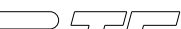
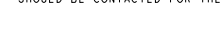


WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.35mm2			0.78+/-0.02 [0.031+/-0.001]		9.2
0.22mm2			0.70+/-0.02 [0.028+/-0.001]		10.4



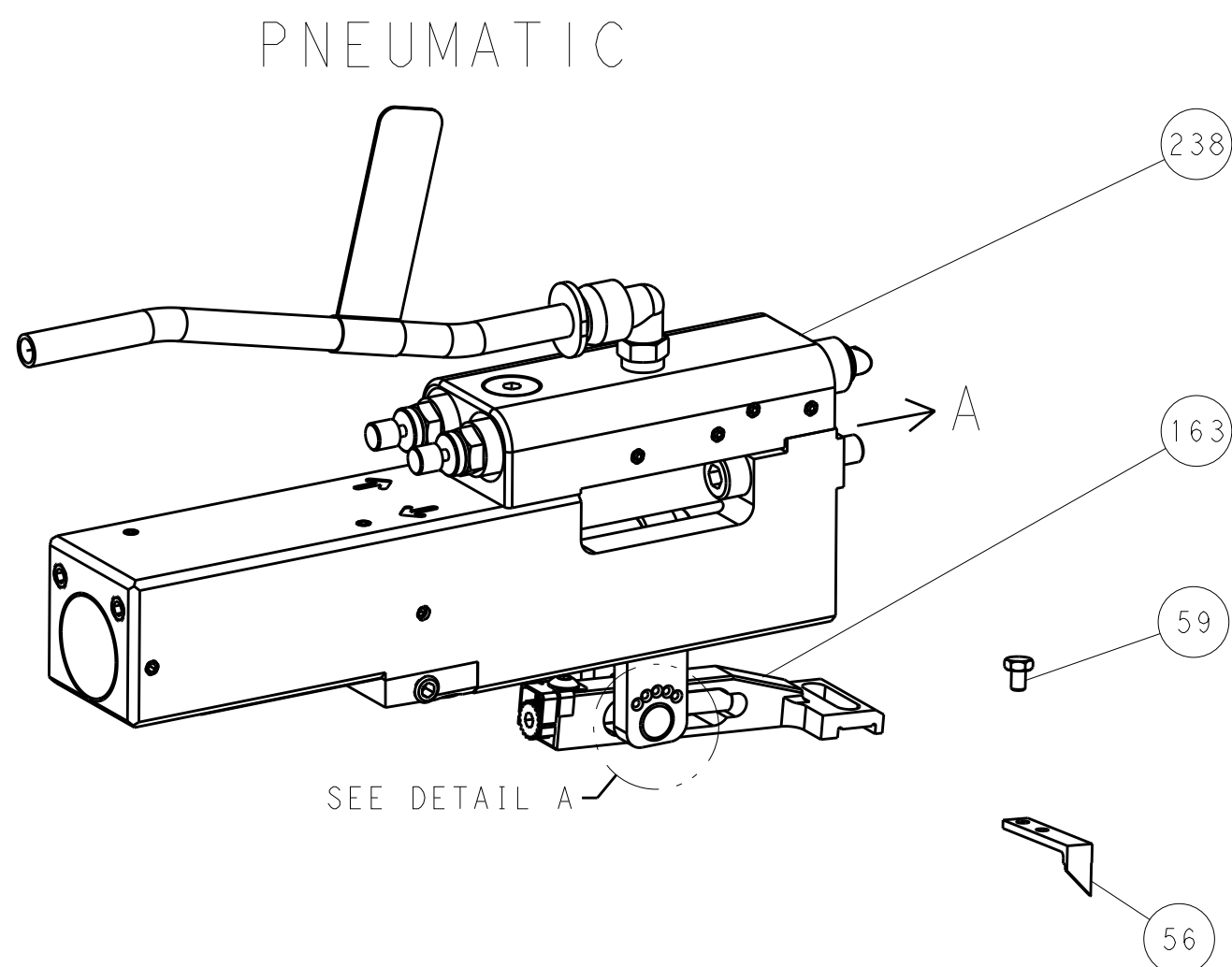
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1-22281-8	SPRING, 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	96
	-	1	1	1-690438-0	FRONT STRIP GUIDE	95
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-5	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	1-1803095-9	FLOATING SHEAR, FRONT -	9
1	1	2	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

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

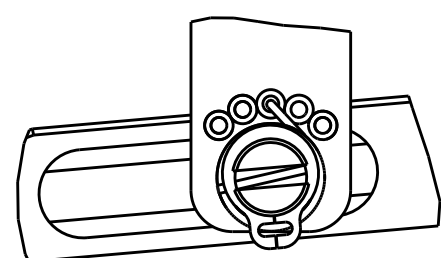
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DIMENSIONS: mm		TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC APPLICATION SPEC		SIZE CAGE CODE DRAWING NO A 1 00779 C=2151523	
MATERIAL -		FINISH -		RESTRICTED TO -	
		WEIGHT -		SCALE 1:2 SHEET 1 OF 4 REV J	
Customer Accessible Production Drawing					

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

FEED TYPE

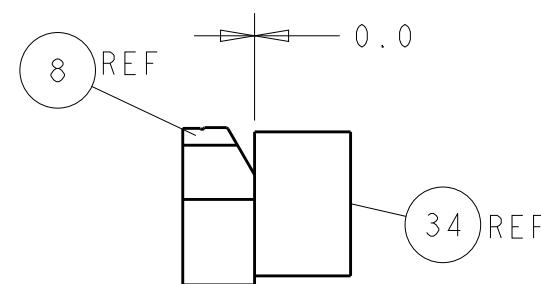
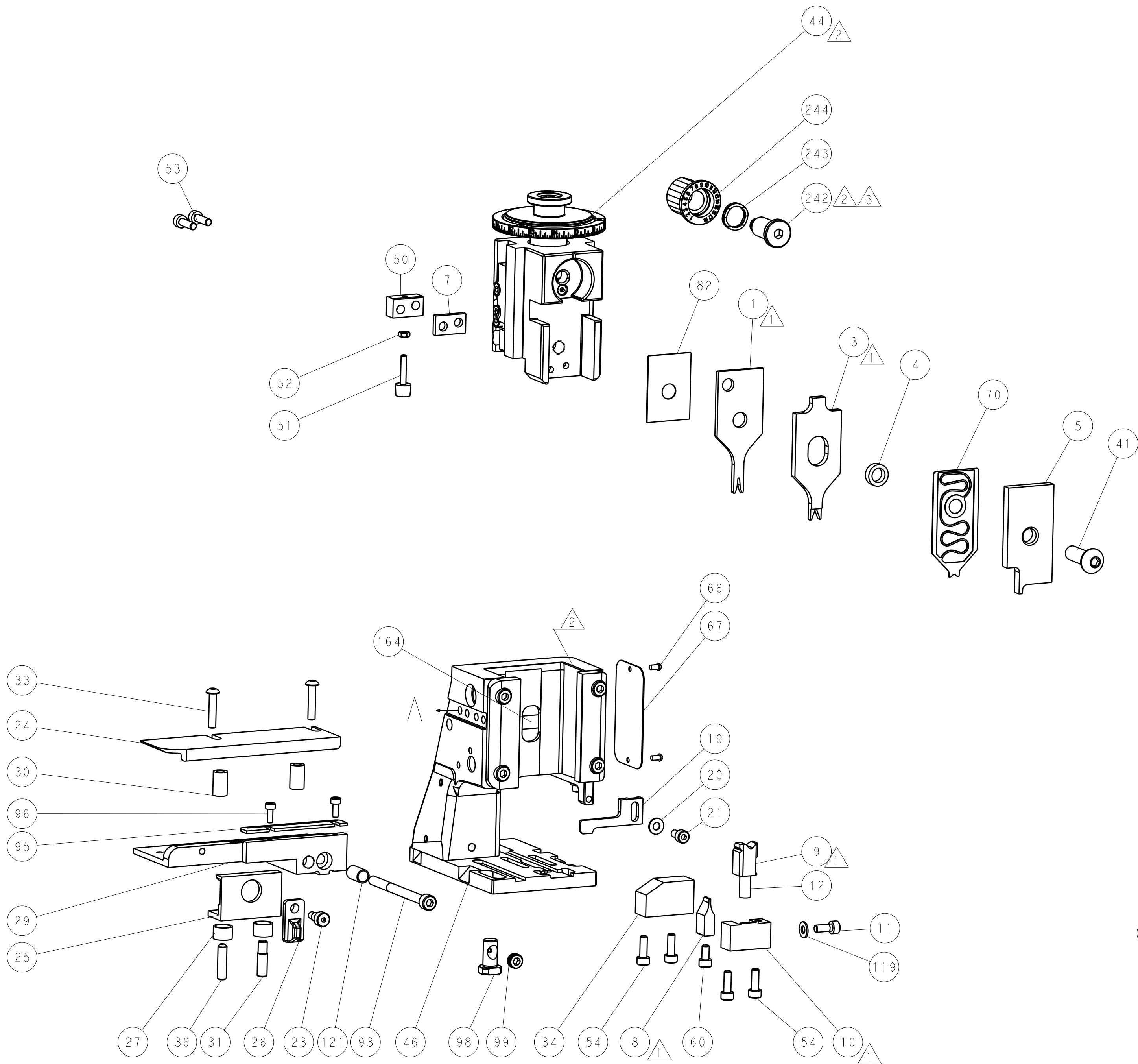
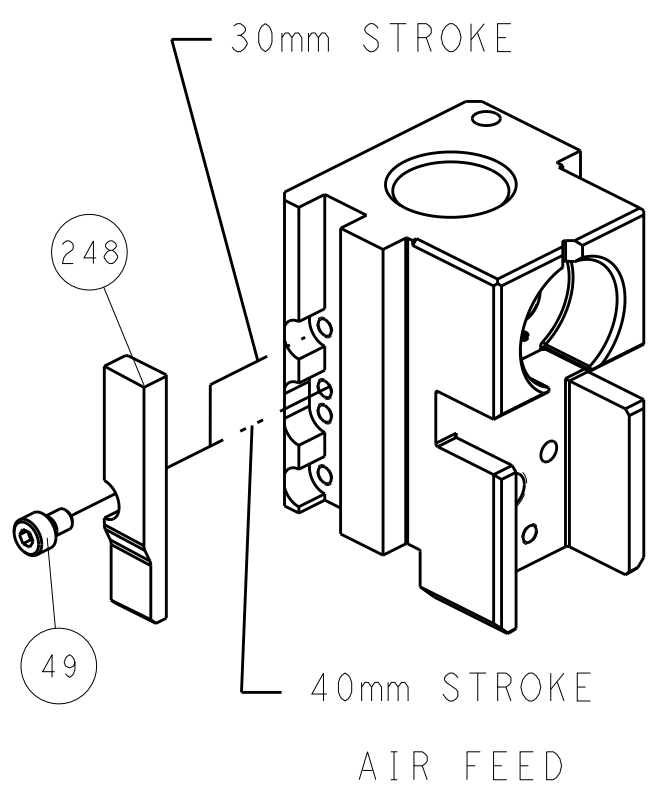


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

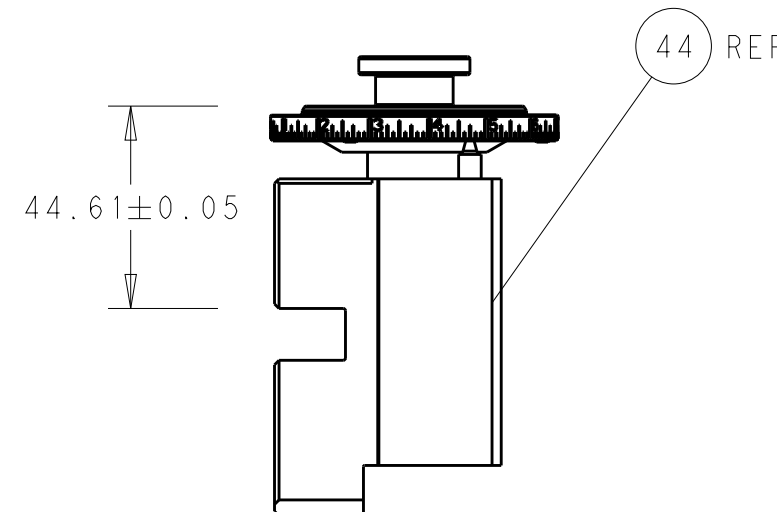


DETAIL A

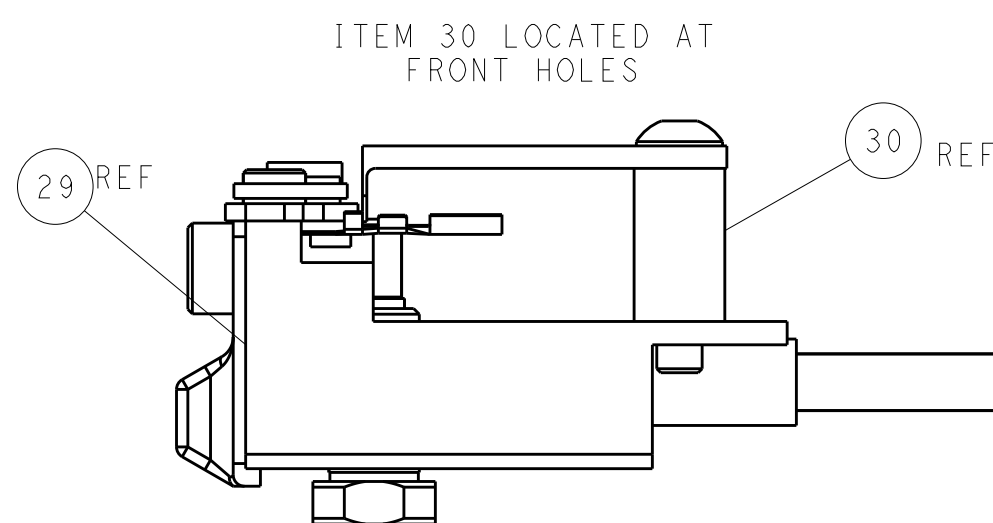
CAM POSITION



TERMINAL SUPPORT LOCATION

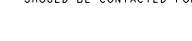


RAM SET-UP



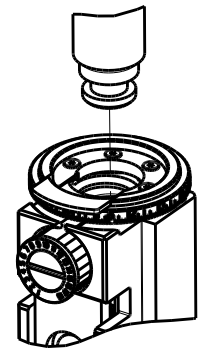
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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.		DWN: BOB HIGMAN 09MAY2013 CHK: G.BAILEY 09MAY2013 APVD: M.CLIFFORD 09MAY2013	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005	NAME: Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151523	
MATERIAL: -		FINISH: -	RESTRICTED TO: -	
		WEIGHT: -	Customer Accessible Production Drawing	
			SCALE: 1:2 SHEET: 2 of 4 REV: J	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151523-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151523-7	B	CRIMP TOOLING KIT	-



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 MOS TERMINAL			
WIRE STRIP LENGTH 3.25-3.55mm [.128-.140 IN]		INSULATION DIAMETER RANGE Ø 0.95-1.20mm [.037-.047 IN]	
TERMINAL APPLICATION 		(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 [0.031+/-0.001]		9.2
0.22mm2			0.70+/-0.02 [0.028+/-0.001]		10.4

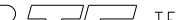


1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY 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.

```
*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.
```

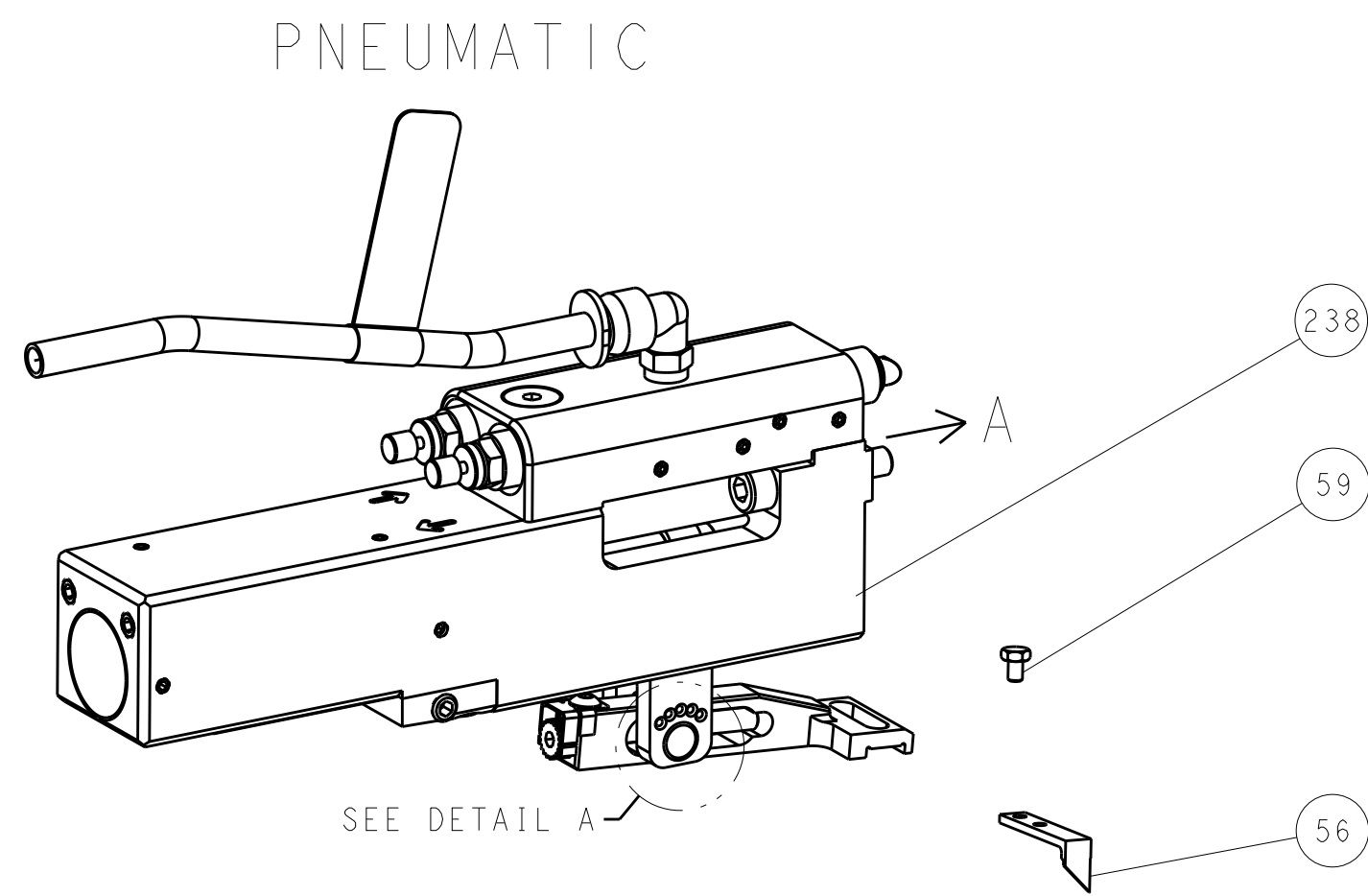
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

	-	1	219082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	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	2119791-5	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	10
1	-	1	1-1803095-9	FLOATING SHEAR, FRONT -	9
1	1	1	1-1633620-2	ANVIL, COMBINATION	8
	-	1	240641-7	SPACER	7
	-	-	-	-	6
	-	1	2119757-1	DEPRESSOR, SHEAR	5
	-	1	5-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1803143-2	CRIMPER, INSULATION O	3
	-	-	-	-	2
1	1	1	2-133281-7	CRIMPER, WIRE PREMIUM	1
	-77	-22	PART NO	DESCRIPTION	ITEM NO

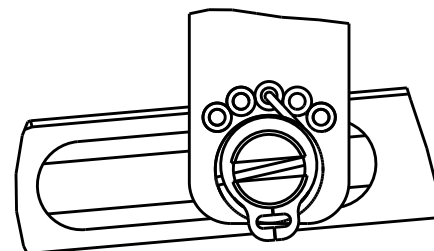
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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± ANGLES ±		PRODUCT SPEC - APPLICATION SPEC -	
		FINISH		SIZE CAGE CODE DRAWING NO A 1 00779 C=2151523	
MATERIAL -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing					
				SCALE 1:2 SHEET 3 OF 4 REV J	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

FEED TYPE

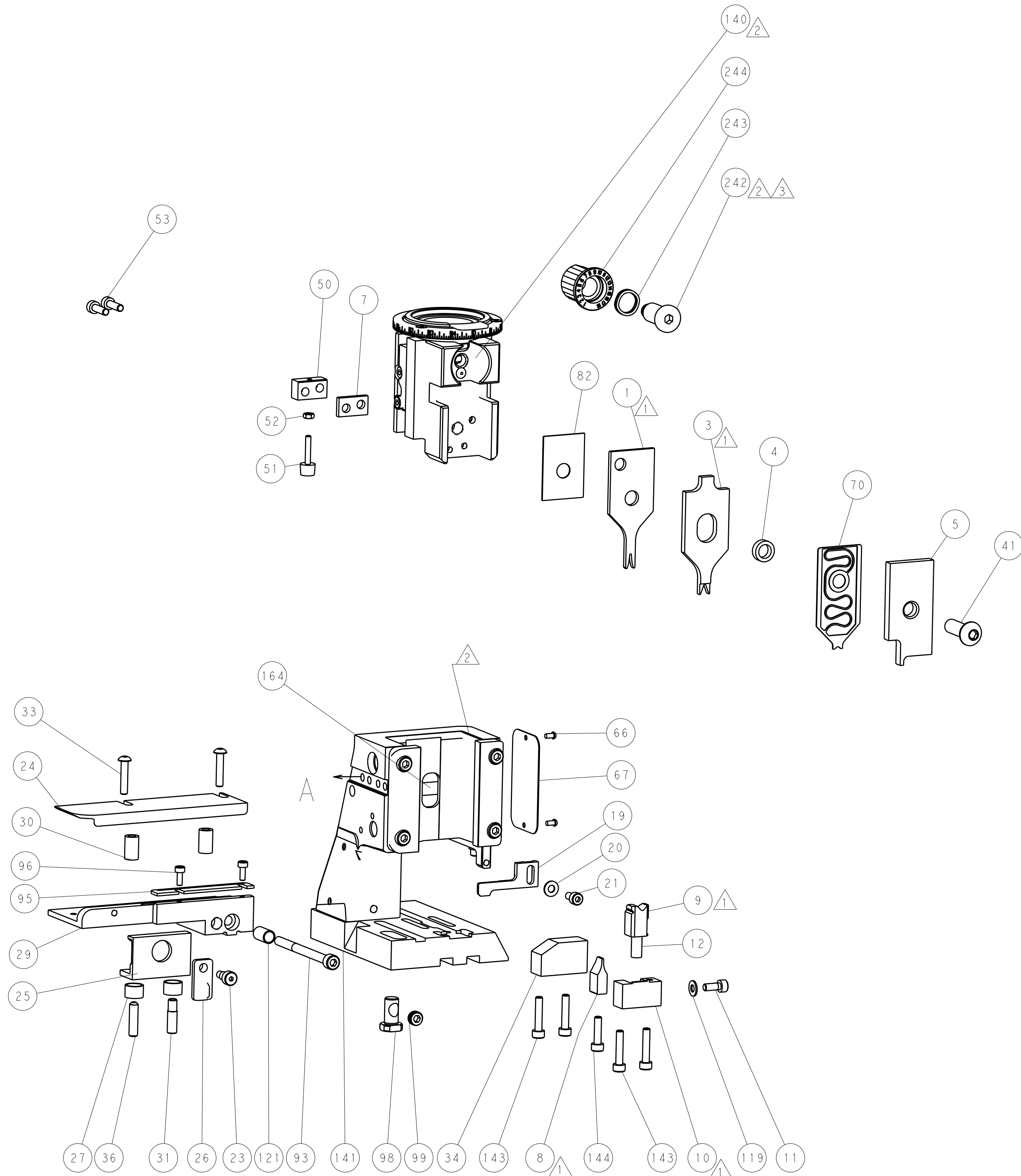
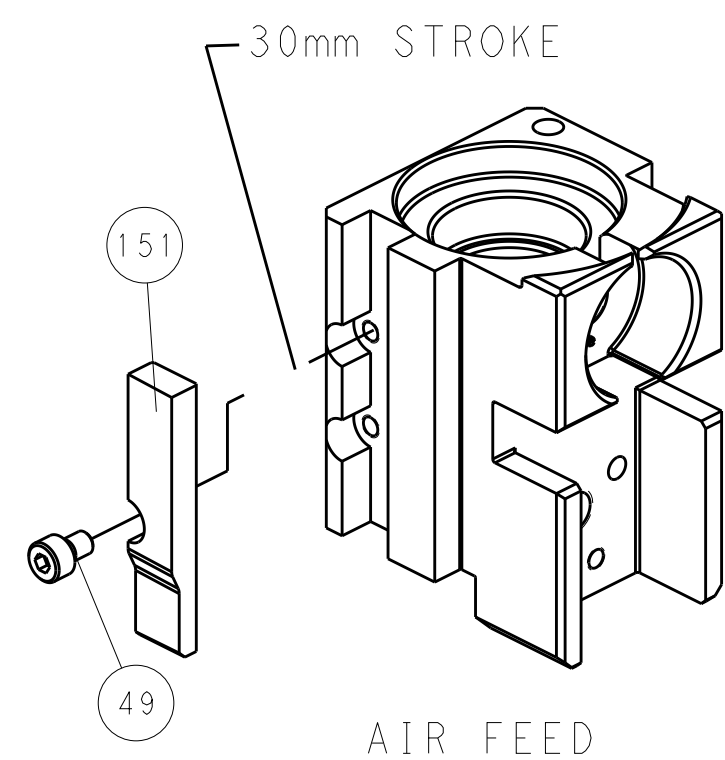


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

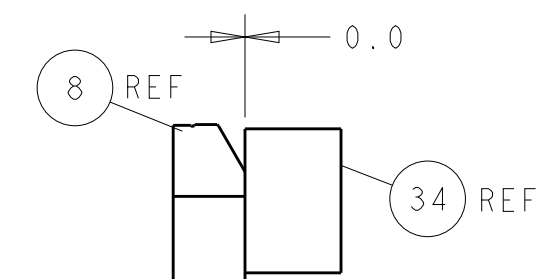


DETAIL A

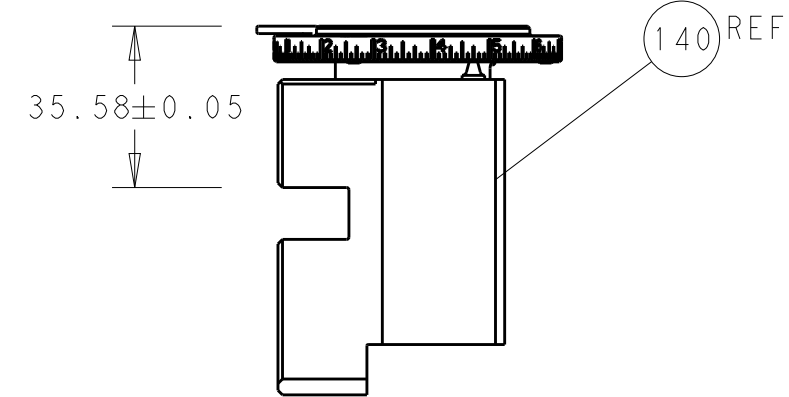
CAM POSITION



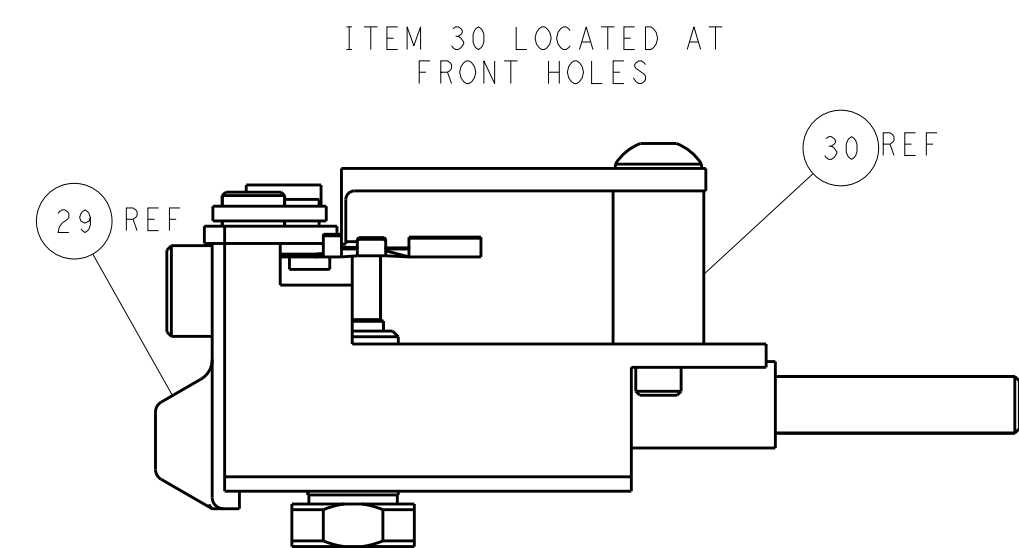
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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DIMENSIONS: mm		CHK G.BAILEY 09MAY2013	NAME Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD M.CLIFFORD 09MAY2013	SIZE A			
0 PLC ±		PRODUCT SPEC	CAGE CODE 00779			
1 PLC ±		APPLICATION SPEC	DRAWING NO C=2151523			
2 PLC ±		WEIGHT	Customer Accessible Production Drawing			
3 PLC ±		SCALE	1:2			
4 PLC ±		REVISIONS	SHEET 4 OF 4			
ANGLES ±		REV	J			
FINISH						