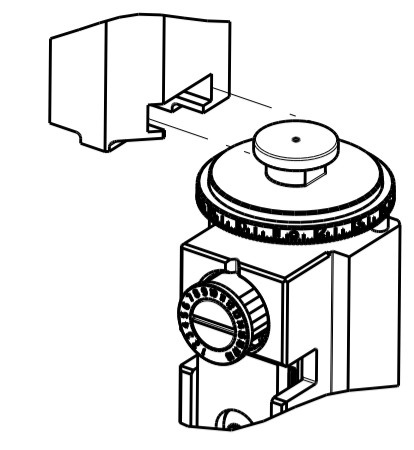


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151698-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151698-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151698-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	.176 [4.47 mm]	0
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: FULLY INSULATED FASTON

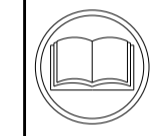
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
.265-.297 IN [6.73-7.54 mm]	Ø 9

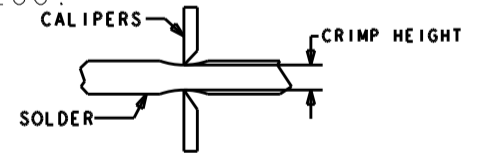
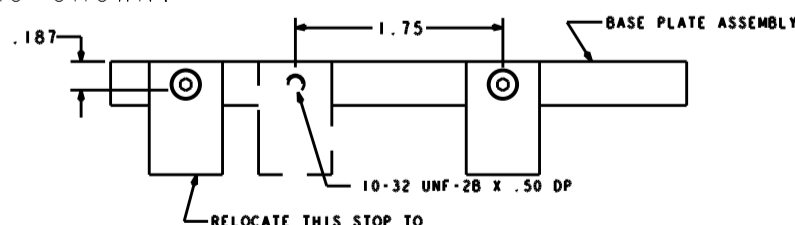
TERMINAL APPLICATION SPECIFICATION 114-2123

TERMINALS APPLIED 3

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520080-2	9-520272-2	2-520306-2	
2-520083-2	2-521010-2	2-520310-2	
2-520272-2			

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
18	0.070+/-0.002 [1.78+/-0.05]	6.3	.12 IN [3.05mm]
20 or 22	0.065+/-0.002 [1.65+/-0.05]	7.7	.12 IN [3.05mm]



- 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 ITEMS 5 AND 9 OR ITEMS 10 AND 22 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 OR 43 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- 6 FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- 7 GROUP 1 TERMINALS: Ø.120 IN [3.05mm] MAX INSULATION
GROUP 2 TERMINALS: Ø.200 IN [5.08mm] MAX INSULATION
- 8 USE ITEMS 5, 9, OR 42 WITH GROUP 1 TERMINALS
USE ITEMS 10, 22, OR 43 WITH GROUP 2 TERMINALS
- 9 TO CHECK CRIMP HEIGHT. CRIMP SOLDER (Ø.12 IN [3.05mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
 
- 10 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.
 
- 11 ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- 12 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.
- 13 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 14. 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.

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	C		ECR-18-017653	19NOV2018	JAH	CT
		D		ECR-18-019699	17DEC2018	JAH	CT
		E		ECR-19-009212	12JUN2019	FJ	TE
		F		ECR-19-014579	18SEP2019	FZ	TE

2	-	REF	REF	462992-7	GUARD ASSEMBLY	257
2	-	REF	REF	679532-1	INSERT, GUARD	256
1	-	1	1	189728-1	BRACKET, SPACER	255
1	-	1	1	568681-1	SPACER, BASE PLATE	253
1	-	1	1	2119641-1	FEED CAM, AIR FEED	248
1	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
1	-	1	1	2844940-2	AIR FEED MODULE	238
1	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
1	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
1	-	1	1	1-22281-8	SPRING, COMPRESSION	121
1	-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
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
4	-	4	4	18023-4	SCR, SKT HD CAP M3 X 10.0	94
1	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
1	-	1	1	455888-4	SPACER, CRIMPER	82
1	-	1	1	240641-9	SPACER	81
1	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
1	-	1	1	2161332-2	DEPRESSOR, WIRE FUNNEL	70
1	-	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
2	-	2	2	1-18028-4	WASHER, FLAT, REG M3	68
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	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
1	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
1	-	1	1	462427-2	FINGER, FEED	56
4	-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
2	-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
1	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
1	-	1	1	1-1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
1	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
5	-	1	1	462433-7	SUPPORT, INSULATION	43
5	-	1	1	1-462433-0	SUPPORT, INSULATION	42
1	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
2	-	2	2	5-22278-1	SPRING, COMPRESSION	33
2	-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
1	-	1	1	2161336-2	PLATE, REAR STRIP GUIDE	29
2	-	2	2	22281-9	SPRING, COMPRESSION	27
1	-	1	1	356835-1	LEVER, DRAG RELEASE	26
1	-	1	1	240792-1	DRAG, TERMINAL	25
1	-	1	1	684042-4	GUIDE, STRIP, FRONT	24
1	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
8	-	5	1	462431-6	WIRE FUNNEL	22
1	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
1	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
1	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	463460-2	HOLD DOWN, TERMINAL	18
1	-	1	1	469542-3	REAR FLOATING SHEAR	17
2	-	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	1	2119862-2	SHEAR HOLDER, REAR	14
1	-	1	1	2280441-1	INSERT, SHEAR	13
1	-	1	1	3-22280-3	SPRING, COMPRESSION	12
1	-	1	1	1-356885-4	STOP, SHEAR	11
5	-	1	1	462843-6	TERMINAL SUPPORT	10
5	-	1	1	462843-8	TERMINAL SUPPORT	9
1	-	2	1	464291-4	ANVIL, SAND-BLASTED 22-18	8
4	-	1	1	803925-2	GUIDE, CARRIER SCRAP	7
1	-	1	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
8	-	5	1	462431-3	WIRE FUNNEL	5
1	-	1	1	238011-1	BLOCK, CRIMPER SPACER	4
1	-	2	1	464290-1	CRIMPER, SEMI-FLAT 22-18	1

