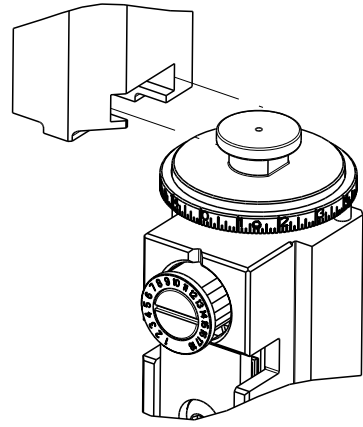


8	7
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RELEASED FOR PUBLICATION 2012	
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PART NUMBER	REVISION
2151699-2	C
7-2151699-2	C
7-2151699-7	A
DESCRIPTION	
FINE CRIMP HEIGHT ADJUST	
PNEUMATIC AND CRIMP TOOLING KIT	
CRIMP TOOLING KIT	
FEED TYPE	
PNEUMATIC	
PNEUMATIC	
-	

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.205 [5.21 mm]	D
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL TYCO ELECTRONICS CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON	
WIRE STRIP LENGTH .296-.328 IN [7.52-8.33 mm]	INSULATION DIAMETER RANGE Ø .320 IN [8.13 mm] MAX
TERMINAL APPLICATION SPECIFICATION 114-2123 Rev G	-
TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL
3-520370-2	

WIRE SIZE		CRIMP HEIGHT INCH [mm]		CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14		0.075+/-0.002 [1.91+/-0.05]		5.6	.19 IN [4.83mm]
16		0.070+/-0.002 [1.78+/-0.05]		7.0	.19 IN [4.83mm]



1 RECOMMENDED SPARE PARTS

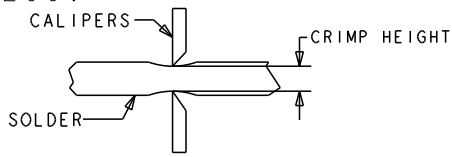
2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

3 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.

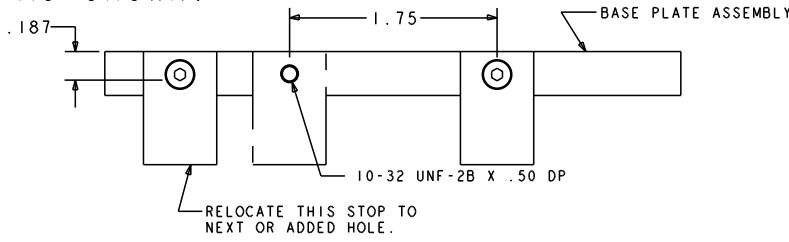
4 ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.

5 ITEM 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.

6 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



7 IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.



8 ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.

9 ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.

10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

11. 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)

