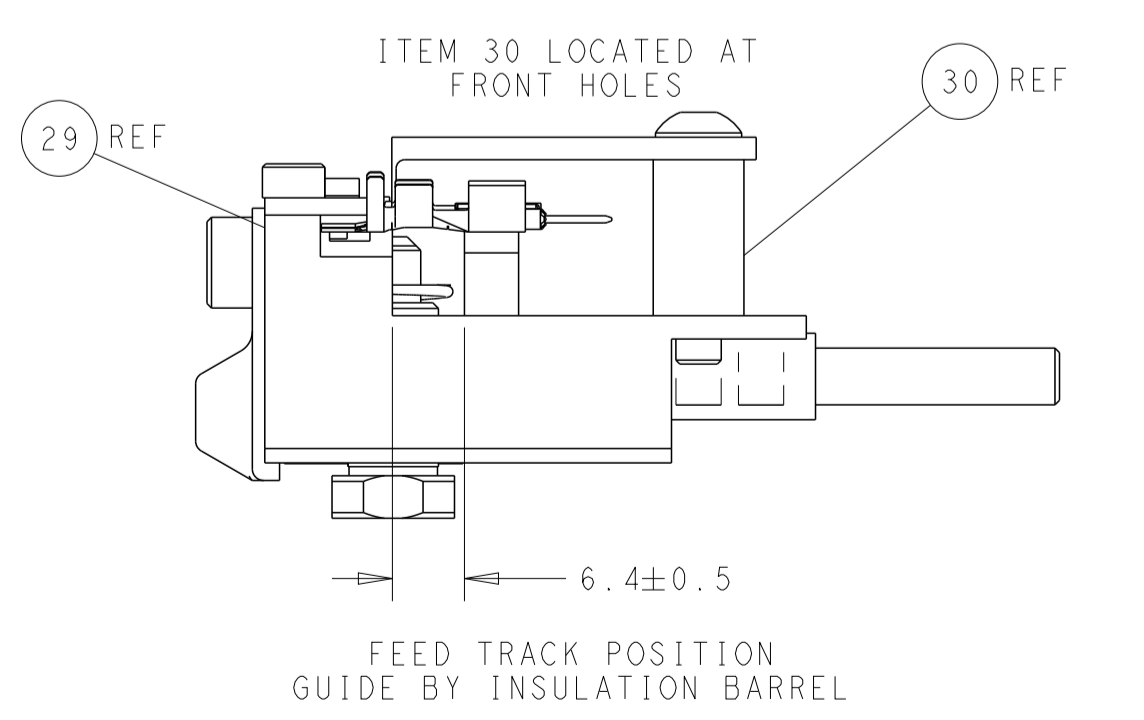
GROUP	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	POSITION
GROUP 1	2-928918-2 3-928918-2 5-928918-1 6-928918-1 6-928918-2 6-928918-3 1394702-1 1394702-2 5-1394702-1 5-1394702-2	POSITION 1
	928918-1 928918-2	POSITION 1
	968893-1	POSITION 1
	968220-1 1703296-1 1703296-5 1534116-1 1534116-2 5-968220-1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



RAM SET-UP



TERMINAL SUPPORT LOCATION



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: L. GROSS 02SEP2011		CHK: G. BAILEY 02SEP2011		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	SIZE: A1	CAGE CODE: 00779
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2	SHEET: 4	OF: 4	REV: J	Customer Accessible Production Drawing		