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

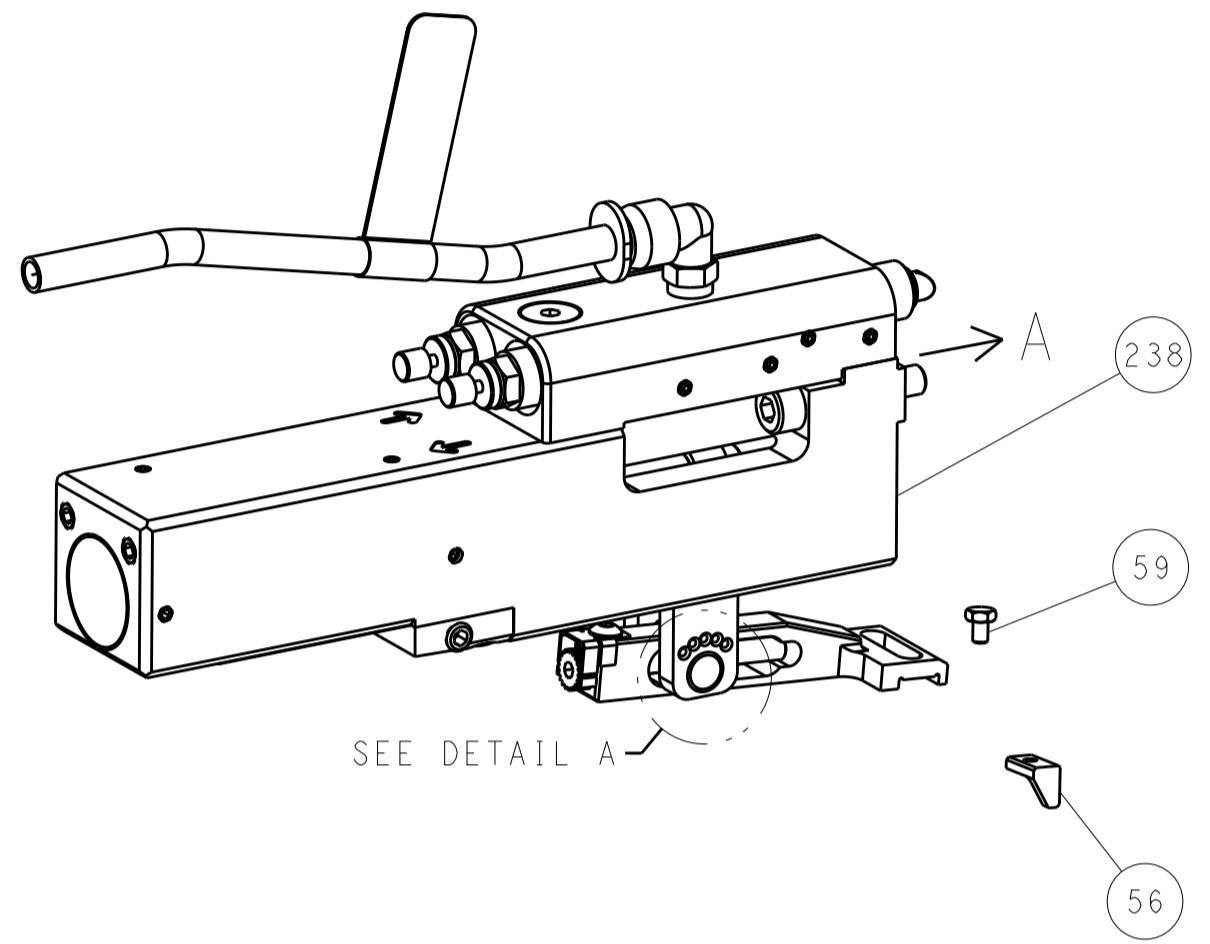
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES					

Customer Accessible Production Drawing

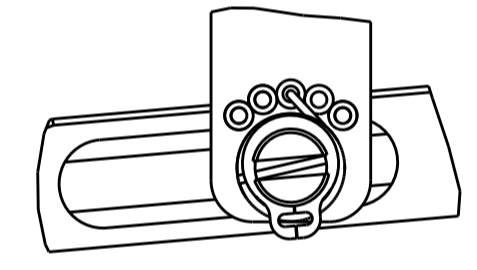
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