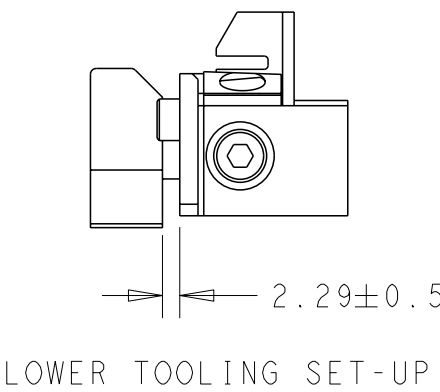
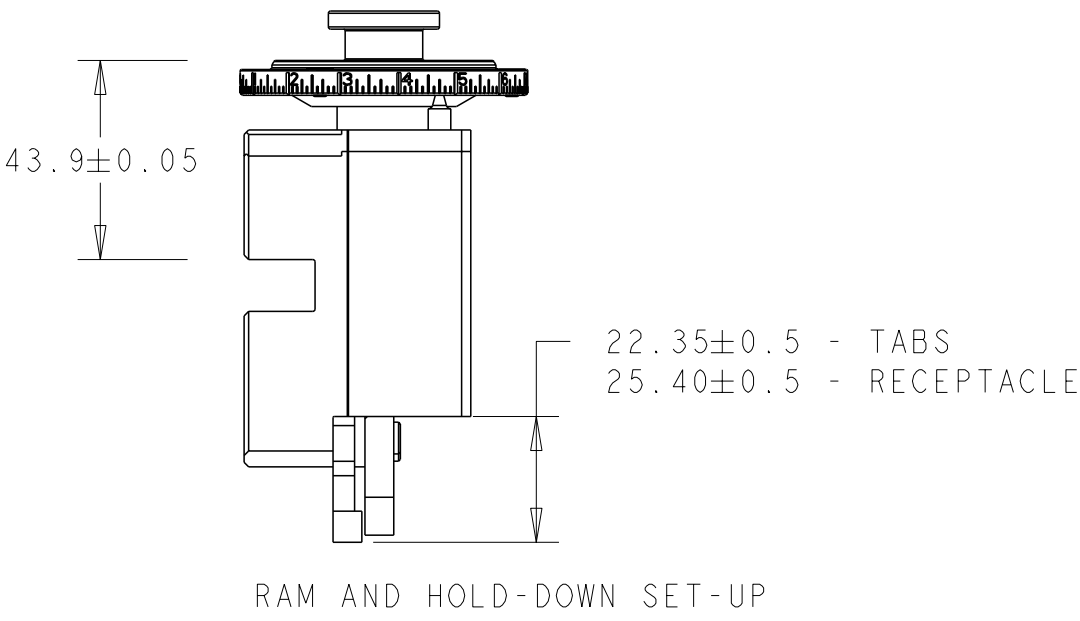
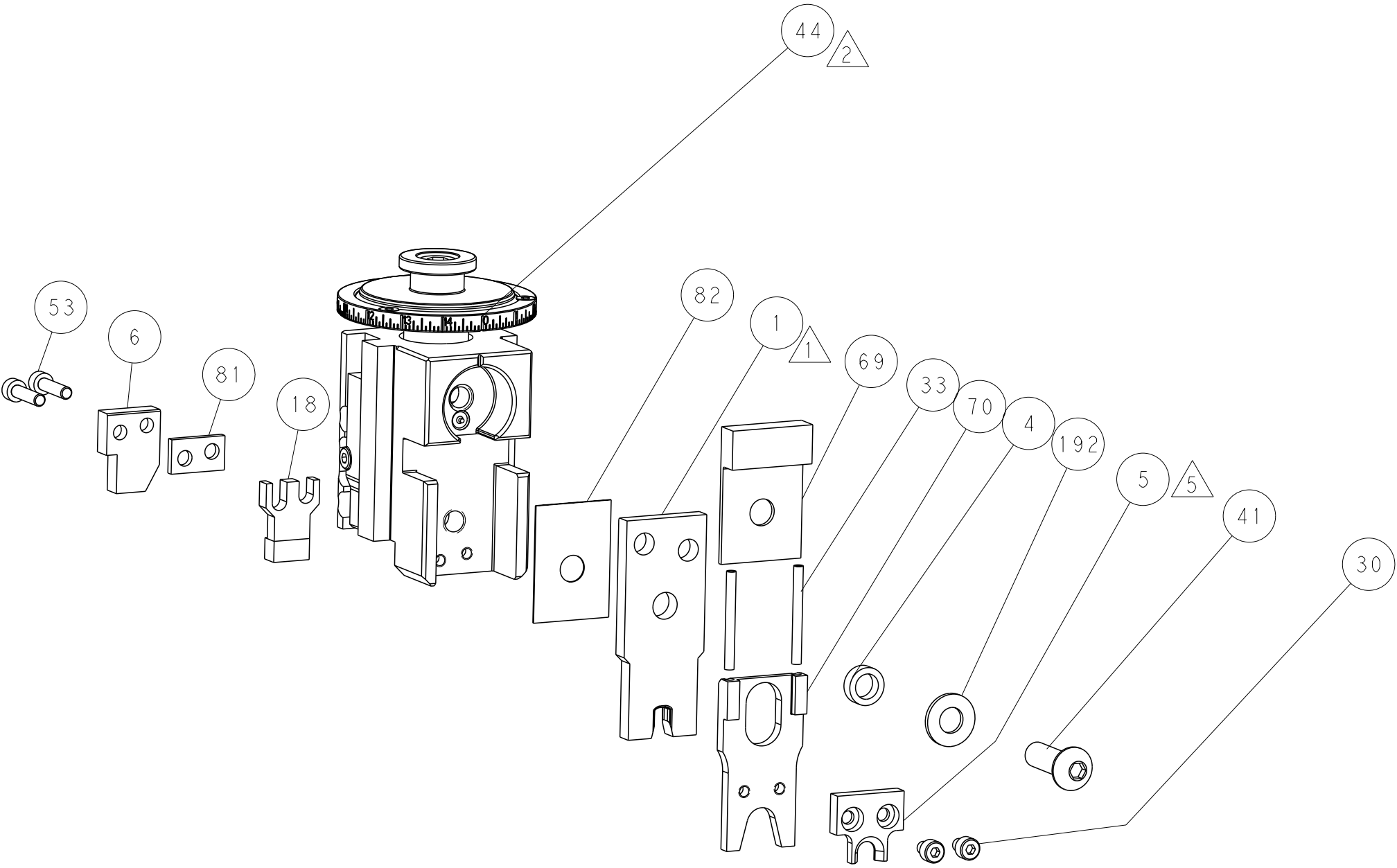
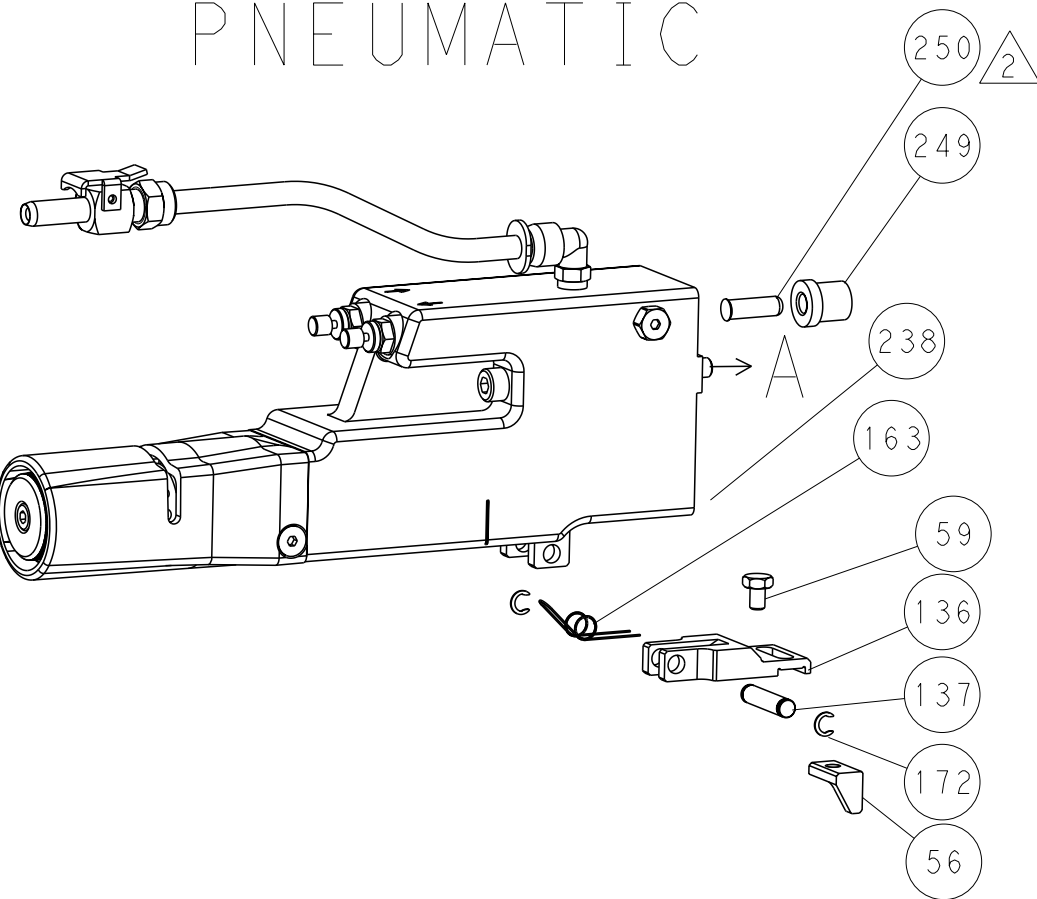
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		B		ECR-18-001327	26JAN2018
		C		ECR-18-016781	25OCT2018
		C1		ECR-18-017084	29OCT2018

