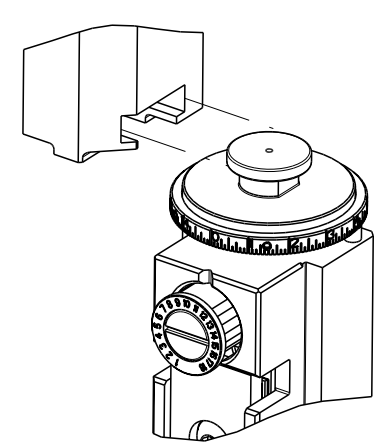


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151234-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151234-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151234-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151234-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	6.35 mm [.250]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER CONTACT TYPE A			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.40-5.00 mm [.173-.197 IN]		∅ 1.4-2.7mm	
TERMINAL APPLICATION SPECIFICATION		114-18037	-

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER CONTACT TYPE A			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.90-4.50 mm [.153-.177 IN]		∅ 1.4-2.7mm	
TERMINAL APPLICATION SPECIFICATION		114-18388	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	∅ 1.4-2.1mm
969040-1		963243-1		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	∅ 1.4-2.1mm
1241412-1	1241412-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.52+/-0.05 [1.060+/- .002]	7.6
0.75mm2	1.43+/-0.05 [1.056+/- .002]	8.5
0.50mm2	1.34+/-0.05 [1.053+/- .002]	9.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.54+/-0.05 [1.061+/- .002]	7.6
0.75mm2	1.47+/-0.05 [1.058+/- .002]	8.5
0.50mm2	1.43+/-0.05 [1.056+/- .002]	9.6

- 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.
 - TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
 - TERMINAL LUBRICANT IS RECOMMENDED.
8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***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	#	LY#	DESCRIPTION	DATE	OWN	APVD
		D		ECR-18-013514	24AUG2018	FZ	KZ
		E		ECR-18-018975	04DEC2018	FJ	KZ
		F		ECR-19-005517	05APR2019	LG	TE
		F1		ECR-20-014998	21OCT2020	JWC	GB

-	-	1	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293	
-	-	1	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292	
-	1	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	1	2844940-1	AIR FEED MODULE	238	
-	-	1	-	4-1722335-3	STRIPPER, SIDE FEED	182	
-	-	1	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181	
	-	-	1	-	2-1752354-2	STANDOFF,HOLD-DOWN	180
-	-	1	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	-	1	-	5-22280-0	SPRING, COMPRESSION	176	
-	-	1	-	1752353-3	GUIDE PIN,HOLDDOWN	175	
-	-	1	-	1901680-2	GUIDE PIN,HOLDDOWN	174	
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	2119740-1	TAG,IDENTIFICATION	67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50	
-	1	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	-	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	-	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1-1752356-1	SUPPORT, TERMINAL	34	
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1320928-6	STRIP GUIDE	24	
-	1	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	1	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	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1-356885-4	STOP, SHEAR	11	
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
	-	1	1	318707-1	FLOATING SHEAR, FRONT	9	
	1	2	1	1	4-1333204-2	ANVIL, COMBINATION	8
-	1	1	1	2119781-1	DEPRESSOR, SHEAR	5	
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
	1	2	1	1	1633996-6	CRIMPER, INSULATION SPECIAL	3
	-	1	1	1	455888-9	SPACER, CRIMPER	2
	1	2	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1