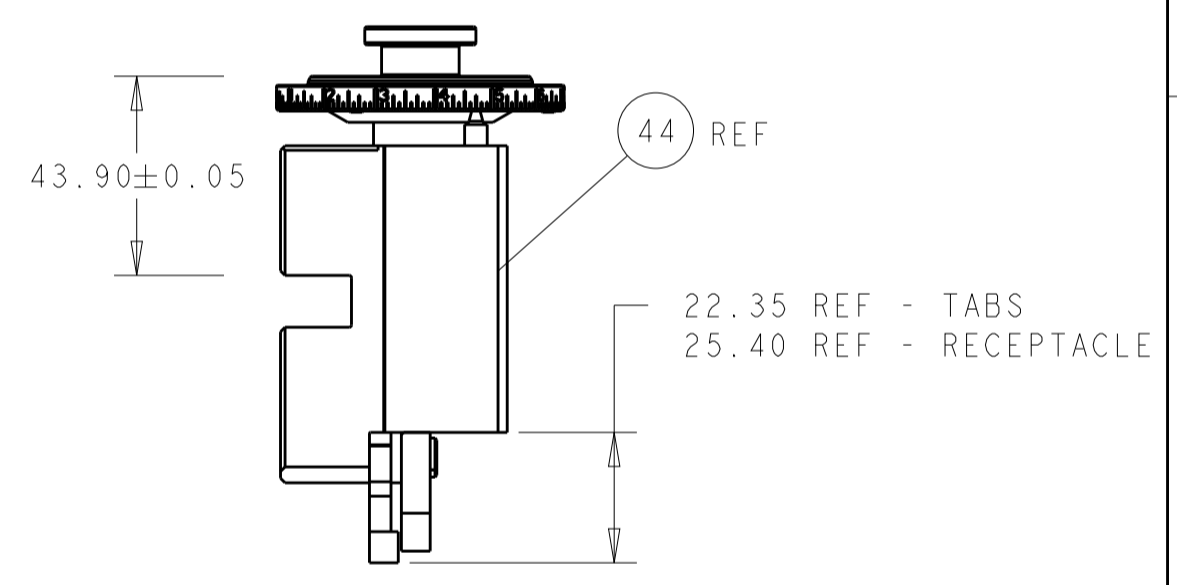
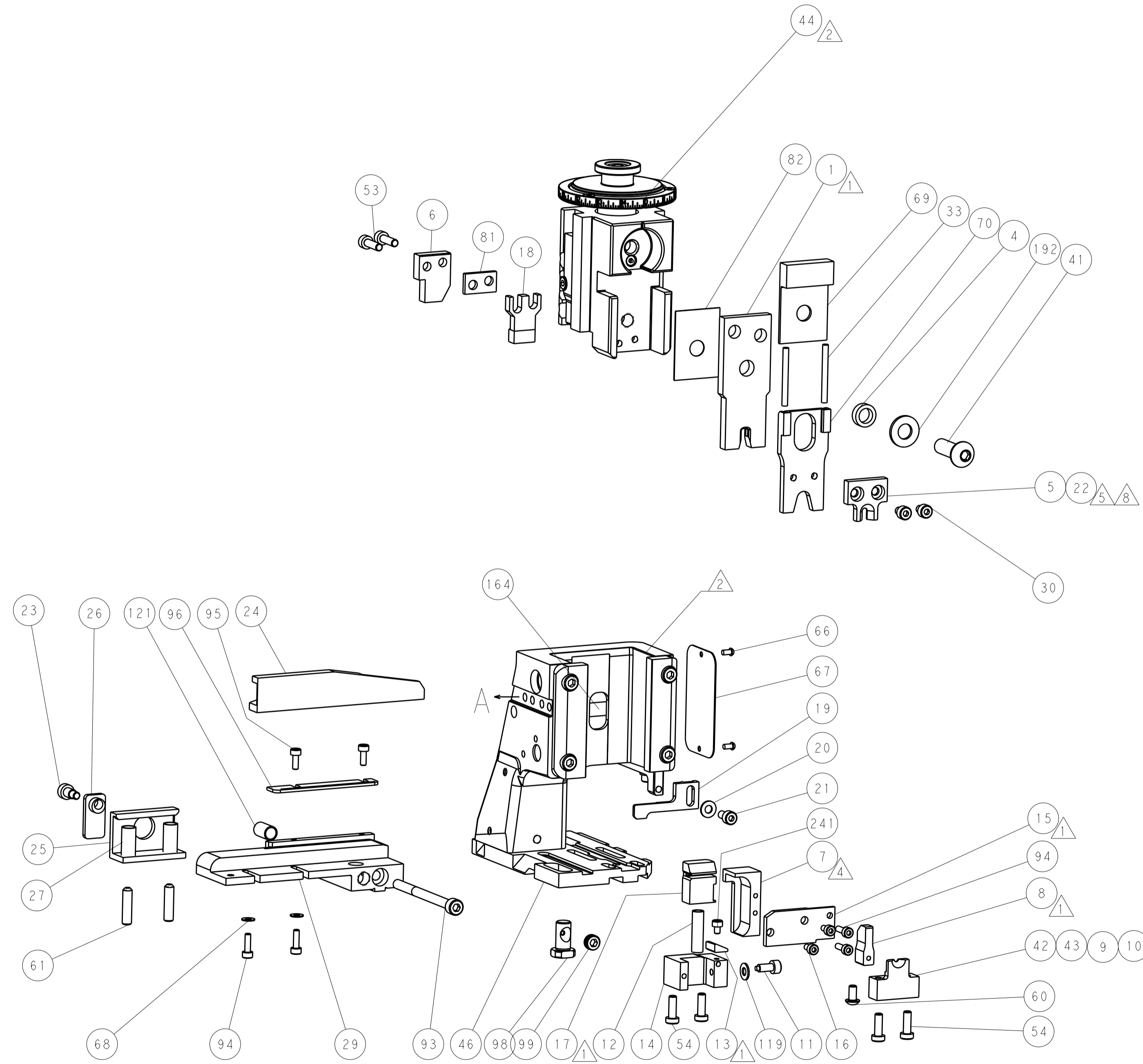
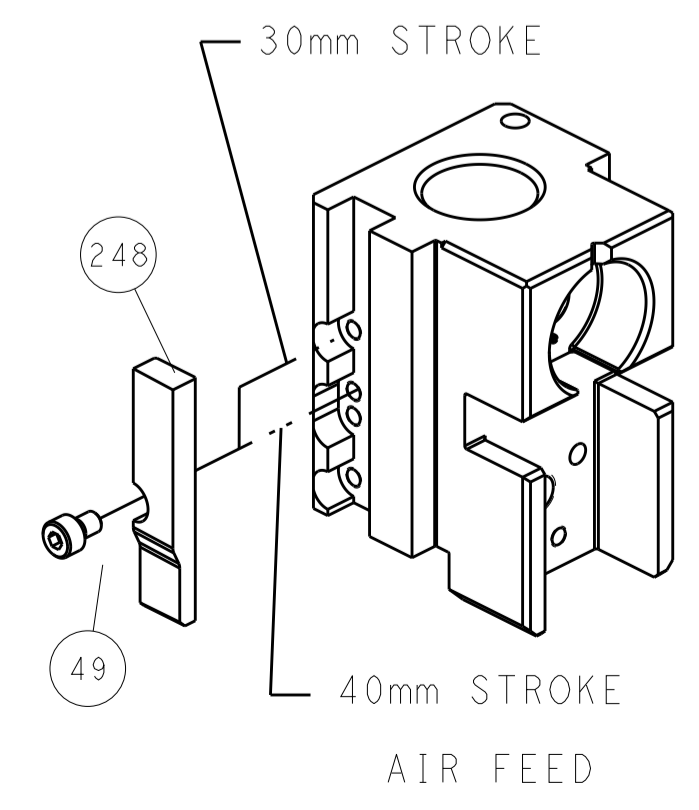