9	-	1	1	2280441-1	INSERT, SHEAR	282
9	-	REF	REF	462992-7	GUARD ASSEMBLY	257
9	-	REF	REF	679532-1	INSERT, GUARD	256
8	-	1	1	189728-1	BRACKET, SPACER	255
8	-	1	1	568681-1	SPACER, BASE PLATE	253
	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	1	2063440-2	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	240638-1	SPRING, FEED FINGER	163
	-	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	1	2119799-1	HOLDER,FEED FINGER, AF	136
	-	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
	-	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	4	4	18023-4	SCR, SKT HD CAP M3 X 10.0	94
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	240641-9	SPACER	81
	-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	1	2161332-4	DEPRESSOR, WIRE FUNNEL	70
	-	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
	-	2	2	1-18028-4	WASHER, FLAT, REG M3	68
	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	462427-2	FINGER, FEED	56
	-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1-1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
5	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	462433-7	SUPPORT, INSULATION	42
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	2	2	5-22278-1	SPRING, COMPRESSION	33
	-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
	-	1	1	2161336-2	PLATE, REAR STRIP GUIDE	29
	-	2	2	22281-9	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	684042-4	GUIDE, STRIP, FRONT	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	463460-2	HOLD DOWN, TERMINAL	18
1	-	1	1	469542-3	REAR FLOATING SHEAR	17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
1	-	1	1	2161335-2	SHEAR PLATE, REAR	15
	-	1	1	2119862-2	SHEAR HOLDER, REAR	14
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-4	STOP, SHEAR	11
	-	-	-	-	-	10
5	-	1	1	462843-6	TERMINAL SUPPORT	9
1	1	2	1	464282-2	ANVIL, SAND-BLASTED 16-14	8
4	-	1	1	803925-2	GUIDE, CARRIER SCRAP	7
	-	1	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
5	-	1	1	462431-5	WIRE FUNNEL	5
	-	1	1	238011-1	BLOCK, CRIMPER SPACER	4
	-	-	-	-	-	3
	-	-	-	-	-	2
1	1	2	1	464281-1	CRIMPER, SEMI FLAT 16-14	1

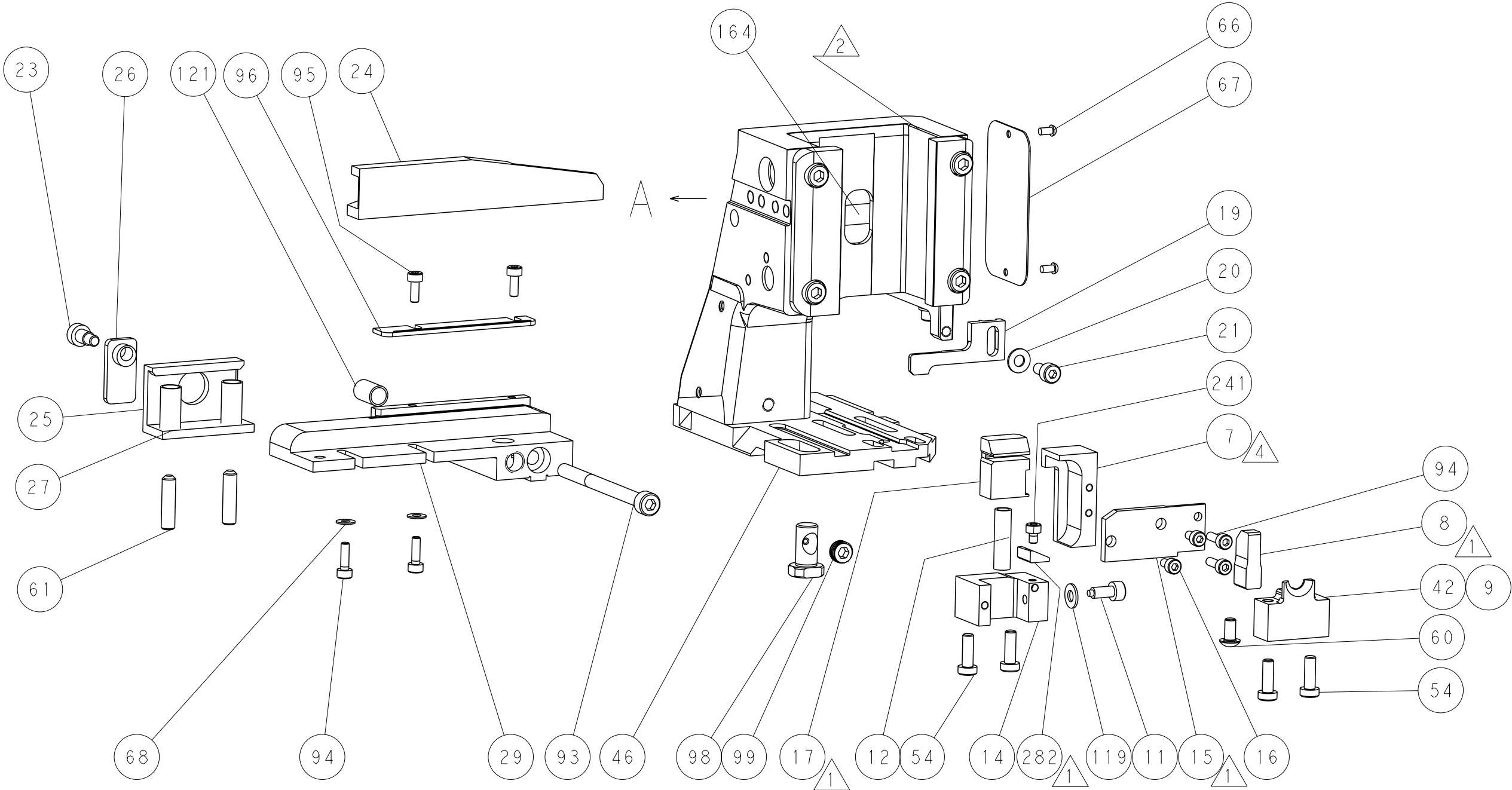
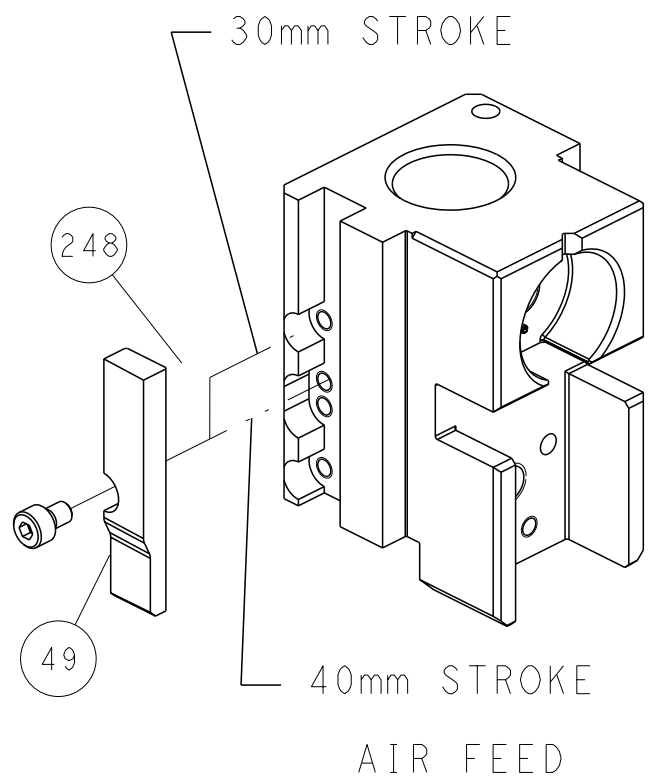
-77-72	-2	PART NO	DESCRIPTION	ITEM NO
DOWN D. WEAVER 18JUN2012 CHK G. HOFENER 18JUN2012 APVD T. ELBIN 18JUN2012				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		
MATERIAL		FINISH		
-		-		
Customer Accessible Production Drawing		SCALE	1:1	SHEET 1 OF 4
REV C1		REV C1		

