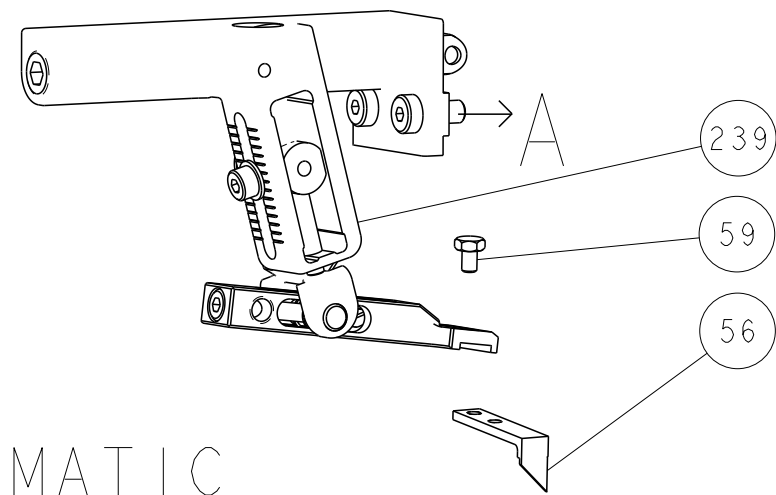


	-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
	-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
	-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	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	18
	-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	18
3	-	-	-	1	1	-	-	1-1752354-6	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	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
	-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	-	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
△	-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
△	-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
△	-	1	1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT -	9
△	1	2	2	1	1	1	1	8-1333201-3	ANVIL, COMBINATION	8
	-	1	1	1	1	1	1	3-240641-7	SPACER	7
	-	1	1	1	1	1	1	1-2119757-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
△	1	2	2	1	1	1	1	2-1803223-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
△	1	2	2	1	1	1	1	3-456402-5	CRIMPER, WIRE PREMIUM	1

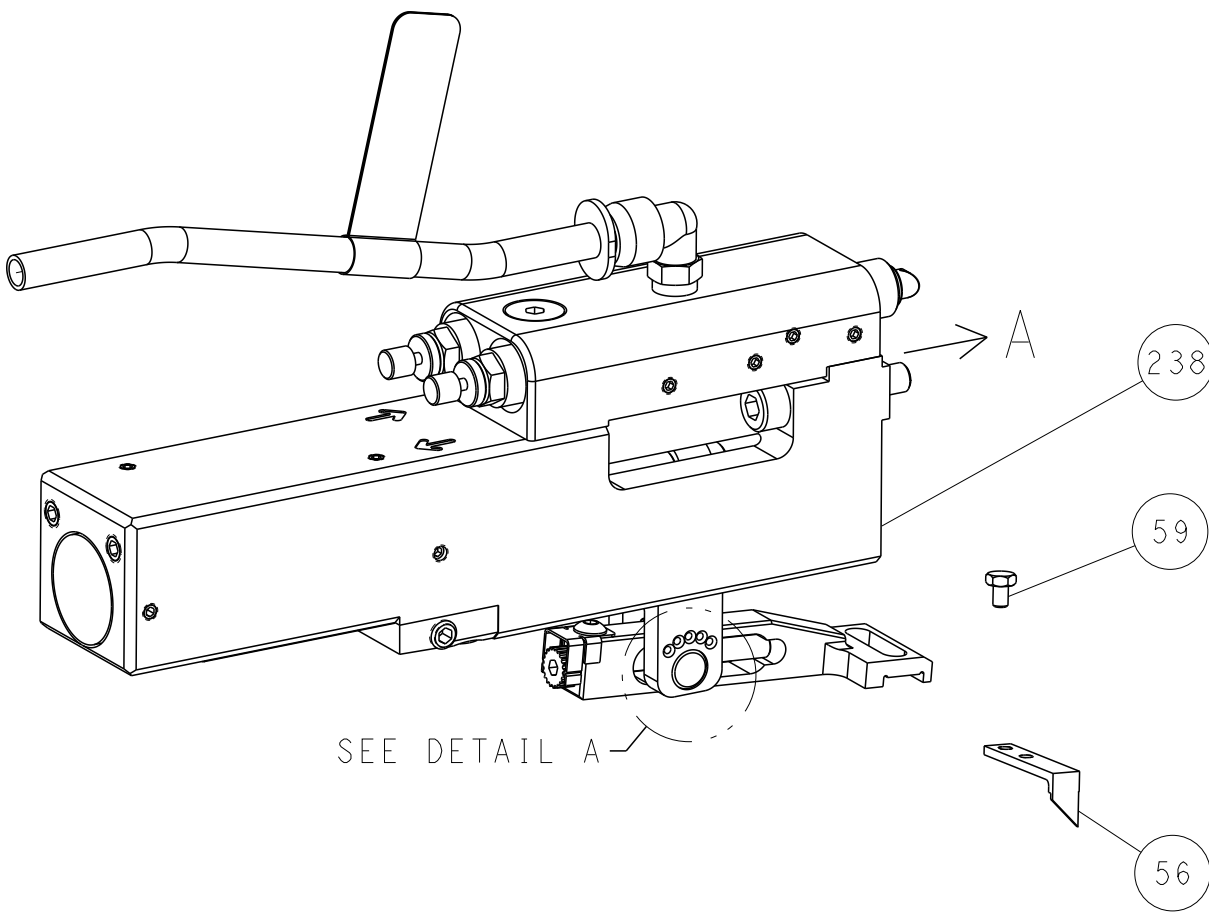
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