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

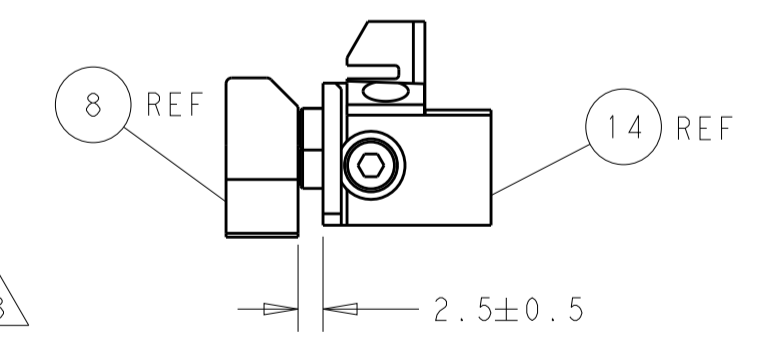


DETAIL A

CAM POSITIONS



RAM SET-UP



LOWER TOOLING SET-UP

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 UNPUBLISHED. RELEASED FOR PUBLICATION 2012 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER 15JUN2012 CHK: G. HOFENER 15JUN2012 APVD: T. ELBIN 15JUN2012	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 PRODUCT SPEC: APPLICATION SPEC: WEIGHT: A1 00779 SCALE: 1:1	RESTRICTED TO: SHEET 2 OF 4 REV F
Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151698-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
2-2151698-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.176 [4.47 mm]	0
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

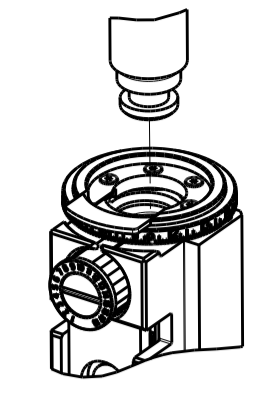
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.265-.297 IN [6.73-7.54 mm]		∅ .114-.123	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520080-2	9-520272-2	2-520306-2	
2-520083-2	2-521010-2	2-520310-2	
2-520272-2			

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
18	0.070 +/- 0.002 [1.78 +/- 0.05]	6.3	.12 IN [3.05mm]
20 or 22	0.065 +/- 0.002 [1.65 +/- 0.05]	7.7	.12 IN [3.05mm]

- 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.
- ITEMS 5 AND 9 OR ITEMS 10 AND 22 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 OR 43 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- GROUP 1 TERMINALS: ∅.120 IN [3.05mm] MAX INSULATION
GROUP 2 TERMINALS: ∅.200 IN [5.08mm] MAX INSULATION
- USE ITEMS 5, 9, OR 42 WITH GROUP 1 TERMINALS
USE ITEMS 10, 22, OR 43 WITH GROUP 2 TERMINALS
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.12 IN [3.05mm] 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.

14. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



***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	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

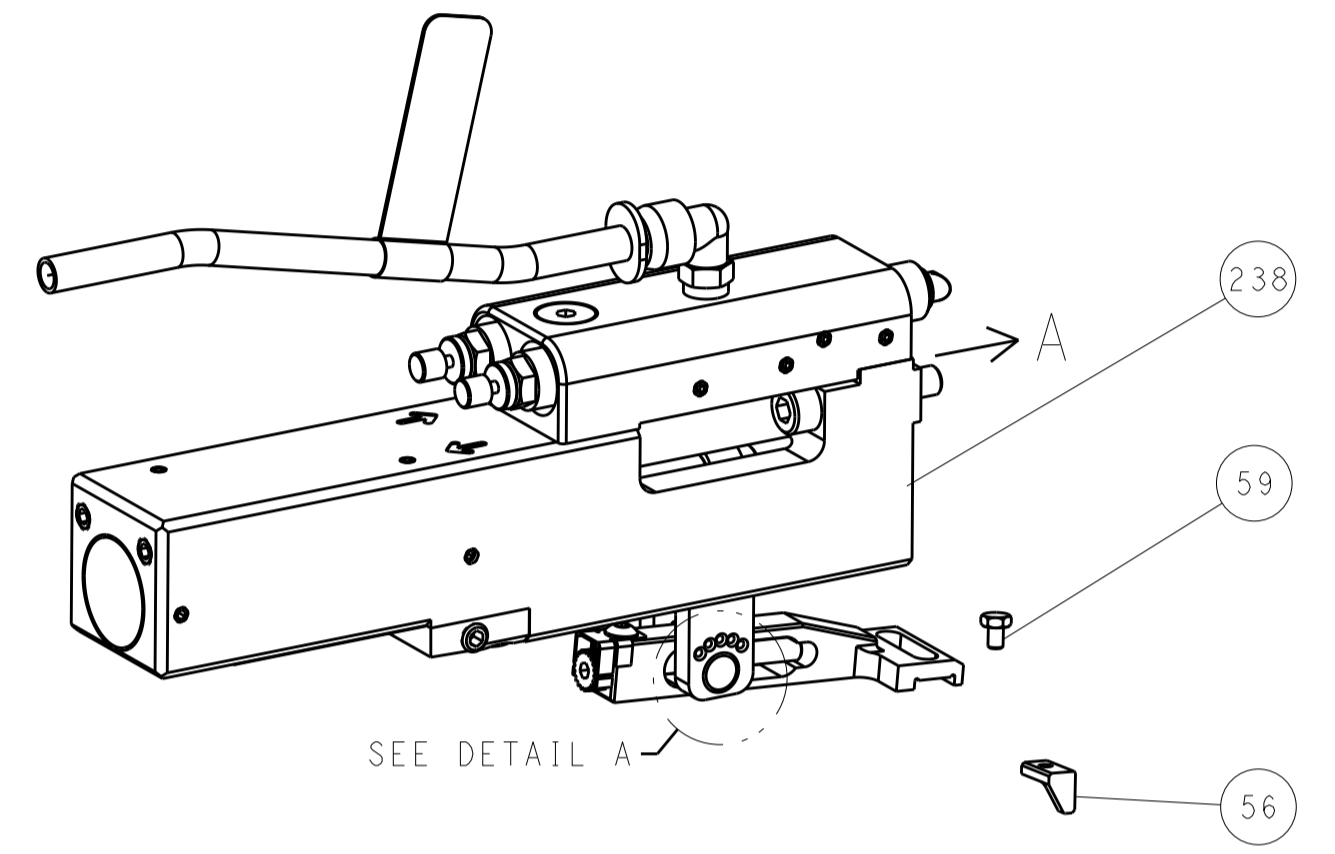
	-	REF	462992-7	GUARD ASSEMBLY	257
	-	REF	679532-1	INSERT, GUARD	256
	-	1	189728-1	BRACKET, SPACER	255
	-	1	568681-1	SPACER, BASE PLATE	253
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2844940-2	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	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	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	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	2161332-2	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	462433-7	SUPPORT, INSULATION	43
	-	1	1-462433-0	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	462431-6	WIRE FUNNEL	22
	-	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	469542-3	REAR FLOATING SHEAR	17
	-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	-	1	2161335-2	SHEAR PLATE, REAR	15
	-	1	2119862-2	SHEAR HOLDER, REAR	14
	-	1	2280441-1	INSERT, SHEAR	13
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-4	STOP, SHEAR	11
	-	1	462843-6	TERMINAL SUPPORT	10
	-	1	462843-8	TERMINAL SUPPORT	9
	-	1	464291-4	ANVIL, SAND-BLASTED 22-18	8
	-	1	803925-2	GUIDE, CARRIER SCRAP	7
	-	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
	-	1	462431-3	WIRE FUNNEL	5
	-	1	238011-1	BLOCK, CRIMPER SPACER	4
	-	1	464290-1	CRIMPER, SEMI-FLAT 22-18	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	WEAVER	15JUN2012	TE Connectivity	
	3 PLC ±	4 PLC ±	ANGLES ±	G. HOFENER	15JUN2012	Harrisburg, PA 17105-3608	
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing		Ocean Side Feed Applicator	
			1:1	A1 00779 ©=2151698		SHEET 3 OF 4 REV F	