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

FEED TYPE
PNEUMATIC



CAM POSITIONS

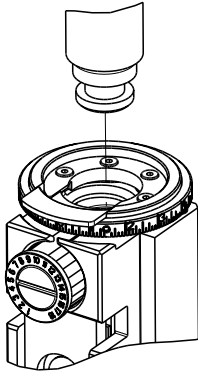


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHALL BE CONTACTED FOR THE LATEST REVISION				DWN B. WEAVER 18JUN2012	 TE Connectivity Harrisburg, PA 17105-3608	
				CHK G. HOFENER 18JUN2012		
				APVD T. ELBIN 18JUN2012	NAME Ocean Side Feed Applicator	
				PRODUCT SPEC		
				APPLICATION SPEC		
				WEIGHT		
				Customer Accessible Production Drawing		
				SCALE	1:1	SHEET 2 OF 4
				REV	C1	

8		7	
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2012		2012	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151699-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151699-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.205 [5.21 mm]	D
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL TYCO ELECTRONICS CRIMP SPECIFICATION			
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH .296-.328 IN [7.52-8.33 mm]		INSULATION DIAMETER RANGE Ø .320 IN [8.13 mm] MAX	
TERMINAL APPLICATION SPECIFICATION	114-2123 Rev G	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-520370-2			

WIRE SIZE		CRIMP HEIGHT INCH [mm]		CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14		0.075+/-0.002 [1.91+/-0.05]		5.6	.19 IN [4.83mm]
16		0.070+/-0.002 [1.78+/-0.05]		7.0	.19 IN [4.83mm]



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- ITEM 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- TO CHECK CRIMP HEIGHT. CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
- IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
- ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD. ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

11. 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				
		#	LYR	DESCRIPTION	DATE	OWN
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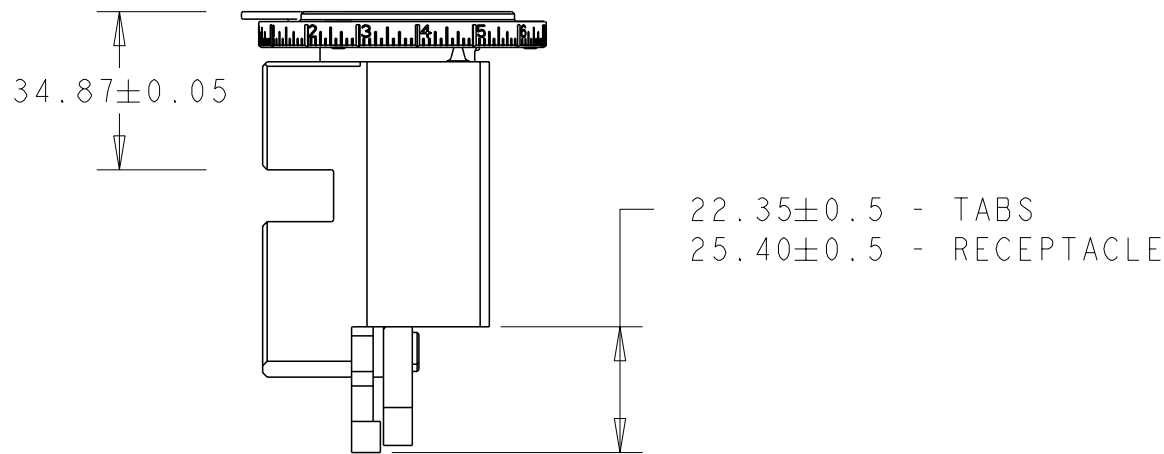
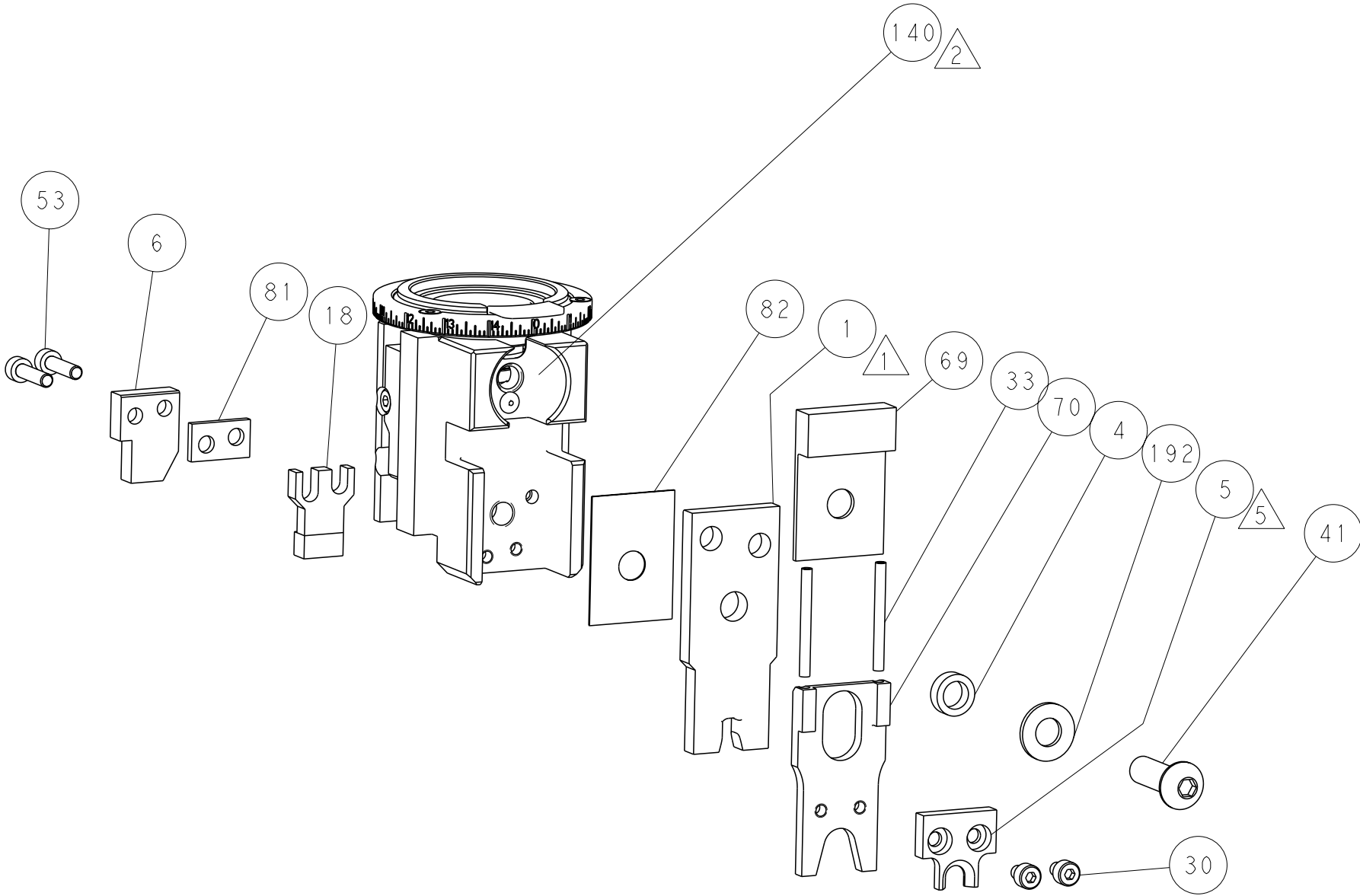
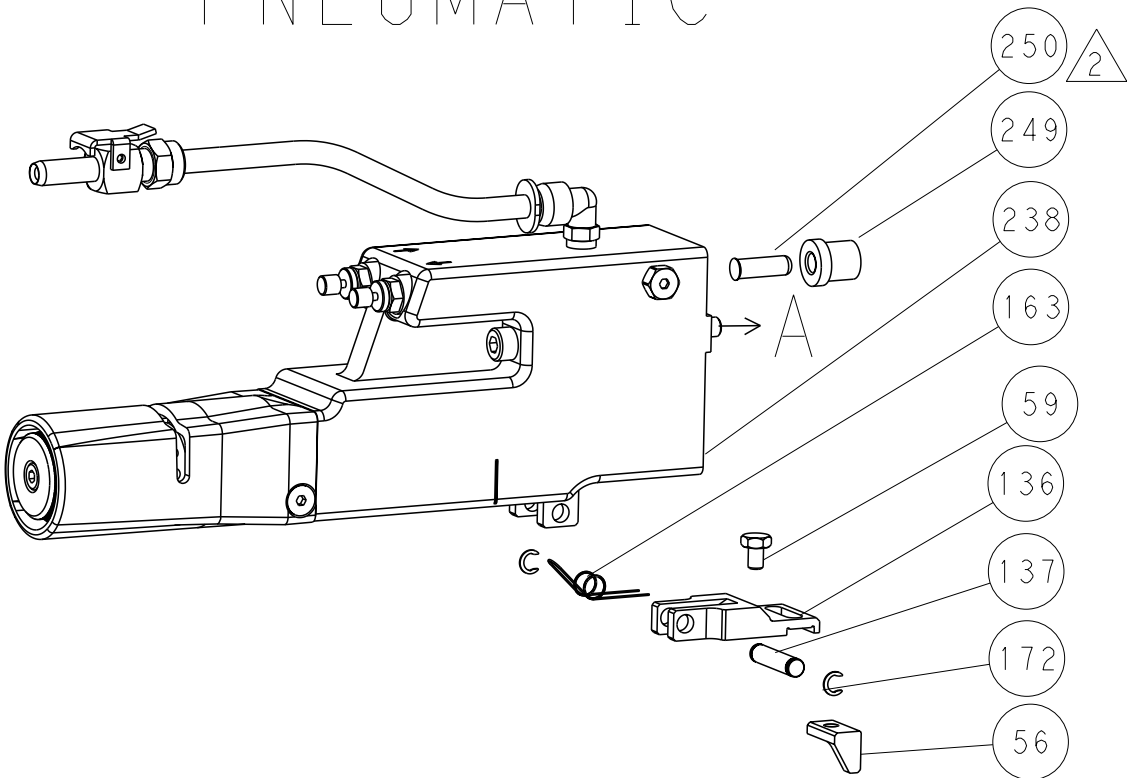
	-	1	2280441-1	INSERT, SHEAR	282
9	-	REF	462992-7	GUARD ASSEMBLY	257
9	-	REF	679532-1	INSERT, GUARD	256
8	-	1	189728-1	BRACKET, SPACER	255
8	-	1	568681-1	SPACER, BASE PLATE	253
	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1803259-1	BUSHING, FLANGED	249
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2063440-2	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	REF		994970-2	COUNTER, MAGNETIC	164
	-	1	240638-1	SPRING, FEED FINGER	163
	-	1	2119641-2	FEED CAM, AIR FEED	151
	-	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
	-	1	2-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	2119799-1	HOLDER, FEED FINGER, AF	136
	-	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
	-	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	4	18023-4	SCR, SKT HD CAP M3 X 10.0	94
	-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	455888-4	SPACER, CRIMPER	82
	-	1	240641-9	SPACER	81
	-	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	2161332-4	DEPRESSOR, WIRE FUNNEL	70
	-	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
	-	2	1-18028-4	WASHER, FLAT, REG M3	68
	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	462427-2	FINGER, FEED	56
	-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
5	-	1	462433-7	SUPPORT, INSULATION	42
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	2	5-22278-1	SPRING, COMPRESSION	33
	-	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
	-	1	2161336-2	PLATE, REAR STRIP GUIDE	29
	-	2	22281-9	SPRING, COMPRESSION	27
	-	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	240792-1	DRAG, TERMINAL	25
	-	1	684042-4	GUIDE, STRIP, FRONT	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	463460-2	HOLD DOWN, TERMINAL	18
1	-	1	469542-3	REAR FLOATING SHEAR	17
	-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
1	-	1	2161335-2	SHEAR PLATE, REAR	15
	-	1	2119862-2	SHEAR HOLDER, REAR	14
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-4	STOP, SHEAR	11
	-	-	-	-	10
5	-	1	462843-6	TERMINAL SUPPORT	9
1	1	1	464282-2	ANVIL, SAND-BLASTED 16-14	8
4	-	1	803925-2	GUIDE, CARRIER SCRAP	7
	-	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
5	-	1	462431-5	WIRE FUNNEL	5
	-	1	238011-1	BLOCK, CRIMPER SPACER	4
	-	-	-	-	3
	-	-	-	-	2
1	1	1	464281-1	CRIMPER, SEMI FLAT 16-14	1
-77 -22		PART NO		DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC INDUSTRY. IT IS SUBJECT TO CHANGE AND TO BE USED IN ACCORDANCE WITH THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN B. WEAVER CHK G. HOFFNER APVD T. ELBIN 18JUN2012		18JUN2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator			
		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		PRODUCT SPEC		SIZE		CAGE CODE	
MATERIAL		FINISH		APPLICATION SPEC		DRAWING NO		RESTRICTED TO	
				WEIGHT		A 00779		C=2151699	
Customer Accessible Production Drawing						SCALE 1:1		SHEET 3 of 4	
								REV C1	