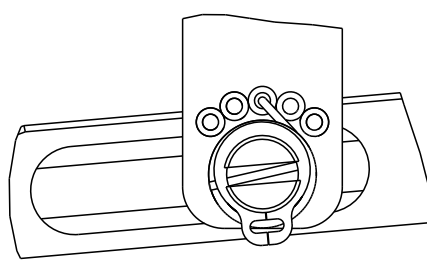
FEED TYPE
MECHANICAL



PNEUMATIC

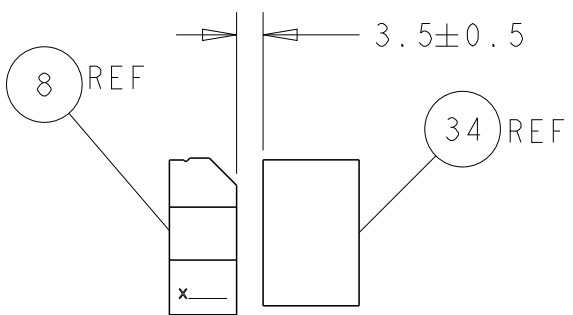
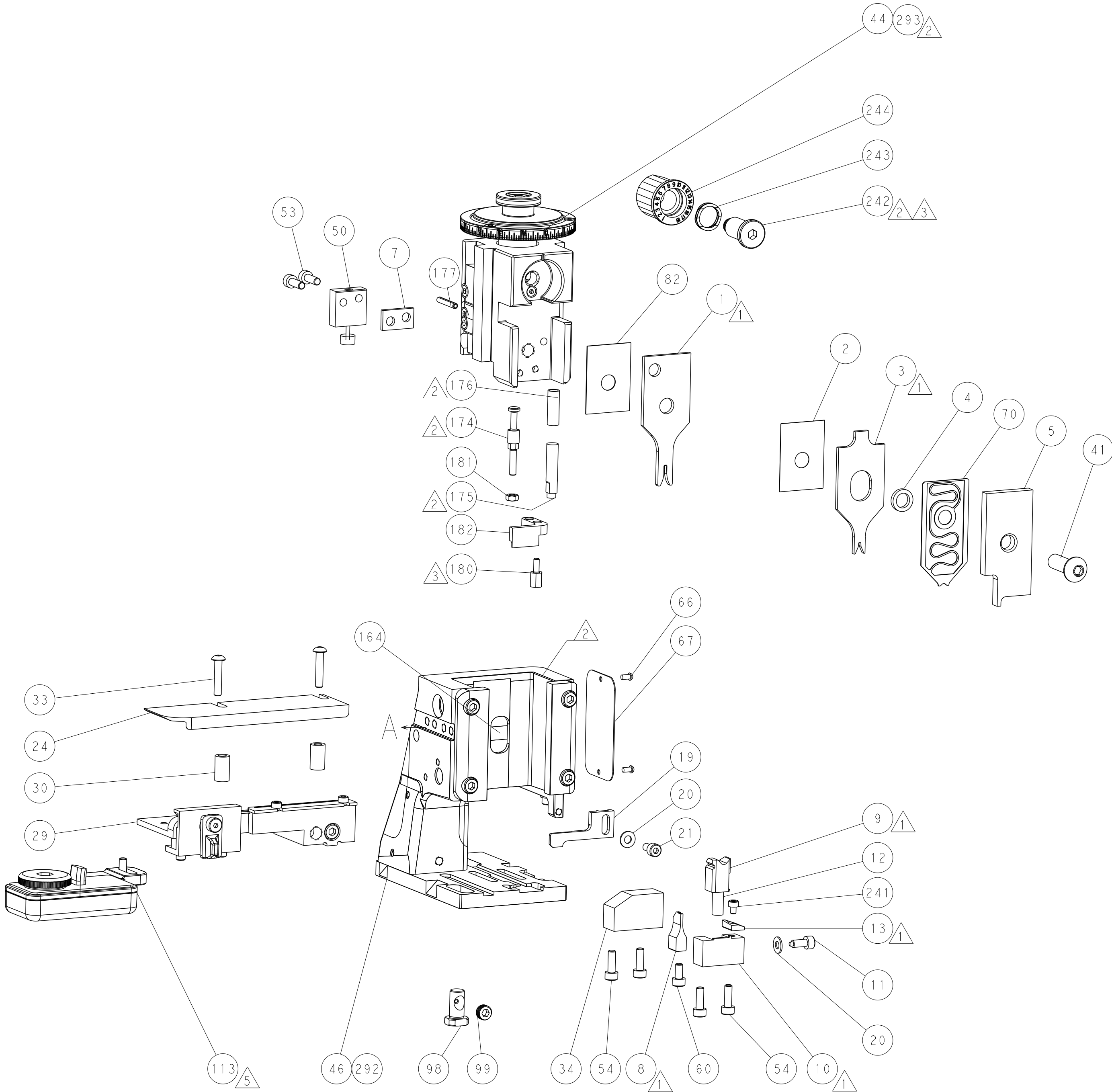
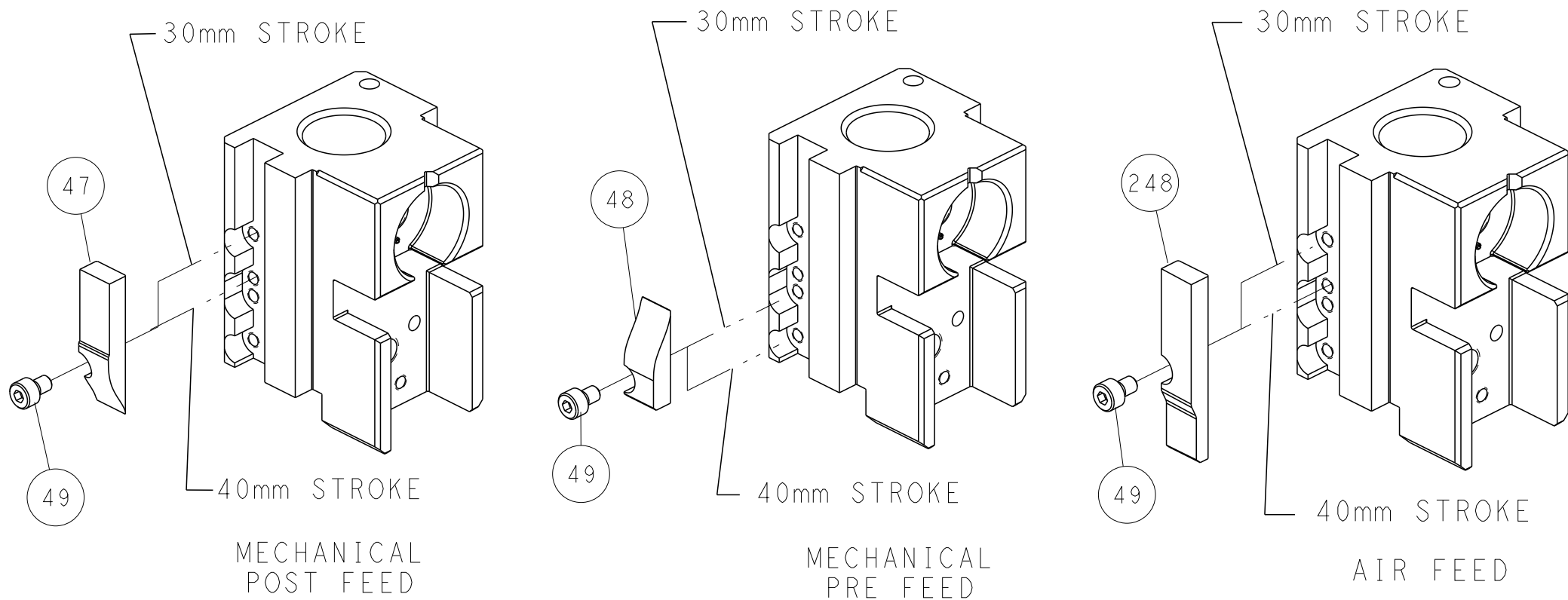