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

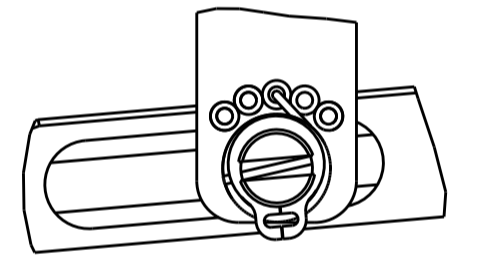
FEED TYPE

PNEUMATIC



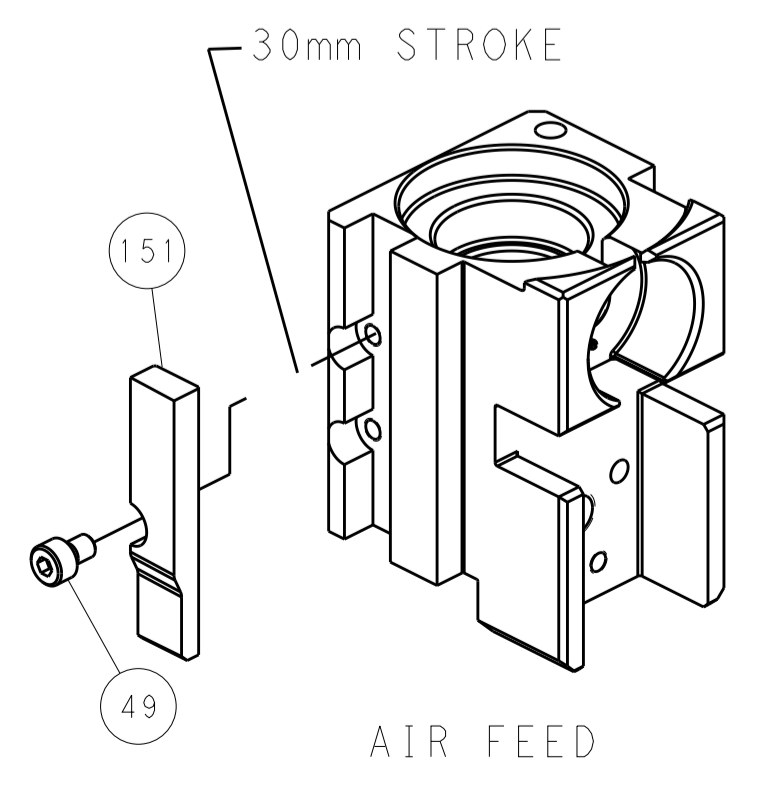
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

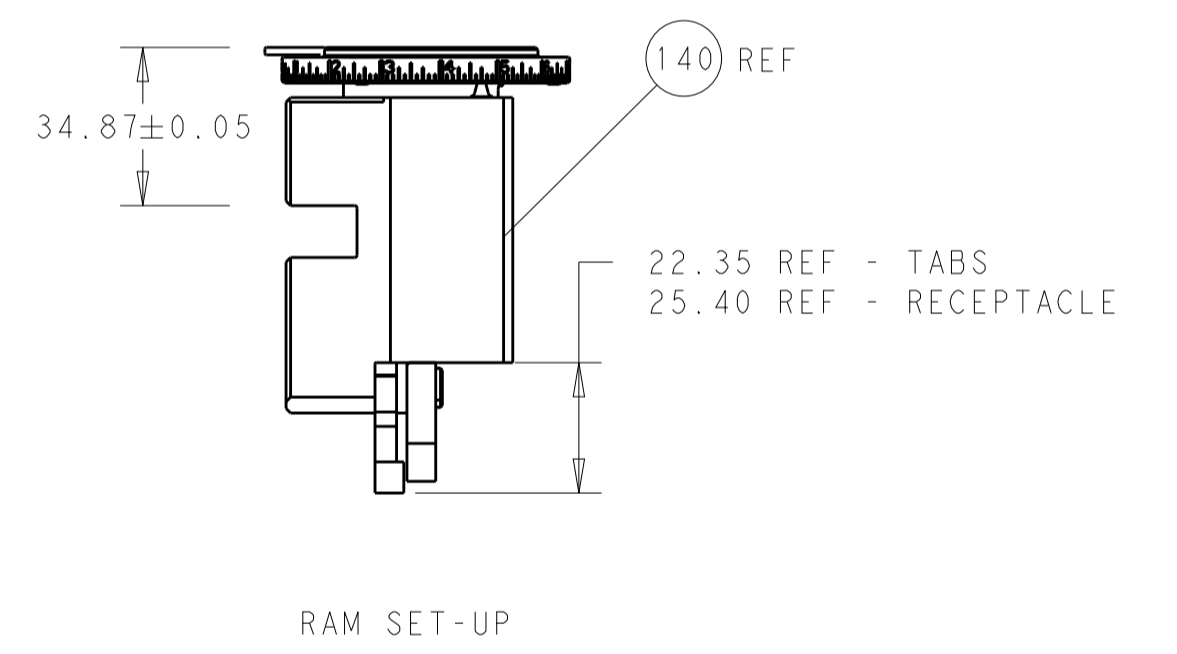
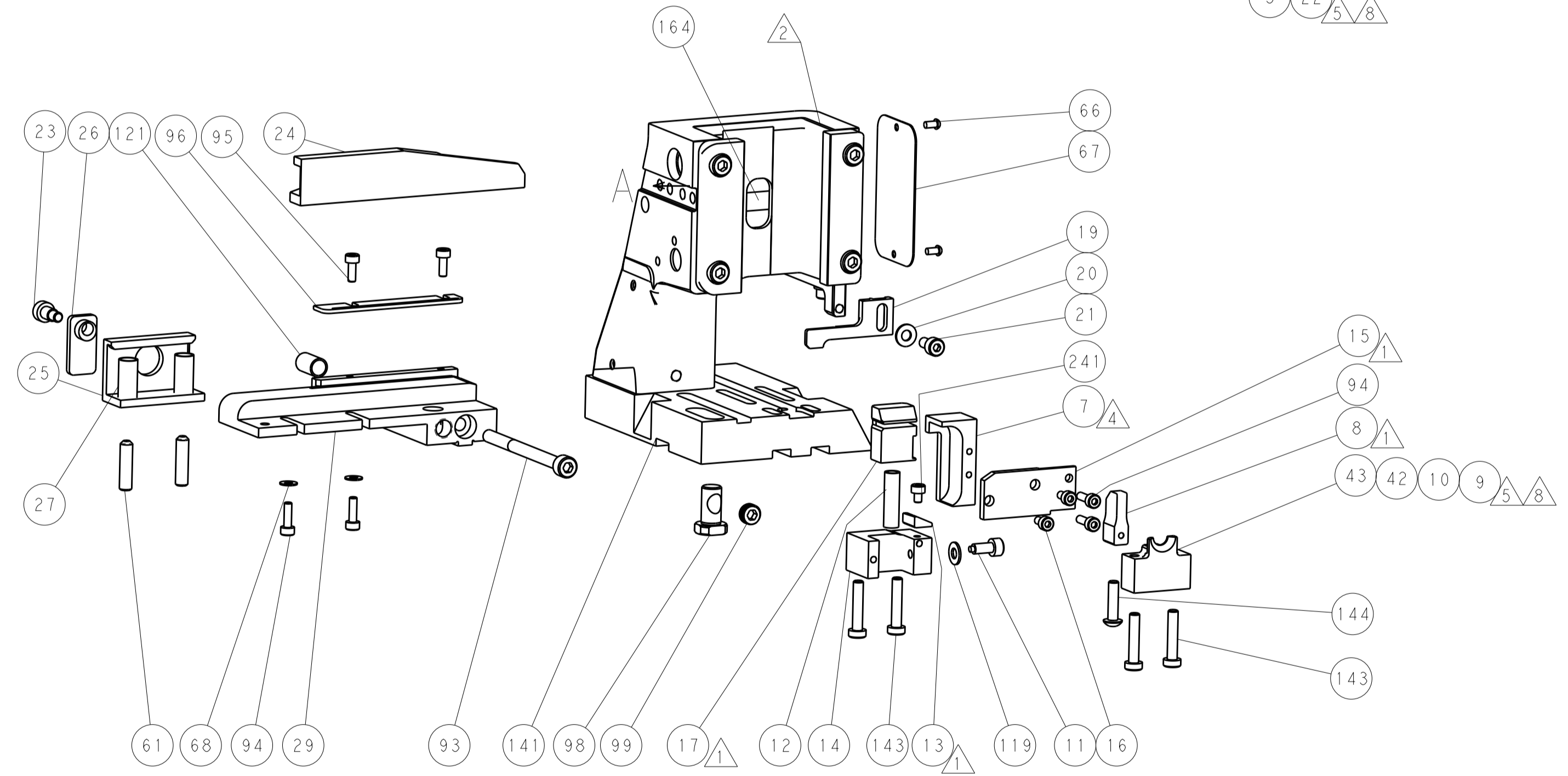
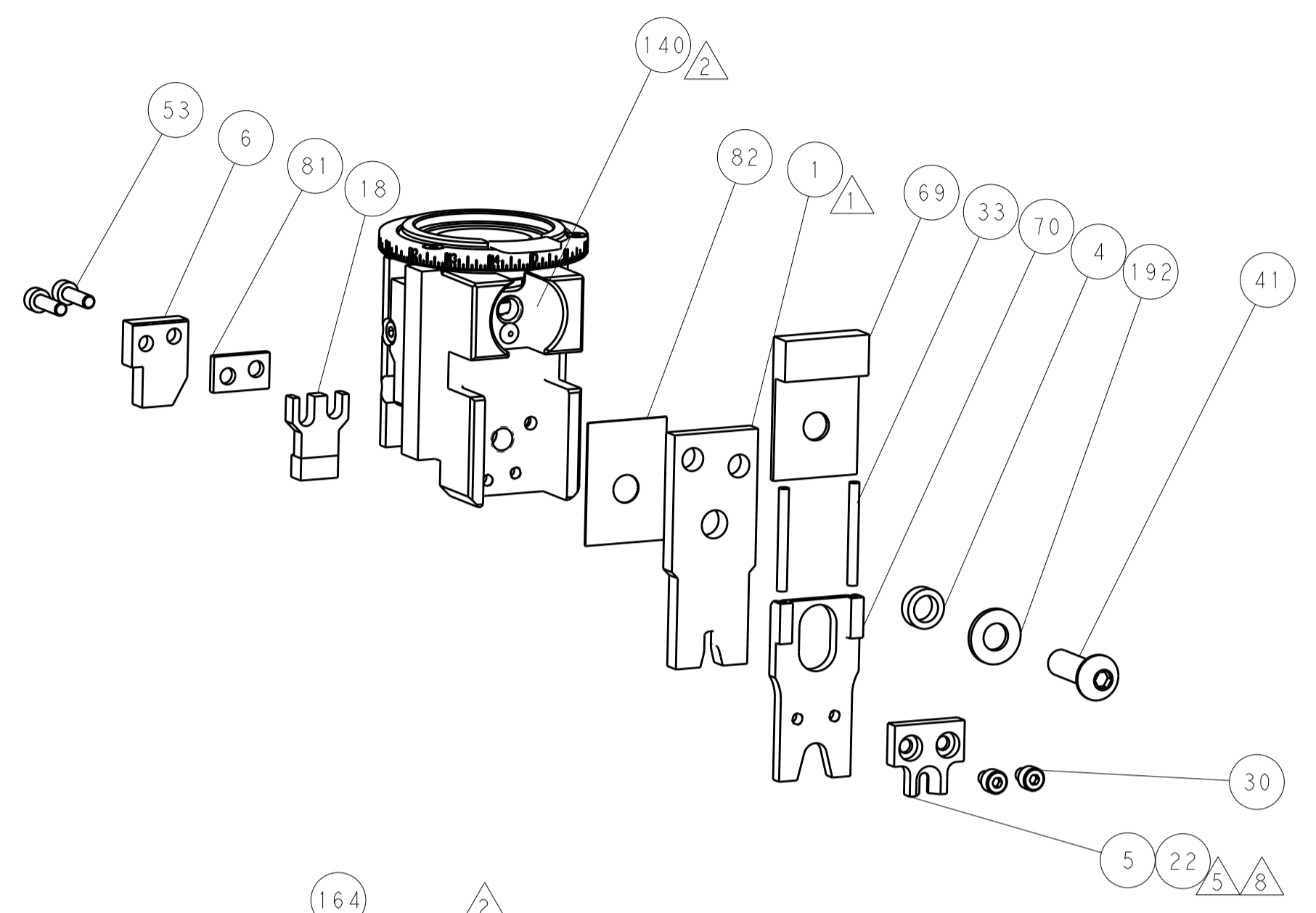