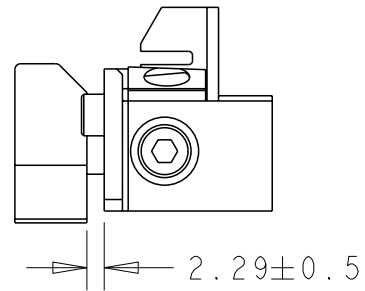
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE
PNEUMATIC

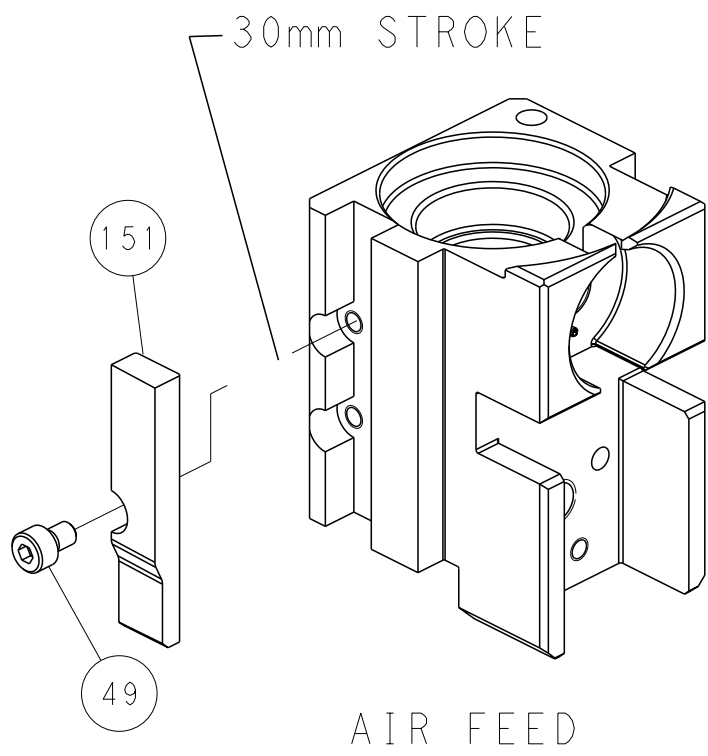


RAM AND HOLD-DOWN SET-UP

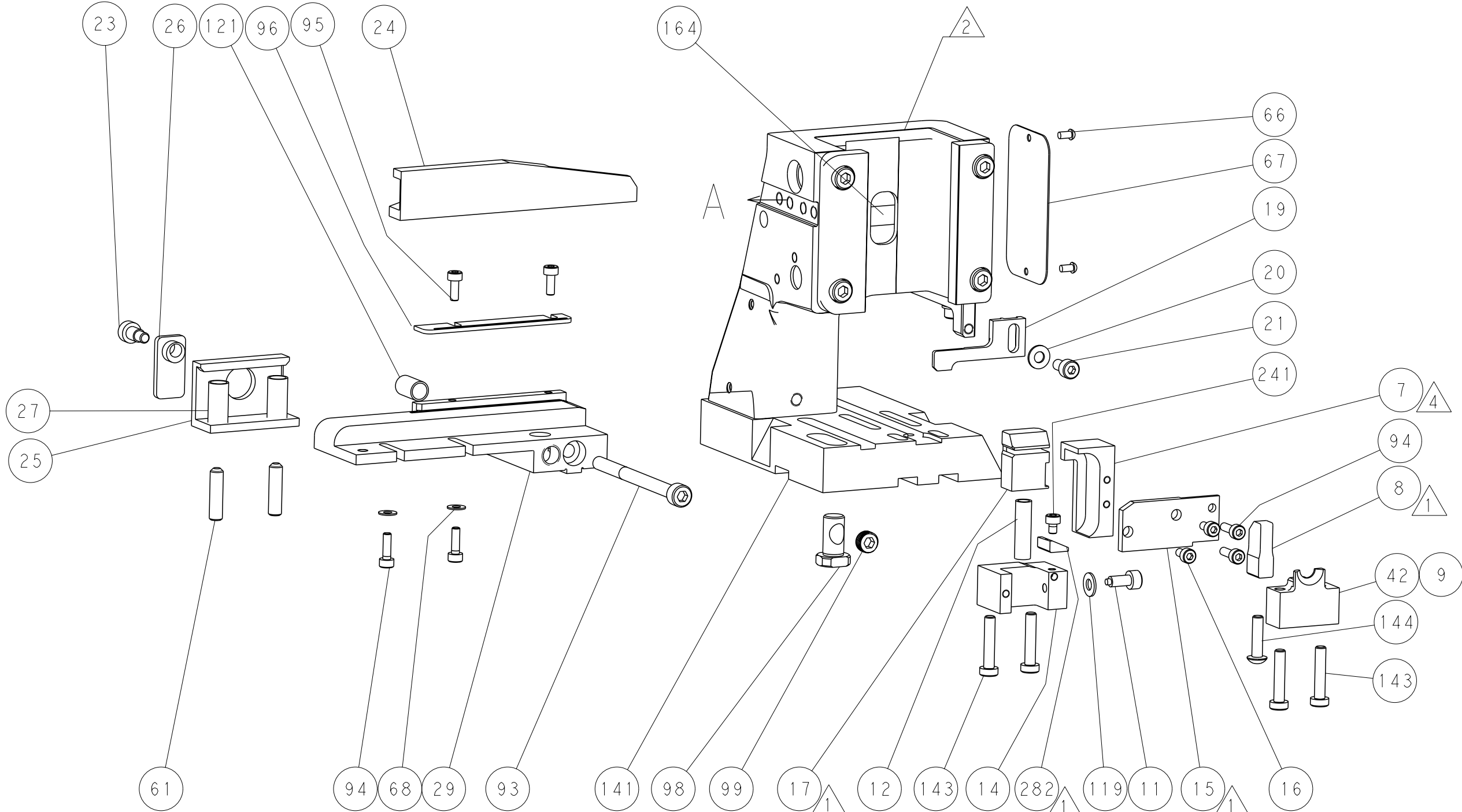


LOWER TOOLING SET-UP

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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN B. WEAVER 18JUN2012	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK G. HOFNER 18JUN2012				
				APVD T. ELBIN 18JUN2012	NAME Ocean Side Feed Applicator			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:				RESTRICTED TO
				0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1				
MATERIAL -				FINISH -				-
				WEIGHT -				-
				Customer Accessible Production Drawing				-
				SCALE 1:1 SHEET 4 OF 4 REV C1				