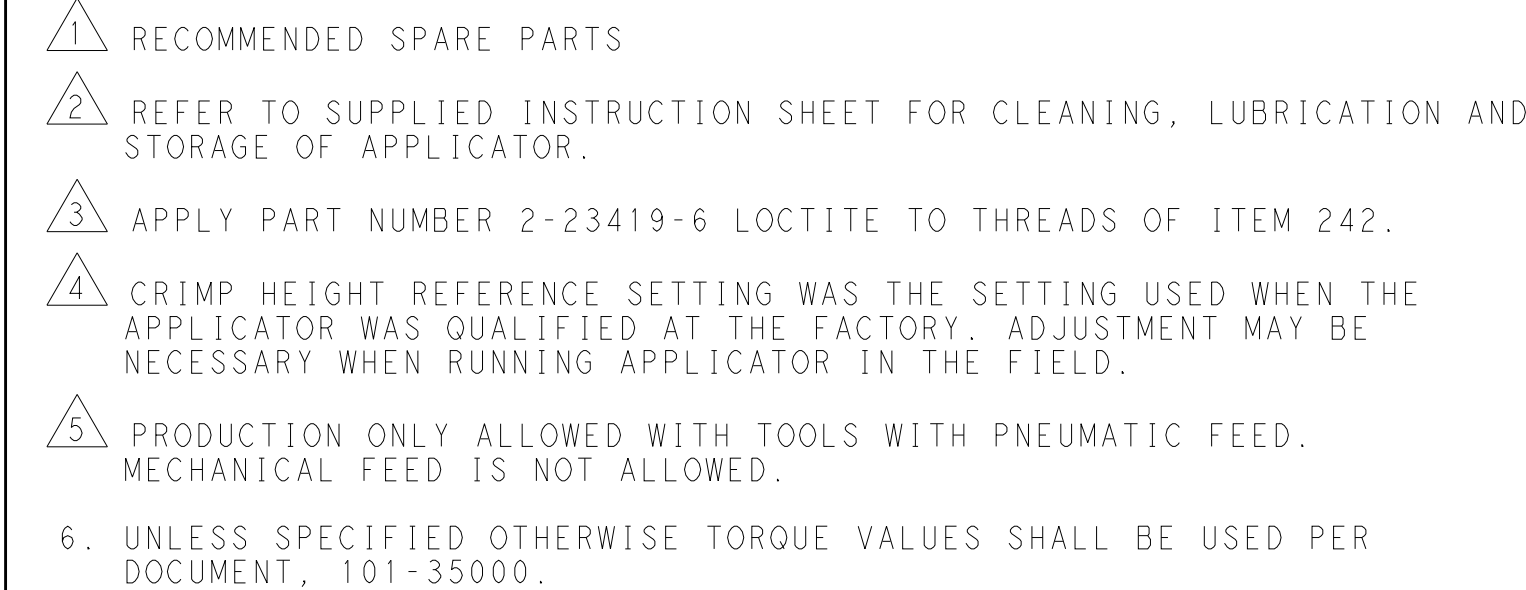


WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.35mm2		0.78+/-0.02 [0.031+/-0.001]		9.2
0.22mm2		0.70+/-0.02 [0.028+/-0.001]		10.4



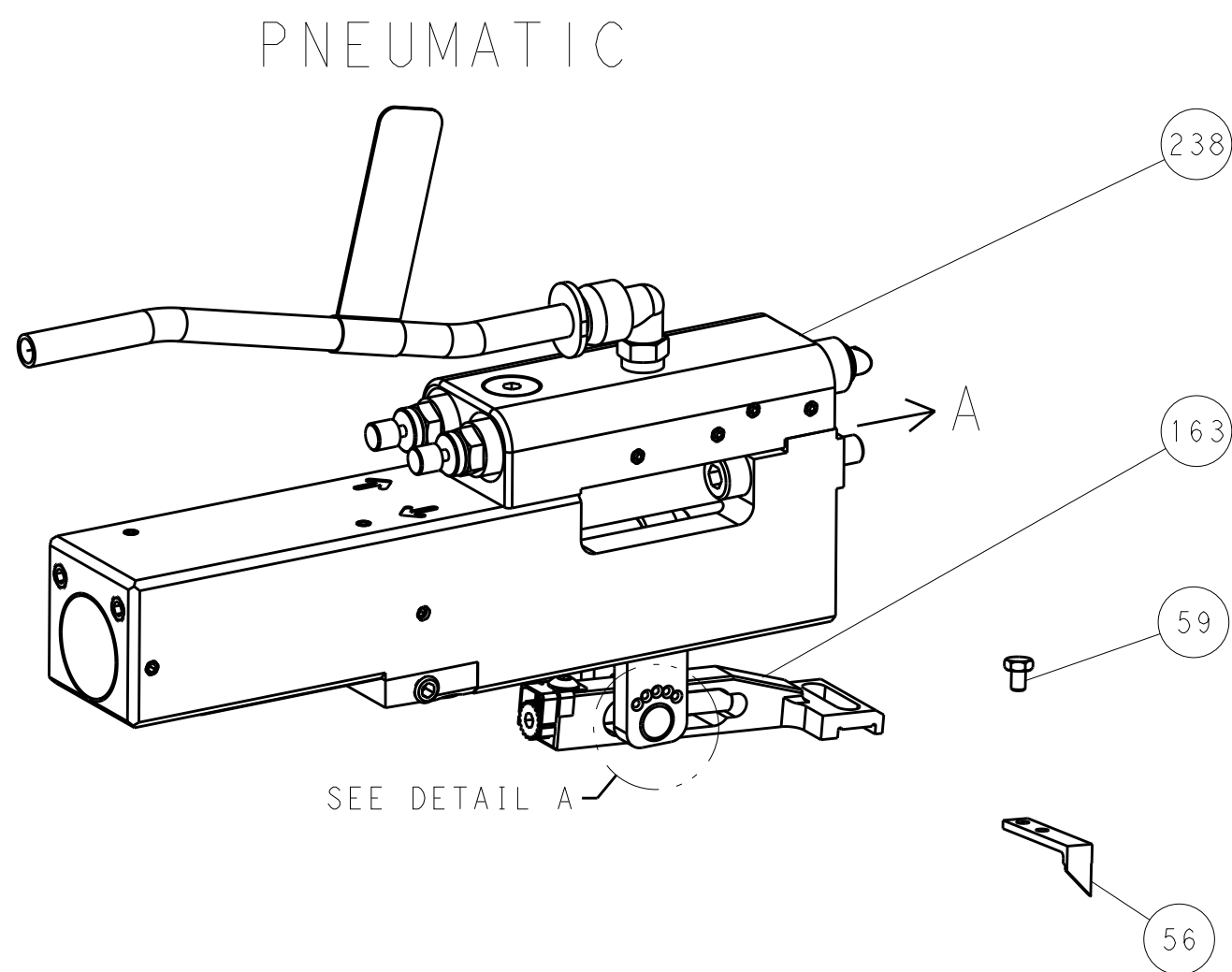
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	98
	-	1	1	1-690438-0	FRONT STRIP GUIDE	95
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1338685-1	PAWL, FEED	56
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	690753-2	SPACER, TONKER	50
	-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	36
	-	1	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	31
	-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844938-1	PLATE, STRIP GUIDE	29
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1803142-1	DRAG, TERMINAL	25
	-	1	1	1320928-2	STRIP GUIDE	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	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1803095-7	FLOATING SHEAR, FRONT -	9
1	2	1	1	1-1633620-2	ANVIL, COMBINATION	8
	-	1	1	240641-7	SPACER	7
	-	-	-	-	-	6
	-	1	1	2119757-1	DEPRESSOR, SHEAR	5
	-	1	1	5-238011-7	BLOCK, CRIMPER SPACER	4
1	1	2	1	1803143-2	CRIMPER, INSULATION O	3
	-	-	-	-	-	2
1	1	2	1	2-1333281-7	CRIMPER, WIRE PREMIUM	1
-77	-72	2		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A COMPUTER GENERATED FILE. ALL DIMENSIONS ARE TO BE VERIFIED BY THE CUSTOMER. THE CUSTOMER IS RESPONSIBLE FOR THE ACCURACY OF THE DIMENSIONS. THE CUSTOMER IS RESPONSIBLE FOR THE ACCURACY OF THE DIMENSIONS.		DWN 09MAY2013 BOB HIGMAN		 TE Connectivity	
CHG 09MAY2013 G. BAILEY		CHG 09MAY2013 M. CLIFFORD		Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ±.0005 1 PLC ±.0005 2 PLC ±.0005 3 PLC ±.0005 4 PLC ±.0005		Ocean Side Feed Applicator	
		APPLICATION SPEC		PRODUCT SPEC	
MATERIAL		WEIGHT		SIZE, CASE CODE, DRAWING NO.	
-		-		A 00779 C=2151523	
FINISH		RESTRICTED TO		SCALE 1:2 SHEET 1 OF 4 REV H	
-		-		Customer Accessible Production Drawing	

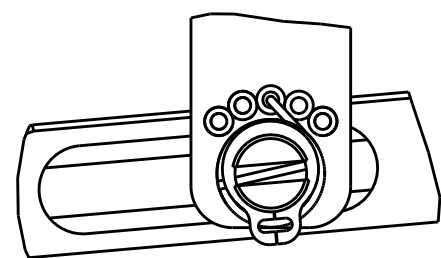
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