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

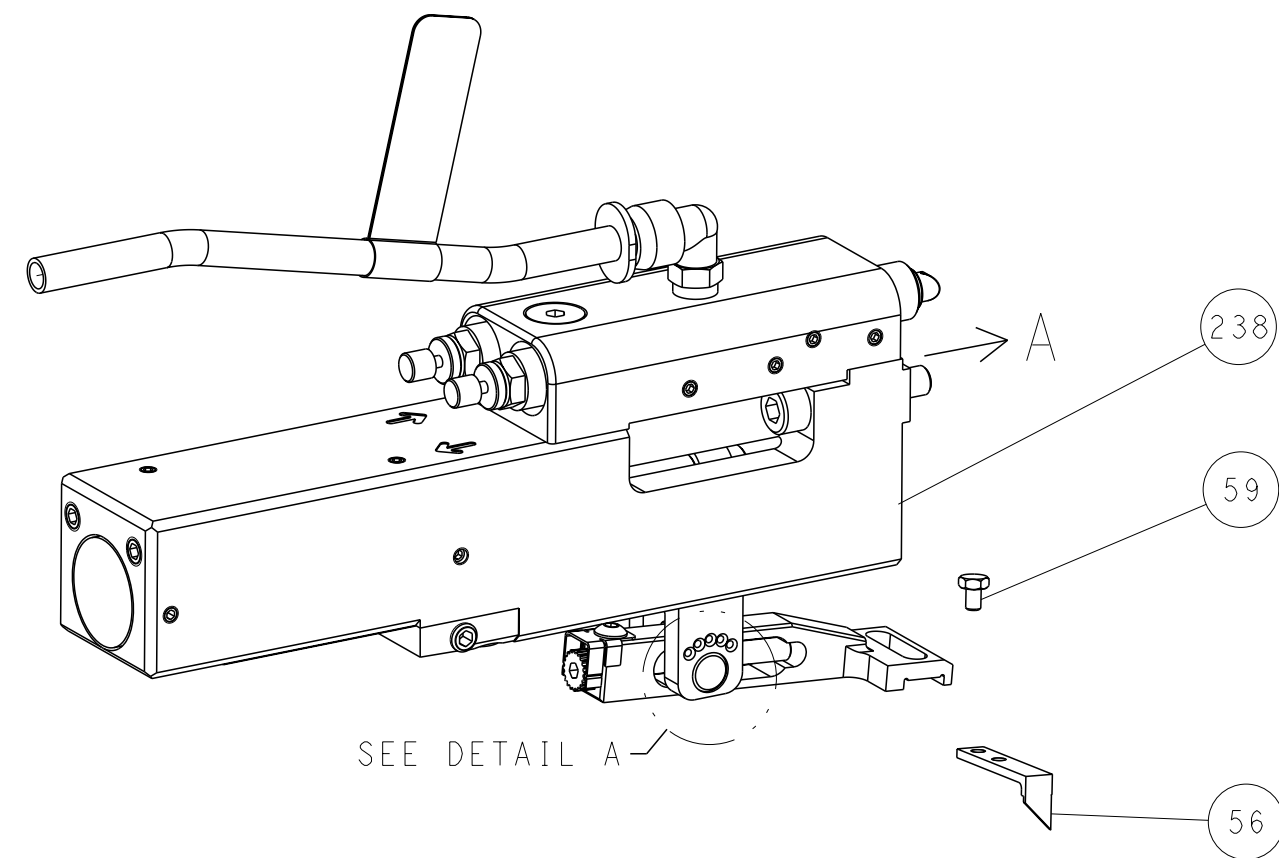
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-77	-72	-52	-2		

OWN	L. ZHANG	22SEP2011
CHK	L. ZHANG	22SEP2011
APVD	S. XI	22SEP2011
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151234
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 of 4
REV	F1	