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

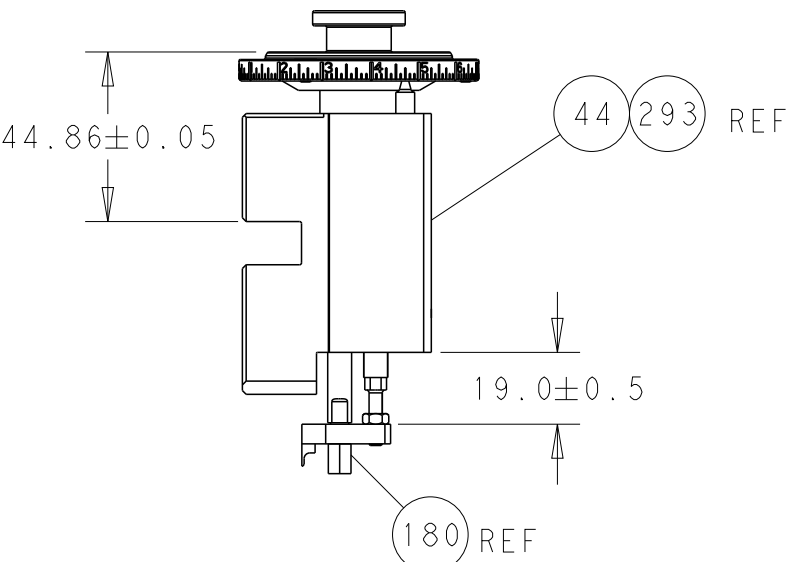


DETAIL A

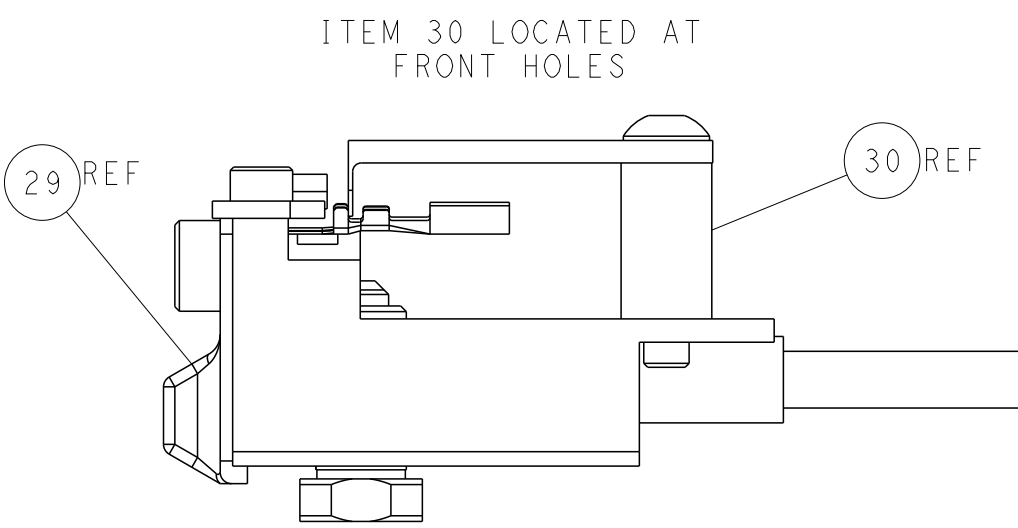
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLD DOWN 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)