FEED TYPE

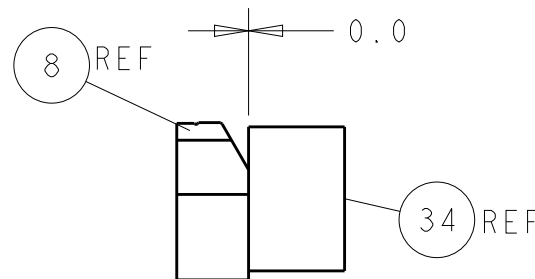
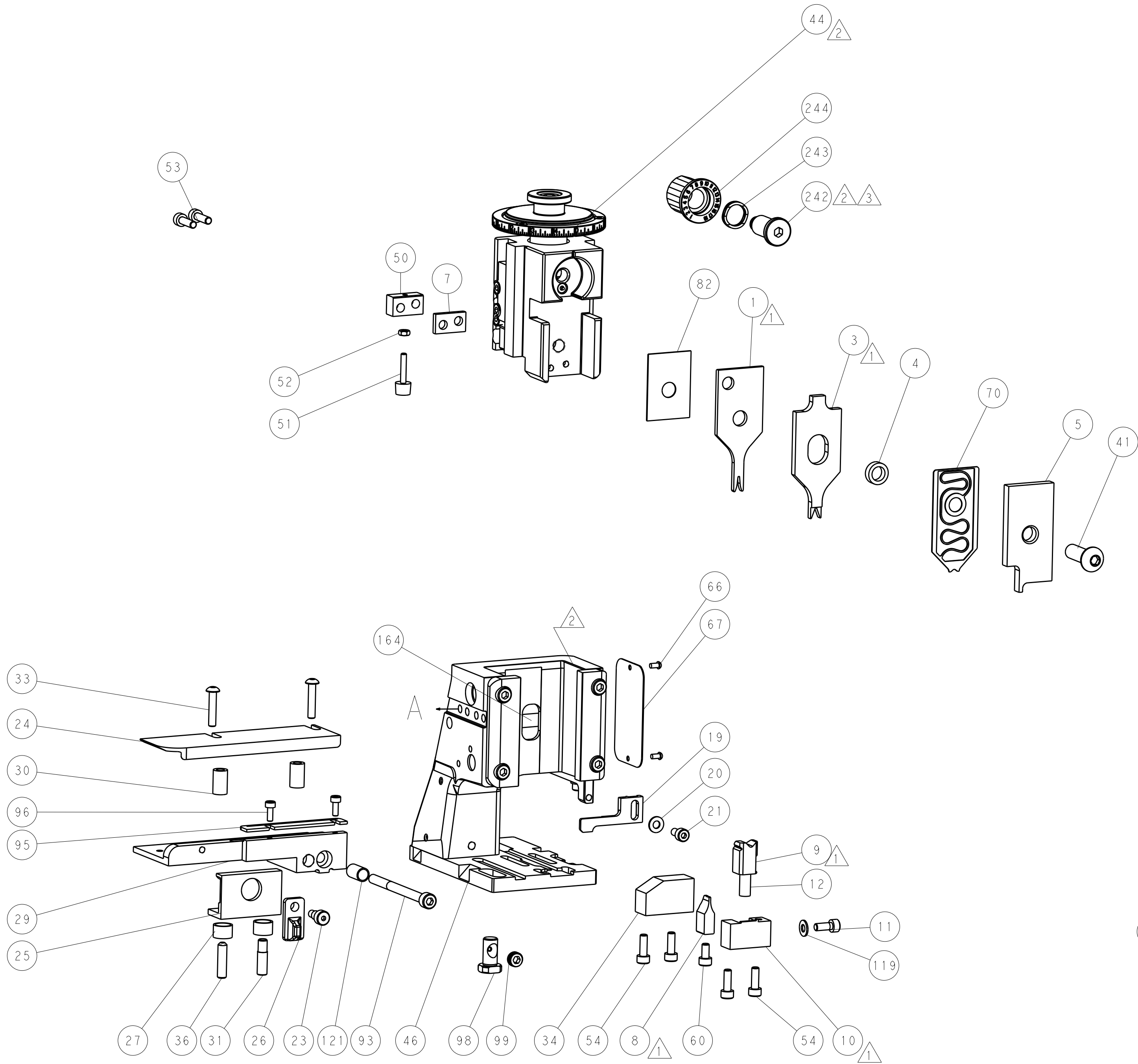
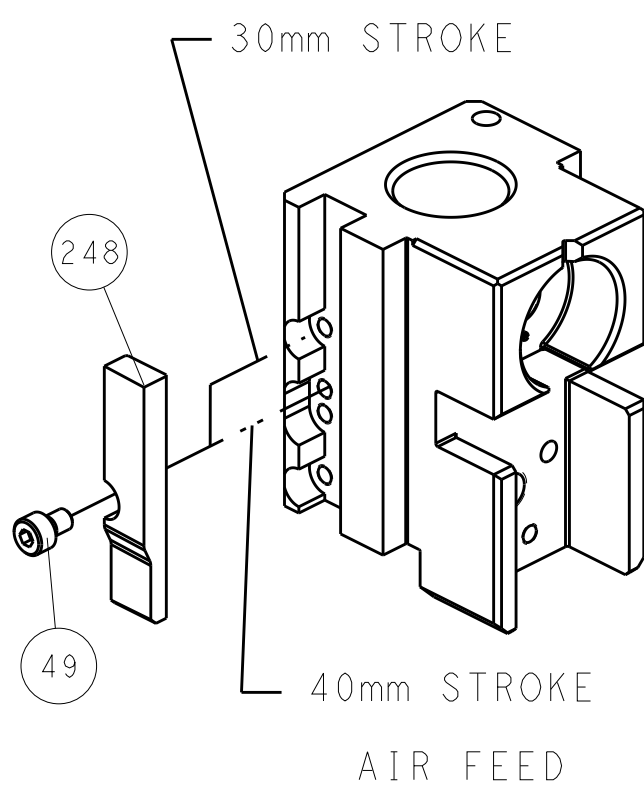


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

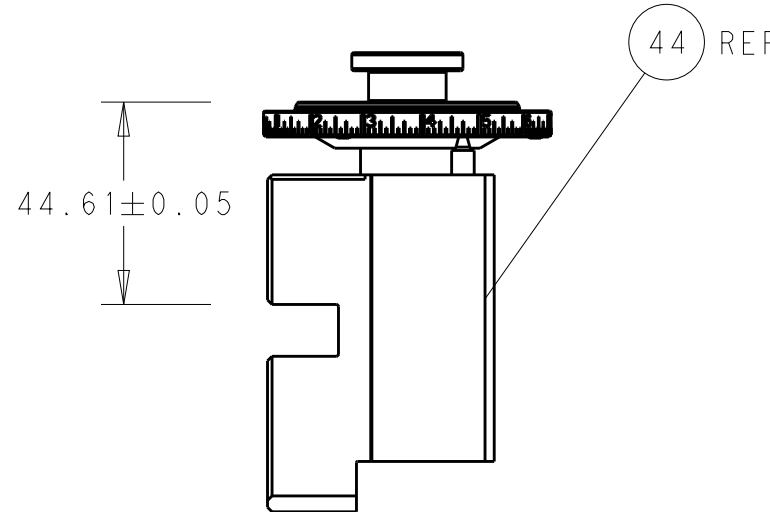


DETAIL A

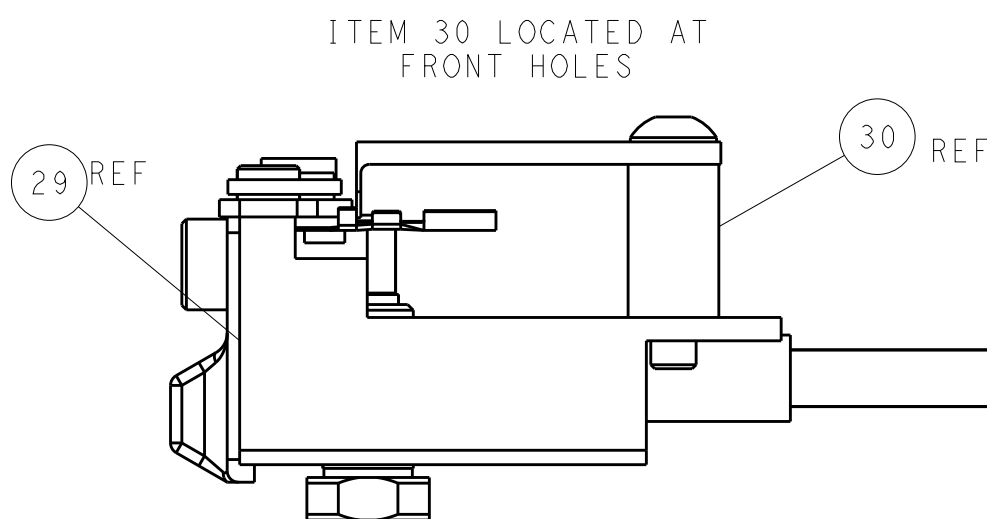
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



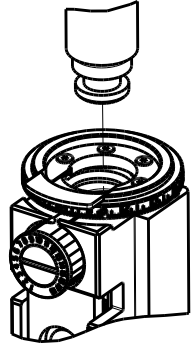
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

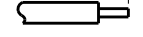
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN: BOB HIGMAN 09MAY2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK: G.BAILEY 09MAY2013	NAME: Ocean Side Feed Applicator	
mm		APVD: M.CLIFFORD 09MAY2013	SIZE: A1	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	CAGE CODE: 00779	
0 PLC ±.0		APPLICATION SPEC	DRAWING NO: 2151523	
1 PLC ±.0		WEIGHT	SCALE: 1:2	
2 PLC ±.0		Customer Accessible Production Drawing	SHEET 2 OF 4	
3 PLC ±.0			REV H	
4 PLC ±.0				
ANGLES ±.0				
FINISH				

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151523-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151523-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.07 mm [.042]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO MQS TERMINAL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.25-3.55mm [.128-.140 IN]			Ø 0.95-1.20mm [.037-.047 IN]
TERMINAL APPLICATION SPECIFICATION		(A)114-18858	
			
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-1703930-1	2-1703930-2	2-1703930-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.78+/-0.02 [.031+/- .001]	9.2
0.22mm2	0.70+/-0.02 [.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 PRODUCTION ONLY ALLOWED WITH TOOLS WITH PNEUMATIC FEED. MECHANICAL FEED IS NOT ALLOWED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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	LTR	DESCRIPTION	DATE
					-	SEE SHEET 1	-

-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL
-	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
-	1	1-690438-0	FRONT STRIP GUIDE	95
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119791-9	DEPRESSOR, WIRE	70
-	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	1338685-1	PAWL, FEED	56
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	811242-5	BUMPER, HOLD DOWN	51
-	1	690753-2	SPACER, TONKER	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	36
-	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	31
-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844938-1	PLATE, STRIP GUIDE	29
-	2	22283-1	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1803142-1	DRAG, TERMINAL	25
-	1	1320928-2	STRIP GUIDE	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	3-22280-3	SPRING, COMPRESSION	12
-	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
1	-	1	2119805-1	SHEAR HOLDER, FRONT
1	-	1	1803095-7	FLOATING SHEAR, FRONT -
1	1	1	1-1633620-2	ANVIL, COMBINATION
-	1	1	240641-7	SPACER
-	-	-	-	6
-	1	1	2119757-1	DEPRESSOR, SHEAR
-	1	1	5-238011-7	BLOCK, CRIMPER SPACER
1	1	1	1803143-2	CRIMPER, INSULATION O
-	-	-	-	2
1	1	1	2-1333281-7	CRIMPER, WIRE PREMIUM
-	-	-	-	1

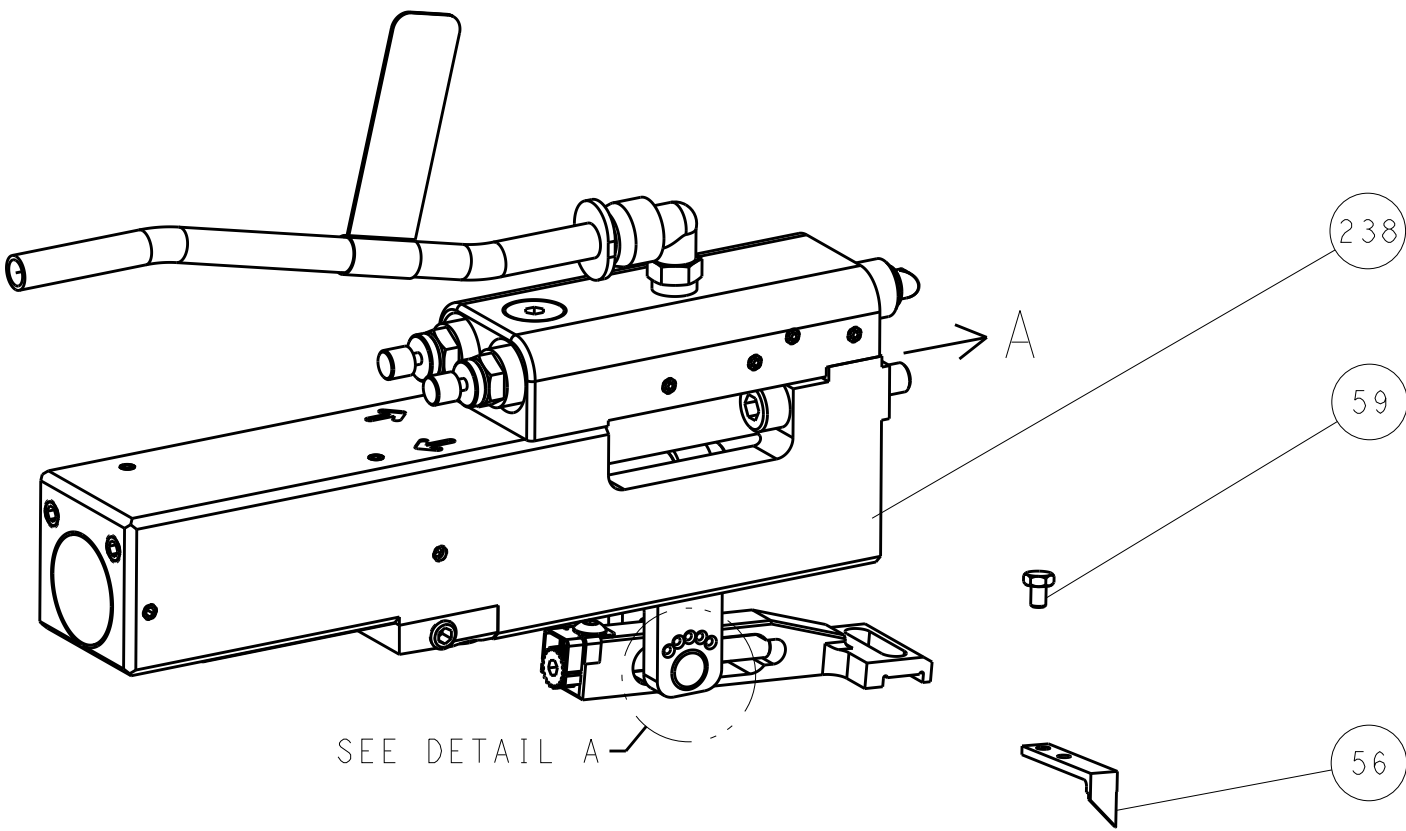
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN	09MAY2013	TE Connectivity	
DIMENSIONS:		CHK	09MAY2013	Harrisburg, PA 17105-3608	
mm		APVD	09MAY2013	NAME	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		Ocean Side Feed Applicator	
0 PLC ±		APPLICATION SPEC		-	
1 PLC ±		WEIGHT		SIZE	
2 PLC ±		MATERIAL		CAGE CODE	
3 PLC ±		FINISH		DRAWING NO	
4 PLC ±		RESTRICTED TO		00779	
ANGLES		Customer Accessible Production Drawing		SCALE	
FINISH		1:2		SHEET	
-		3		OF	
-		4		REV	
-		H			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

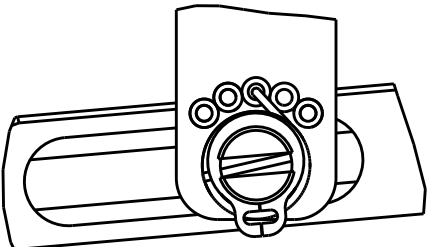
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-		SEE SHEET 1	-	-	-

FEED TYPE

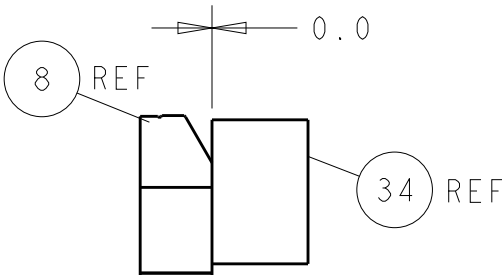
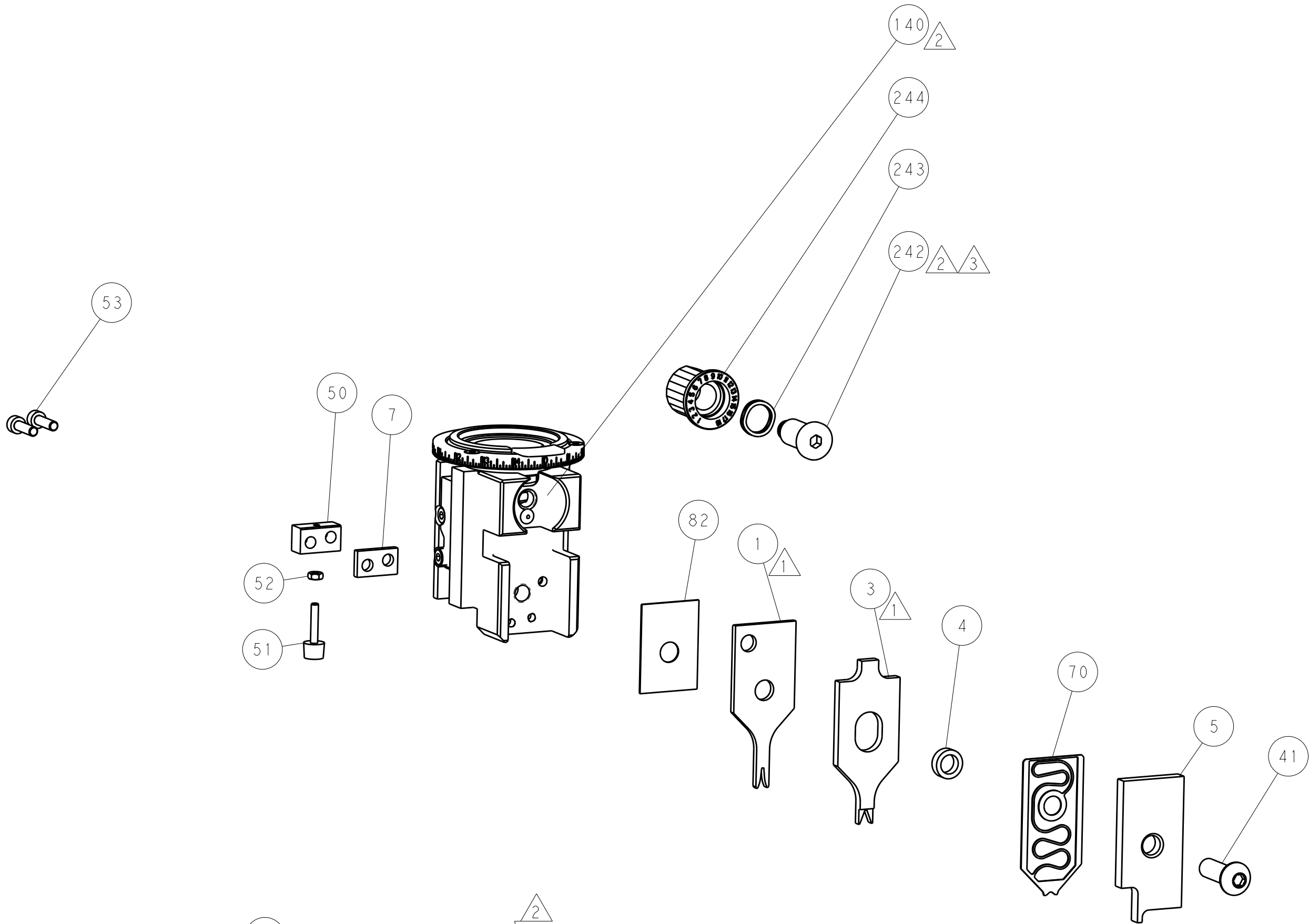
PNEUMATIC