DETAIL A

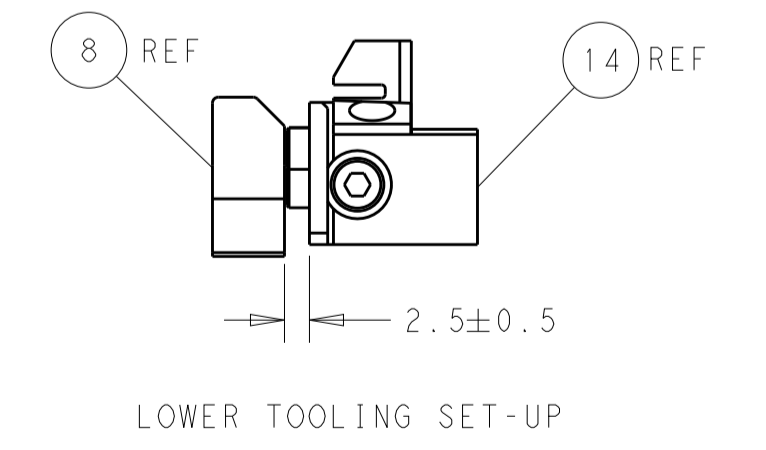
CAM POSITION



AIR FEED



RAM SET-UP



LOWER TOOLING SET-UP

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 2012. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS TO BE USED FOR THE EXCLUSIVE USE OF THE CUSTOMER. IT IS THE CUSTOMER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISIONS.</small>		DWN: B. WEAVER 15JUN2012 CHK: G. HOFENER 15JUN2012 APVD: T. ELBIN 15JUN2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151698	RESTRICTED TO: F
MATERIAL:		WEIGHT:	SCALE: 1:1 SHEET: 4 OF 4 REV: F