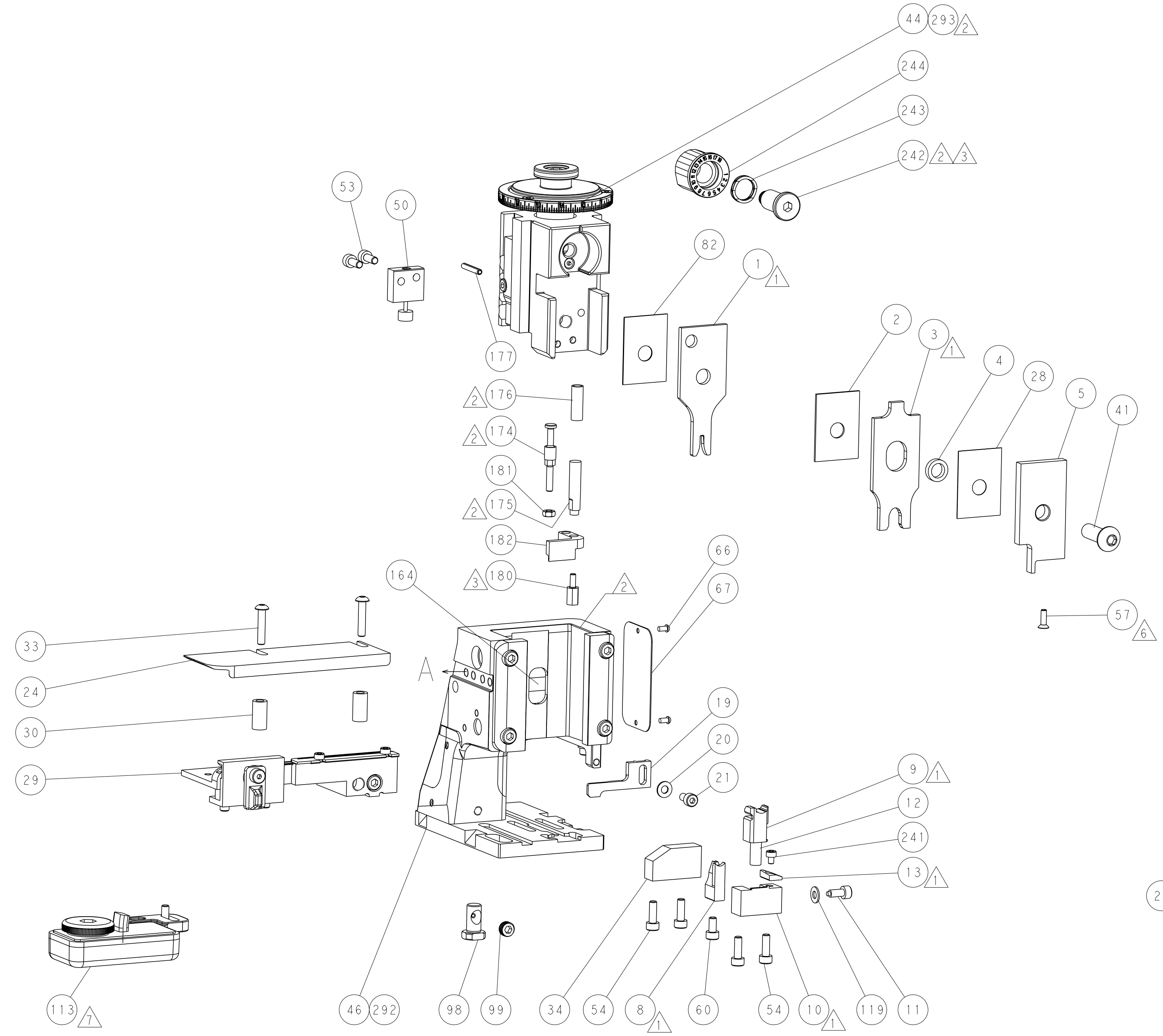
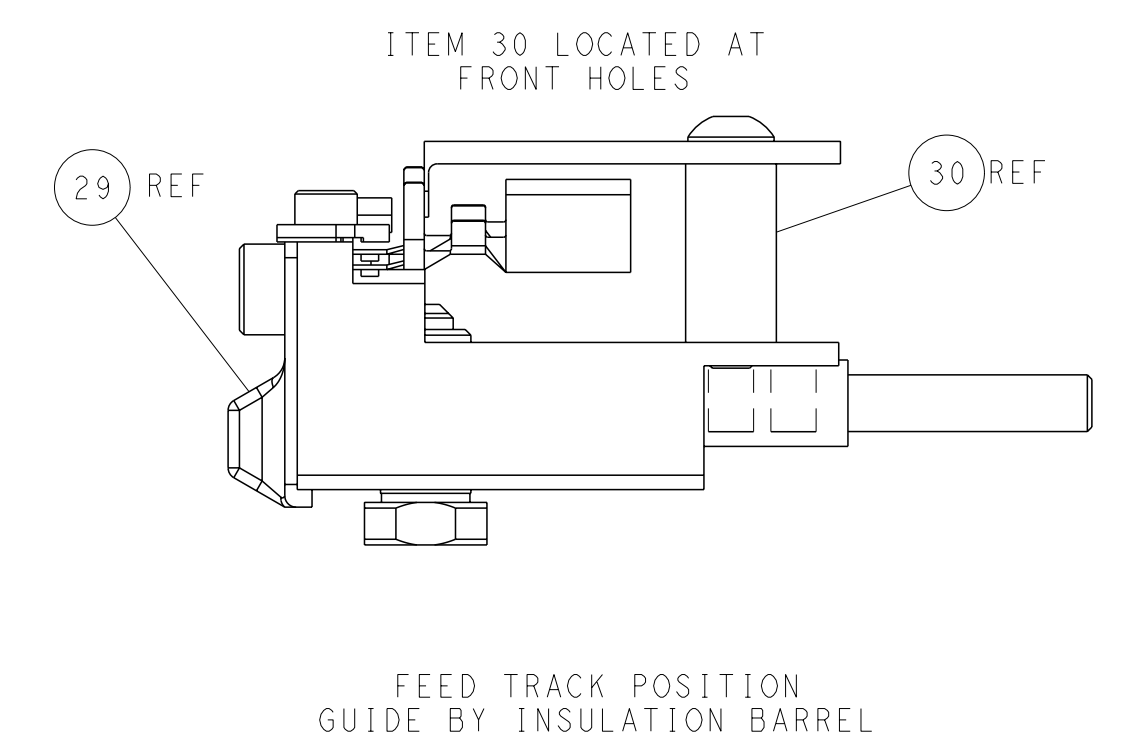
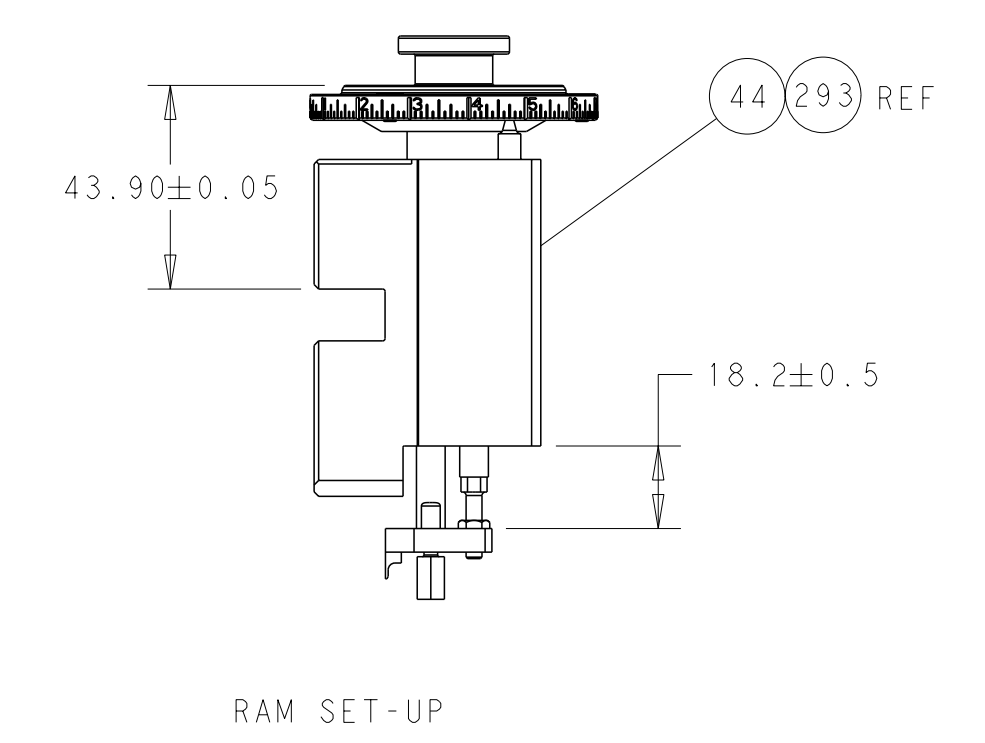
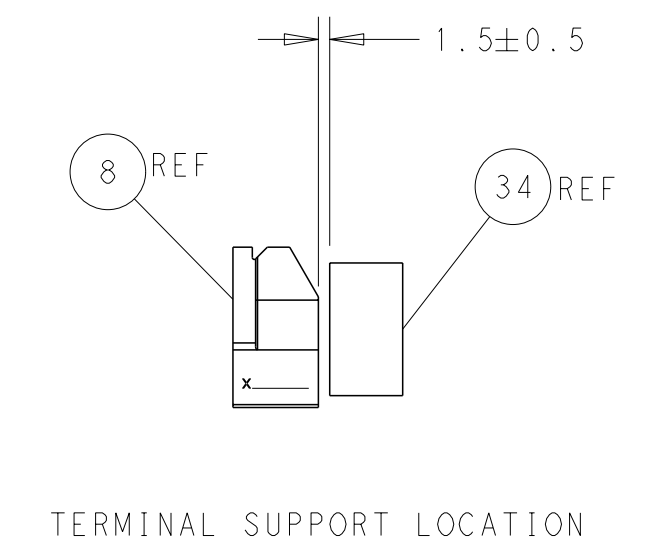
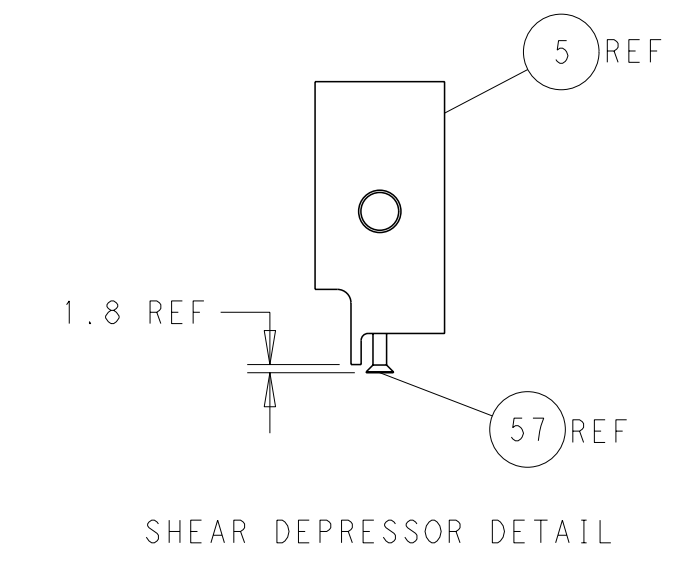
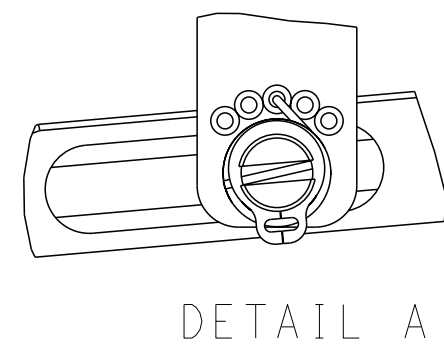
LOC	DIST	REVISIONS			
		REV	DATE	OWN	APVD
A	66	1	SEE SHEET 1	-	-

FEED TYPE

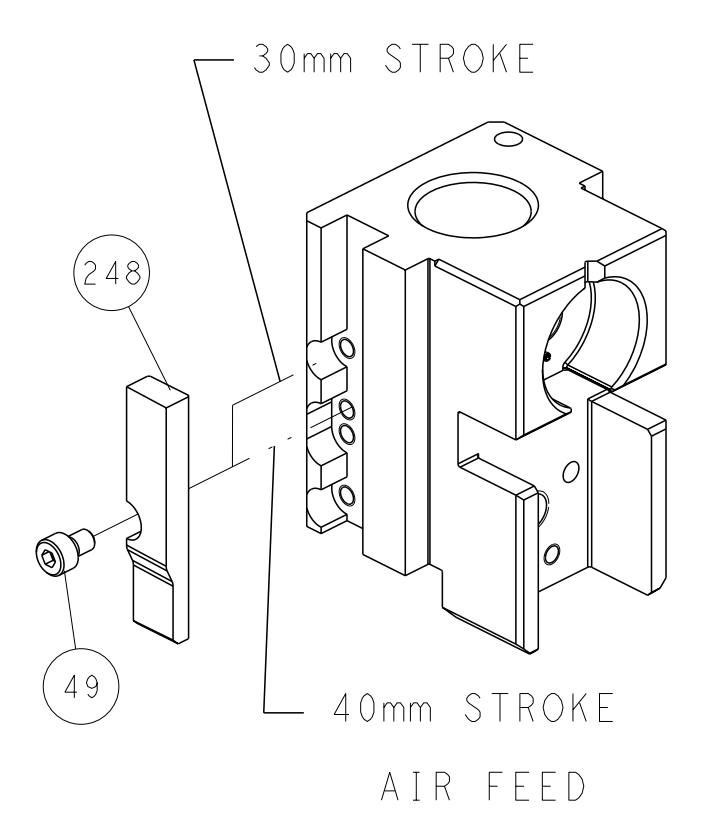
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION

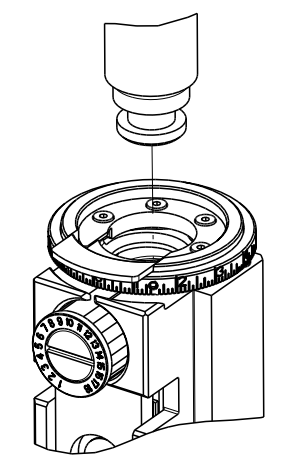


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN L. ZHANG 22SEP2011 CHK L. ZHANG 22SEP2011 APVD S. XI 22SEP2011	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 SIZE CAGE CODE DRAWING NO. A1 00779 ©=2151234 WEIGHT - SCALE 1:2 SHEET 2 of 4 REV 1	RESTRICTED TO
MATERIAL:		Customer Accessible Production Drawing	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151234-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151234-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	6.35 mm [.250]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER CONTACT TYPE A			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.40-5.00 mm [.173-.197 IN]		∅ 1.4-2.7mm	
TERMINAL APPLICATION SPECIFICATION	114-18037	-	-

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER CONTACT TYPE A			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.90-4.50 mm [.153-.177 IN]		∅ 1.4-2.7mm	
TERMINAL APPLICATION SPECIFICATION	114-18388	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	∅ 1.4-2.1mm
969040-1			963243-1	

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	∅ 1.4-2.1mm
1241412-1	1241412-3		963243-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.52+/-0.05 [.060+/- .002]	7.6
0.75mm2	1.43+/-0.05 [.056+/- .002]	8.5
0.50mm2	1.34+/-0.05 [.053+/- .002]	9.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.54+/-0.05 [.061+/- .002]	7.6
0.75mm2	1.47+/-0.05 [.058+/- .002]	8.5
0.50mm2	1.43+/-0.05 [.056+/- .002]	9.6

- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - 6 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
 - 7 TERMINAL LUBRICANT IS RECOMMENDED.
8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***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)

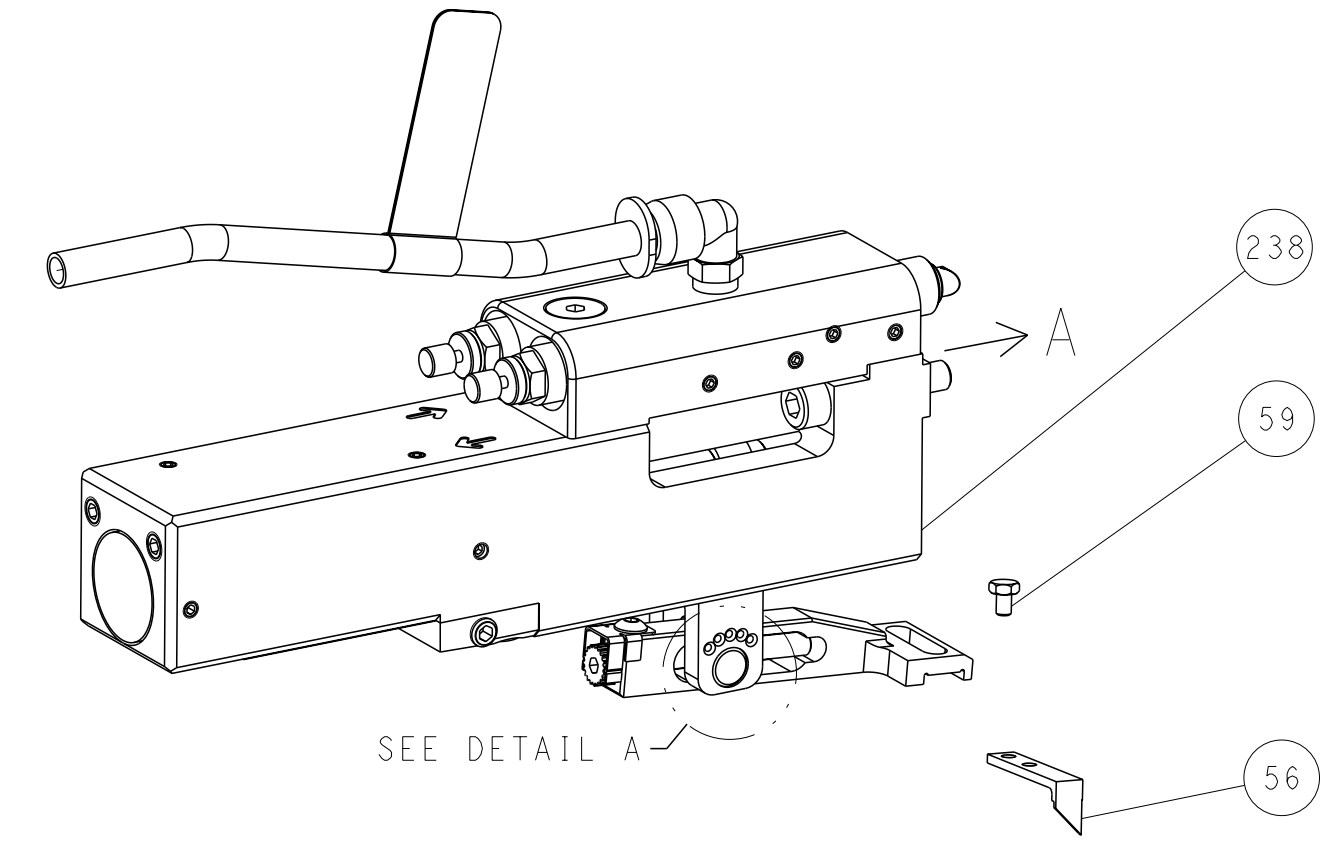
LOC	DIST	REVISIONS					
A	66	P	LYH	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-1	AIR FEED MODULE	238
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1338685-1	PAWL, FEED	56
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1-1752356-1	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	1	1320928-6	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	4-1333204-2	ANVIL, COMBINATION	8
-	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1633996-6	CRIMPER, INSULATION SPECIAL	3
-	1	455888-9	SPACER, CRIMPER	2
1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
-77	-22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	L. ZHANG	22SEP2011	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	CHK	L. ZHANG	22SEP2011	
MATERIAL:		FINISH:		APVD	S. XI	22SEP2011	NAME
				PRODUCT SPEC		Ocean Side Feed Applicator	
				APPLICATION SPEC		SIZE	
				WEIGHT		CAGE CODE DRAWING NO	
				A1		00779 C=2151234	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 of 4 REV F1	

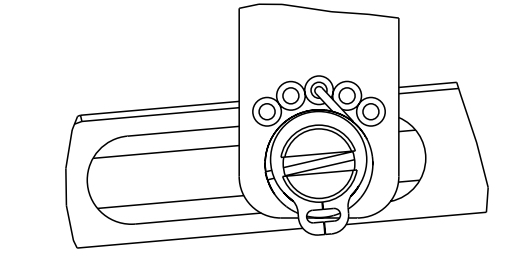
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC

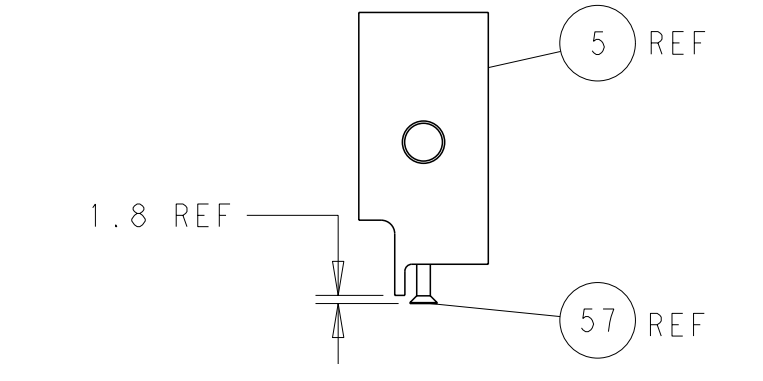


SEE DETAIL A

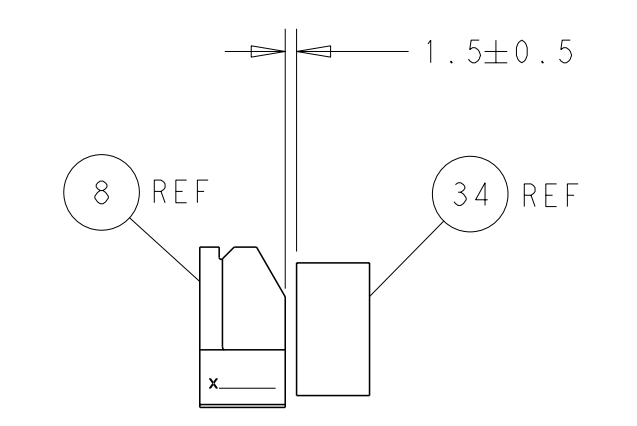
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



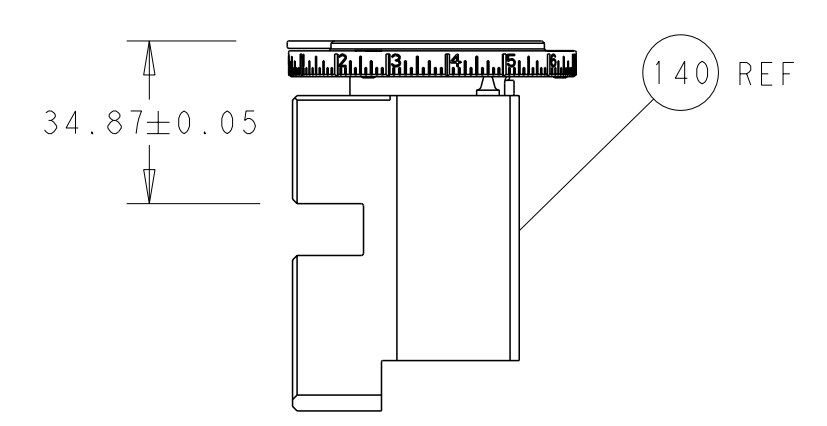
DETAIL A



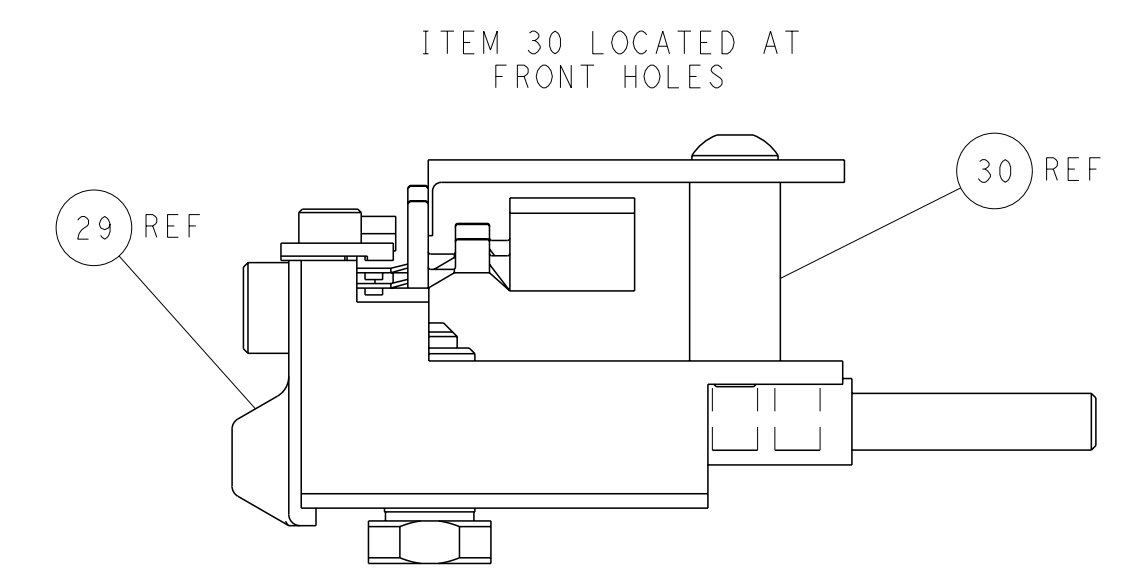
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

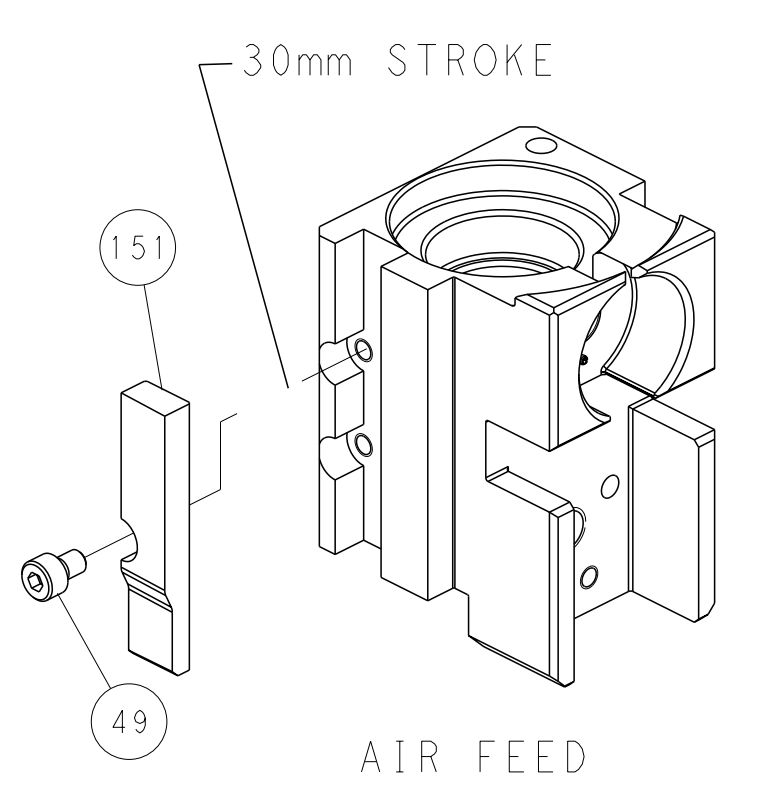


RAM SET-UP

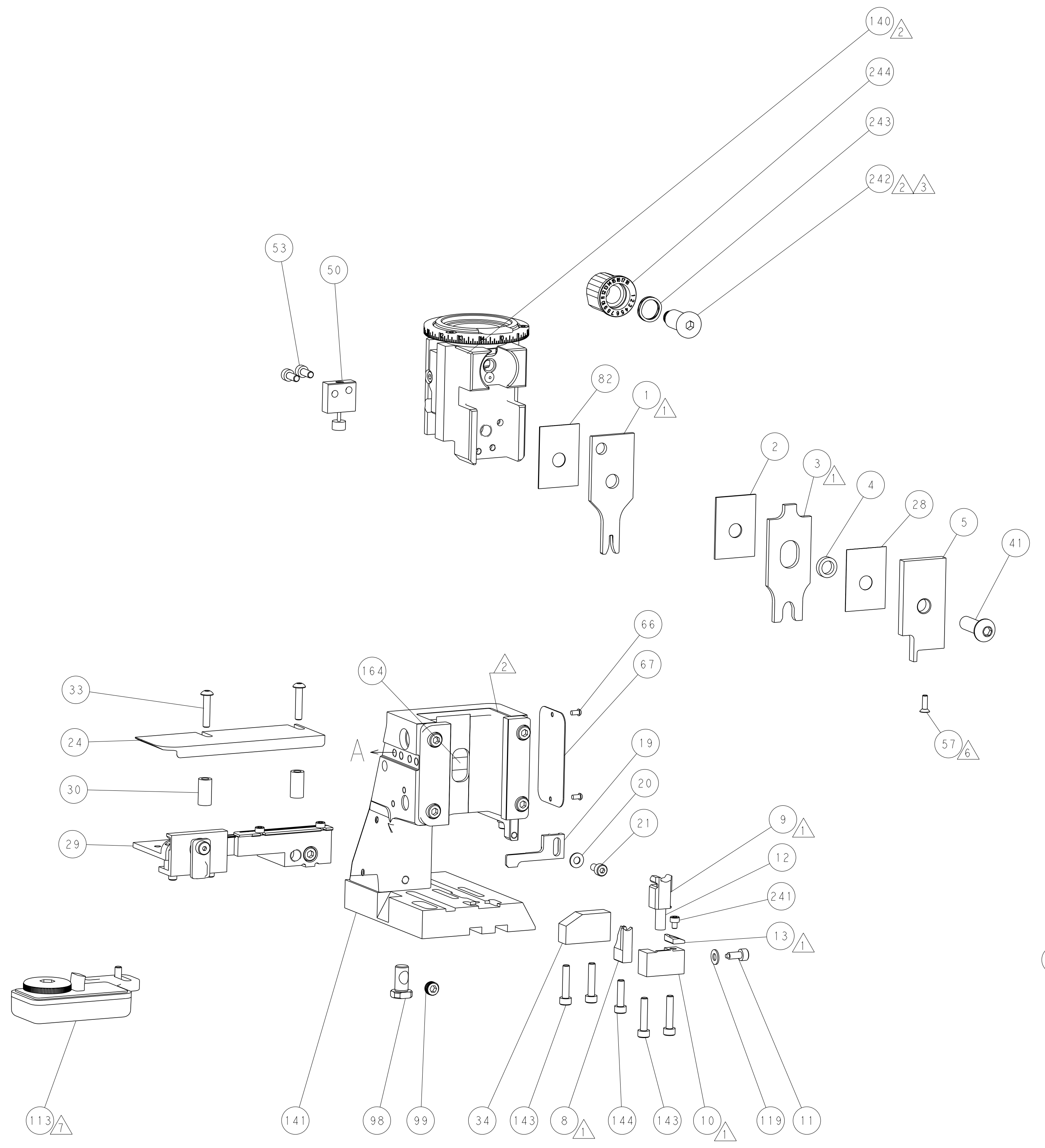


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITION



AIR FEED



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 UNPUBLISHED. RELEASED FOR PUBLICATION 20. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO VERIFY DIMENSIONS AND TOLERANCES. DIMENSIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: L. ZHANG CHK: L. ZHANG APVD: S. XI PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	DATE: 22SEP2011 NAME: Ocean Side Feed Applicator SIZE: A1 SCALE: 1:2 SHEET: 4 of 4 REV: F1	TE Connectivity Harrisburg, PA 17105-3608
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