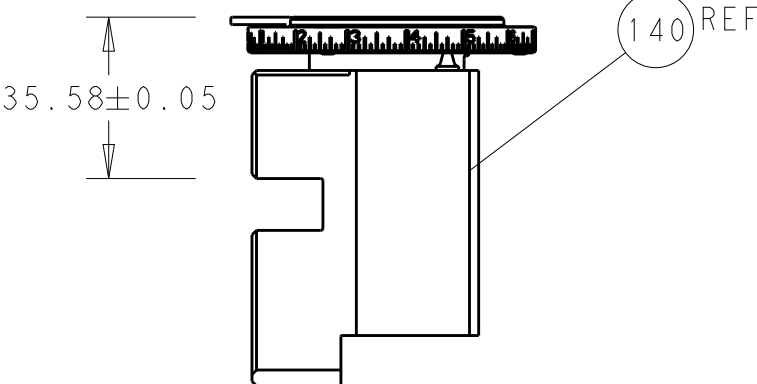
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

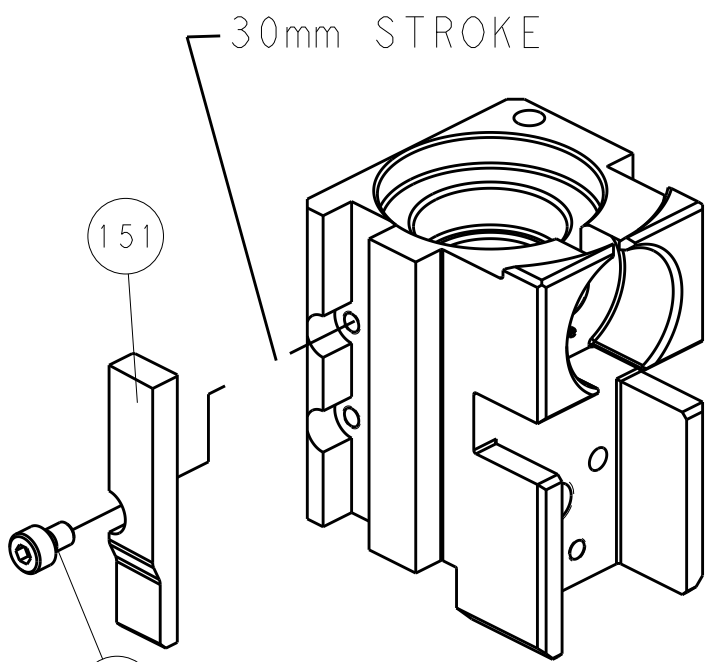


TERMINAL SUPPORT LOCATION

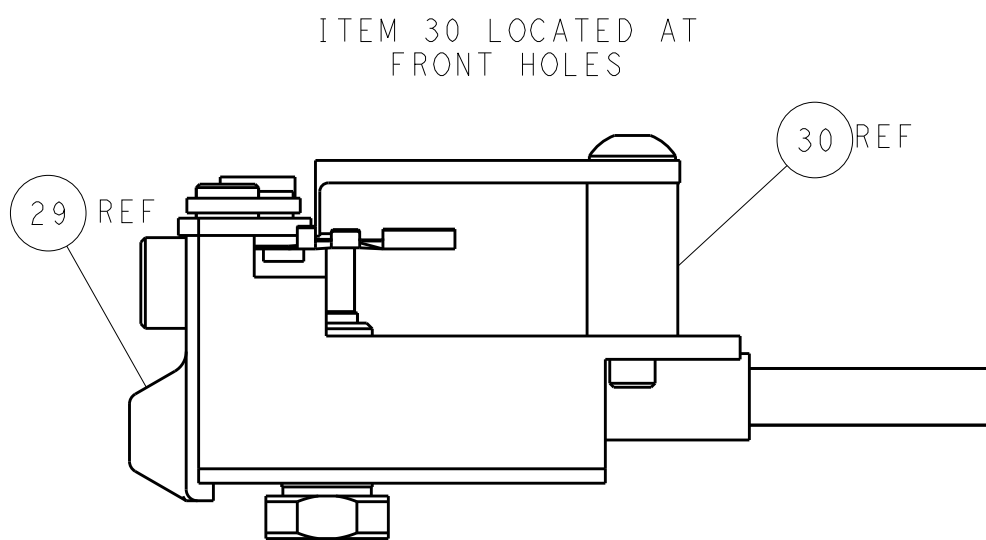
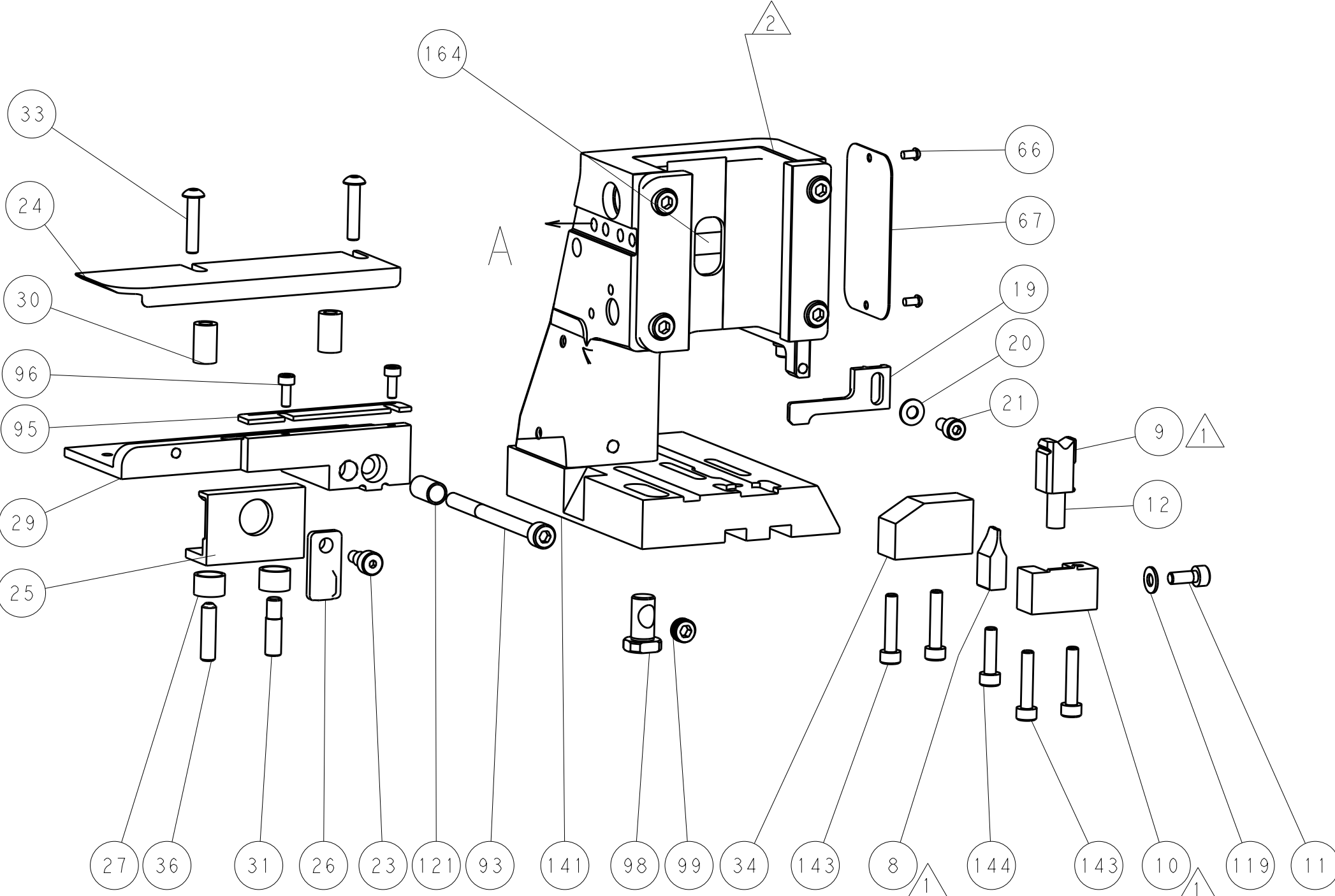


RAM SET-UP

CAM POSITION



AIR FEED



FEED TRACK POSITION
GUIDE BY INUSLATION 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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN: BOB HIGMAN 09MAY2013	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK: G. BAILEY 09MAY2013		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: M. CLIFFORD 09MAY2013	NAME: Ocean Side Feed Applicator	
0 PLC ±		PRODUCT SPEC	SIZE: CAGE CODE: DRAWING NO: 00779 ©=2151523	
1 PLC ±		APPLICATION SPEC	RESTRICTED TO	
2 PLC ±		WEIGHT	Customer Accessible Production Drawing	
3 PLC ±		SCALE: 1:2	SHEET 4 OF 4	
4 PLC ±		REV: H		
ANGLES FINISH				