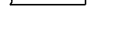
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.				DWN B. WEAVER 11OCT2011				TE Connectivity			
CHK G. HOFNER 11OCT2011				NAME				Harrisburg, PA 17105-3608			
APVD G. BAILEY 11OCT2011				PRODUCT SPEC				Ocean Side Feed			
APPLICATION SPEC				SIZE				A1			
WEIGHT				CAGE CODE				00779			
Customer Accessible Production Drawing				SCALE				1:2			
				SHEET				2 of 4			
				REV				P			

8		7	
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2011		2011	
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COPYRIGHT 2011			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151494-1	N	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151494-2	P	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151494-7	J	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 025 RECEPTACLE CONTACT			
WIRE STRIP LENGTH 3.00-3.50 mm [.118-.138 IN]			INSULATION DIAMETER RANGE Ø0.95-1.70 mm [.037-.067 IN]
TERMINAL APPLICATION SPECIFICATION 	(A)114-5250	-	-
	(B)114-5291	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1123343-1	(A) 1123343-2	(B) 1376109-1	(B) 1376109-2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 025 RECEPTACLE CONTACT			
WIRE STRIP LENGTH 3.00-3.50 mm [.118-.138 IN]		INSULATION DIAMETER RANGE Ø0.95-1.70 mm [.037-.067 IN]	
TERMINAL APPLICATION SPECIFICATION		(C) 114-5250-2	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 1674298-1	(C) 2005427-1		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 025 RECEPTACLE CONTACT			
WIRE STRIP LENGTH 3.00-3.50 mm [.118-.138 IN]			INSULATION DIAMETER RANGE Ø1.20-1.60 mm [.047-.063 IN]
TERMINAL APPLICATION SPECIFICATION	114-15120	-	-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1674298-1	1123343-1	1122343-2	1802189-1
1801069-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.06+/-0.05 [.042+/- .002]	8.5
0.30mm2	0.96+/-0.05 [.038+/- .002]	9.2
0.22mm2	0.84+/-0.05 [.033+/- .002]	10.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.01+/-0.05 [.040+/- .002]	8.5
0.30mm2	0.96+/-0.05 [.038+/- .002]	9.2
0.22mm2	0.84+/-0.05 [.033+/- .002]	10.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.99+/-0.05 [.039+/- .002]	8.5
0.35mm2	0.92+/-0.05 [.036+/- .002]	9.3
0.22mm2	0.84+/-0.05 [.033+/- .002]	10.0



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
6. 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)

2		1							
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
		-		SEE SHEET 1			-	-	-

-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	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	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	8-1333201-3	ANVIL, COMBINATION	8
-	1	1	3-240641-7	SPACER	7
-	1	1	1-2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	2-1803223-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	3-456402-5	CRIMPER, WIRE PREMIUM	1

-77		-22	-21	PART NO	DESCRIPTION	ITEM NO
DWN		B. WEAVER		11OCT2011	TE Connectivity Harrisburg, PA 17105-3608	
CHK		G. HOFENER		11OCT2011		
APVD		S. BAILEY		11OCT2011	NAME Ocean Side Feed Applicator	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		
mm		0 PLC ±.01		APPLICATION SPEC	SIZE CASE CODE DRAWING NO RESTRICTED TO	
		1 PLC ±.01				
		2 PLC ±.01			A1 00779 ©=2151494	
		3 PLC ±.01				
		4 PLC ±.01			Customer Accessible Production Drawing	
		ANGLES FINISH				
MATERIAL				WEIGHT	SCALE 1:2	SHEET 3 OF 4 REV P

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Diagram illustrating the front view of the machine assembly, showing the front plate, front plate bracket, and front plate bracket bracket. Callouts 238, 59, and 56 point to specific components. A callout 'SEE DETAIL A' points to a detail view of the front plate bracket.

This diagram shows the front panel assembly in an exploded view. It includes a long rectangular panel (24) with two vertical slots. Two screws (33) are shown above the panel, aligned with these slots. Below the panel, two cylindrical components (30) are shown, which are part of the front panel assembly. To the right, a larger component (29) is shown, which is the front panel assembly itself, featuring a central circular opening and a handle on the right side.

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

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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		NAME Ocean Side Feed Aplicator -	
MATERIAL -		FINISH -		WEIGHT -	
		SIZE A1 CODE 00779 DRAWING NO C-2151494		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 4 OF 4 REV P	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION