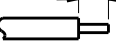


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151541-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151541-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151541-2	G	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151541-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151541-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151541-7	C	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-35042		

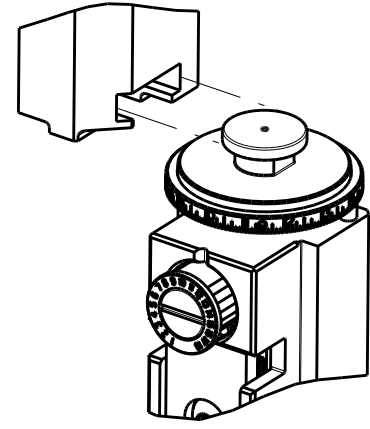
TERMINAL DATA: TE TERMINAL		TE SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM			
WIRE STRIP LENGTH 3.05-3.35 mm [.120-.132 IN]		 INSULATION DIAMETER RANGE Ø1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-18021 (B)114-61024		 - -	
TERMINALS APPLIED			
GROUP 1 		GROUP 2 	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 5-928999-5	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 5-928999-6	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 6-928999-5	(A) 1394702-2	(B) 2005119-1	(A) 1241918-1
(A) 928918-1	(A) 5-1394702-1		
(A) 928918-2	(A) 5-1394702-2		
(A) 1-928918-1	(A) 968893-1		
(A) 1-928918-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.76+/-0.03 [.030+/- .001]	9.3
0.25mm2	0.72+/-0.03 [.028+/- .001]	10.0
0.20mm2	0.72+/-0.03 [.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 REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm² WIRE.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

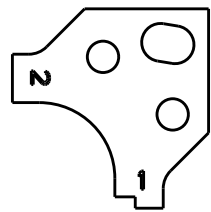
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



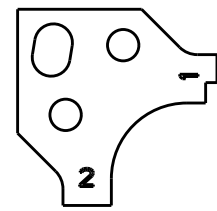
TERMINAL DATA: TE TERMINAL		TE SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM			
WIRE STRIP LENGTH 3.05-3.35 mm [.120-.132 IN]		INSULATION DIAMETER RANGE Ø 1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-18021 (B)114-61024			
TERMINALS APPLIED			
GROUP 1 		GROUP 2 	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 5-928999-5	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 5-928999-6	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 6-928999-5	(A) 1394702-2		(A) 1241918-1
(A) 928918-1	(A) 5-1394702-1		
(A) 928918-2	(A) 5-1394702-2		
(A) 1-928918-1	(A) 968893-1		
(A) 1-928918-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.92+/-0.03 [.036+/- .001]	8.3

7 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS, REFER TO SHEET 2.



8 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS, REFER TO SHEET 2.



9 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.

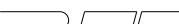
*WARNING

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)

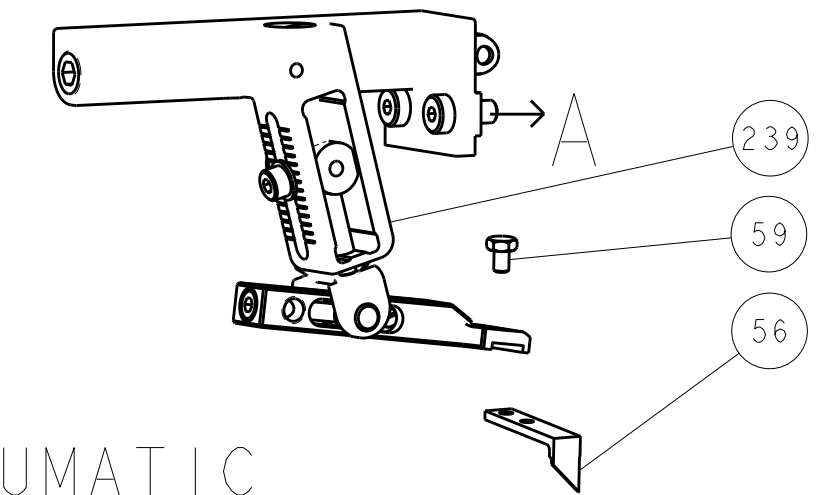
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		E1		ECR-19-005671	09APR2019	WEH	CT
		F		ECR-19-006015	15APR2019	FJ	CT
		G		ECR-19-012198	02AUG2019	FZ	RK

9	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
8	-	1	1	1	1	1	1-240641-3	SPACER	81
7	-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
	-	1	1	1	1	1	1633782-2	FENCE	78
	-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
	-	1	1	1	1	1	2119740-1	TAG IDENTIFICATION	67
	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	1	1338685-1	PAWL, FEED	56
	-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
9	-	1	2	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	-	1	-	-	1	2119653-1	FEED CAM, POST FEED	47
	-	1	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
8	-	1	1	1	1	1	2217529-1	TERMINAL HOLD DOWN	18
7	-	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	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	1	1333233-1	ANVIL, COMBINATION, SPECIAL	8
8	-	1	1	1	1	1	4-240641-2	SPACER	7
	-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	2	2	1	1	1	5-568176-3	CRIMPER, WIRE	1

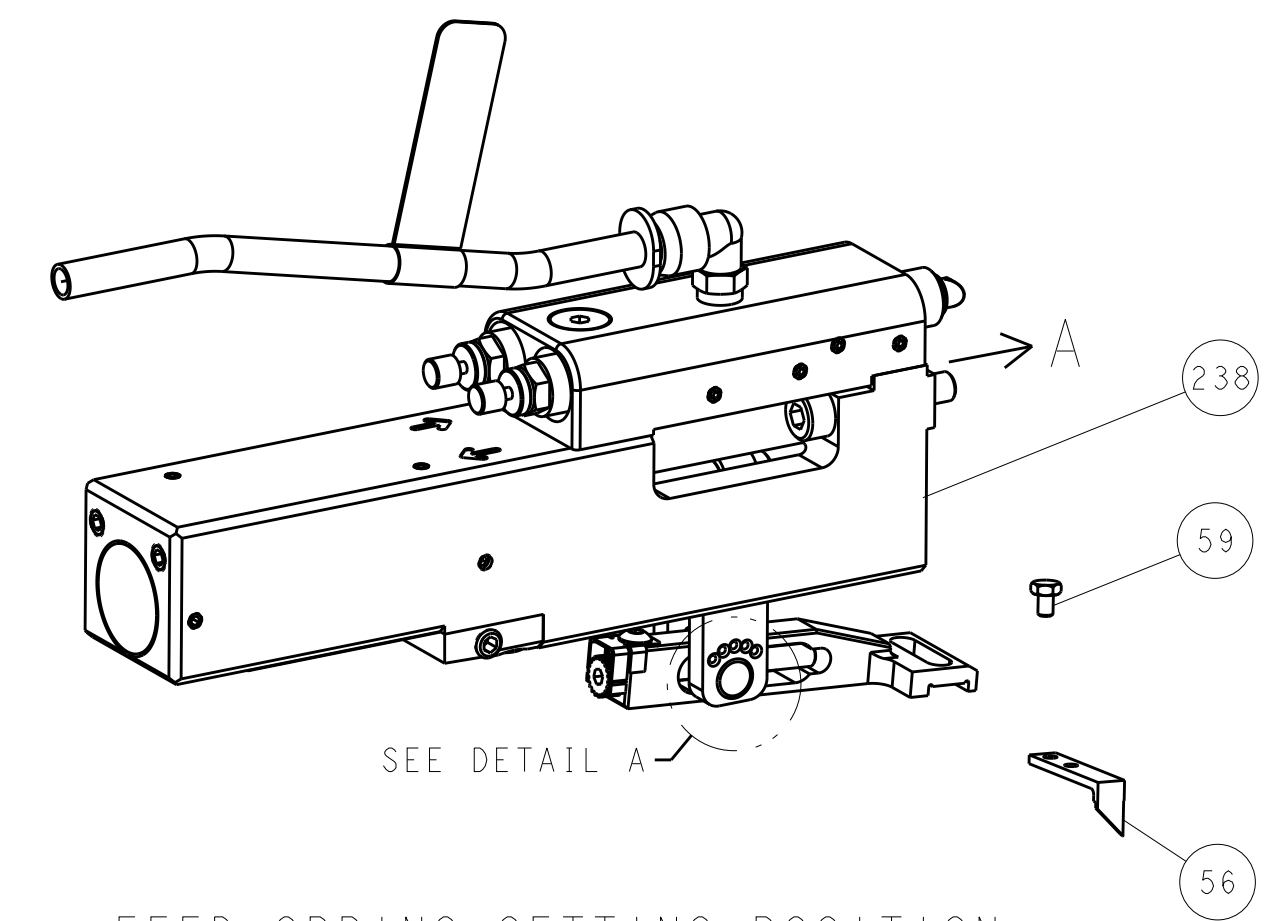
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.				DWN	HOFFNER	07DEC2001	 TE Connectivity Harrisburg, PA 17105-3608				
DIMENSIONS:				CHK	T.ELBIN	08DEC2011	NAME				
mm				APVD	T.ELBIN	08DEC2011	Ocean Side Feed Applicator				
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC		SIZE					
0 PLC ±				APPLICATION SPEC		CASE CODE					
1 PLC ±				MATERIAL		DRAWING NO					
2 PLC ±				FINISH		RESTRICTED TO					
3 PLC ±				WEIGHT		A1 00779 ©=2151541					
4 PLC ±				CUSTOMER DRAWING		SCALE					
ANGLES				SHEET		1 OF 4					
REV				REV		G					
											
MATERIAL				FINISH		WEIGHT					
-				-		-					

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

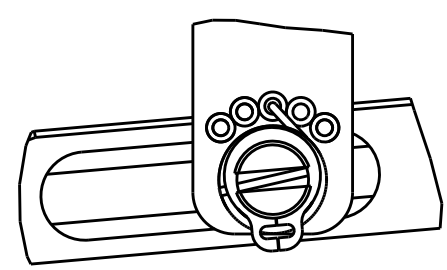
FEED TYPE MECHANICAL



PNEUMATIC

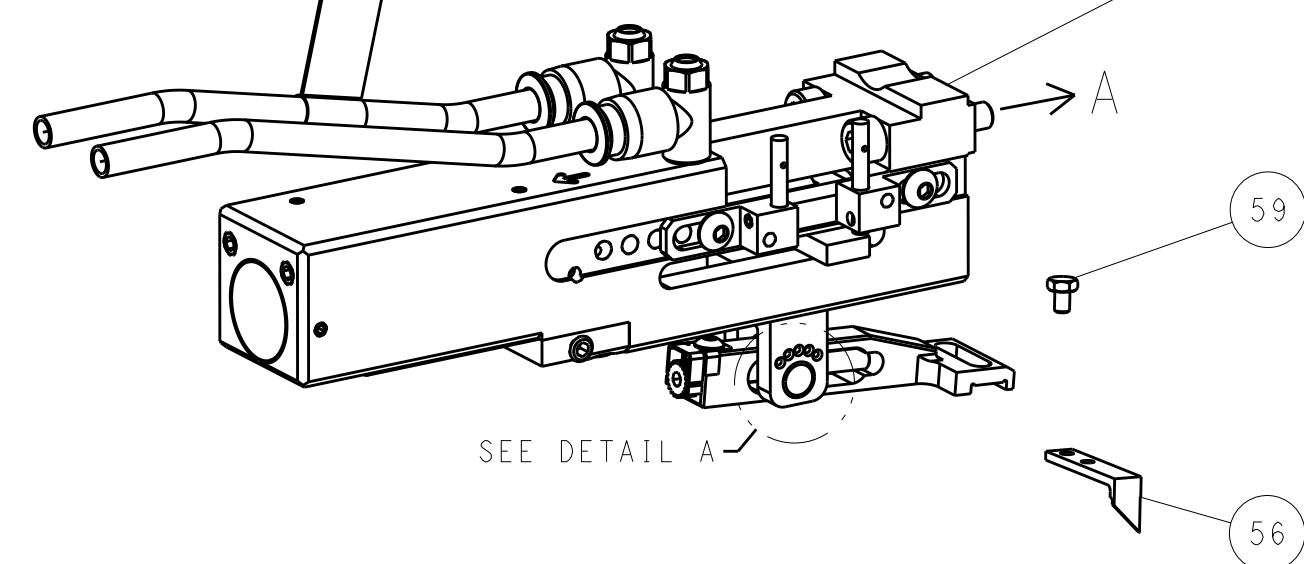


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

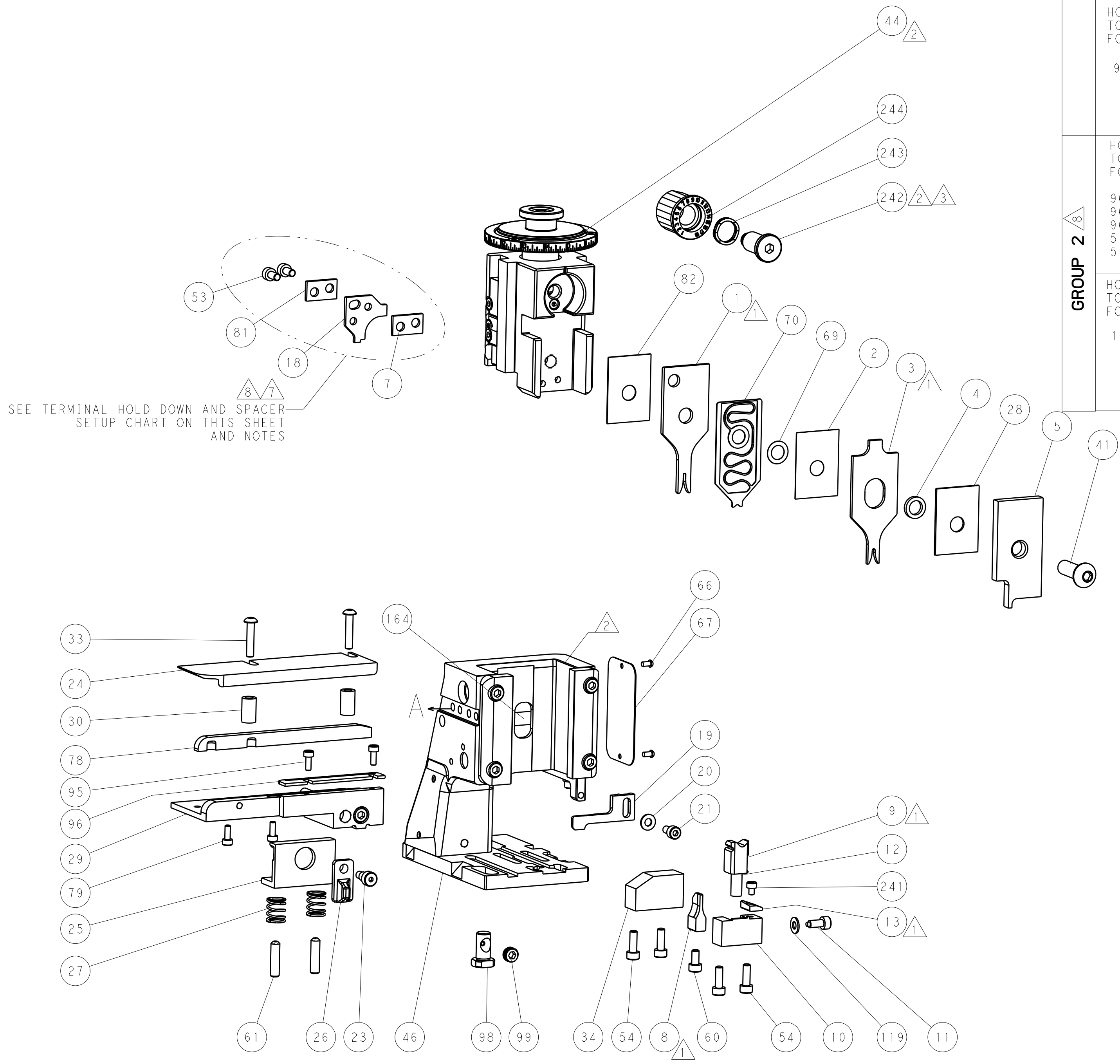
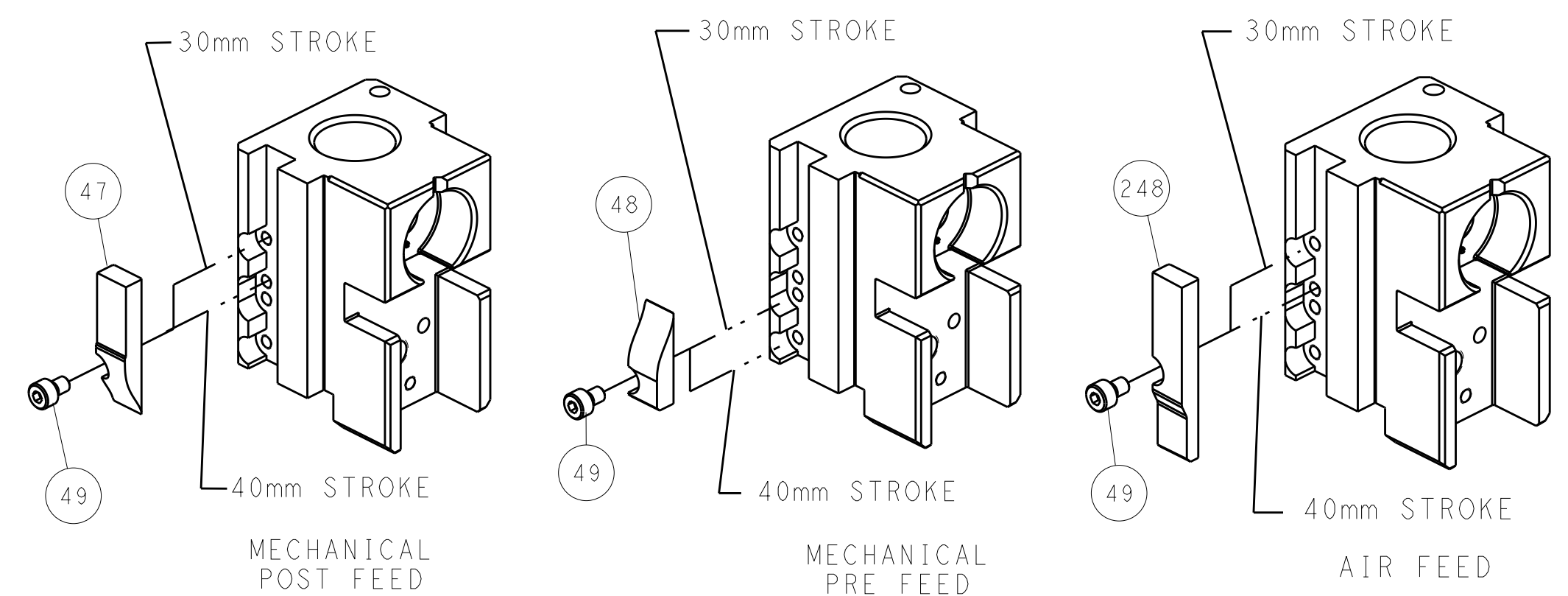


DETAIL A

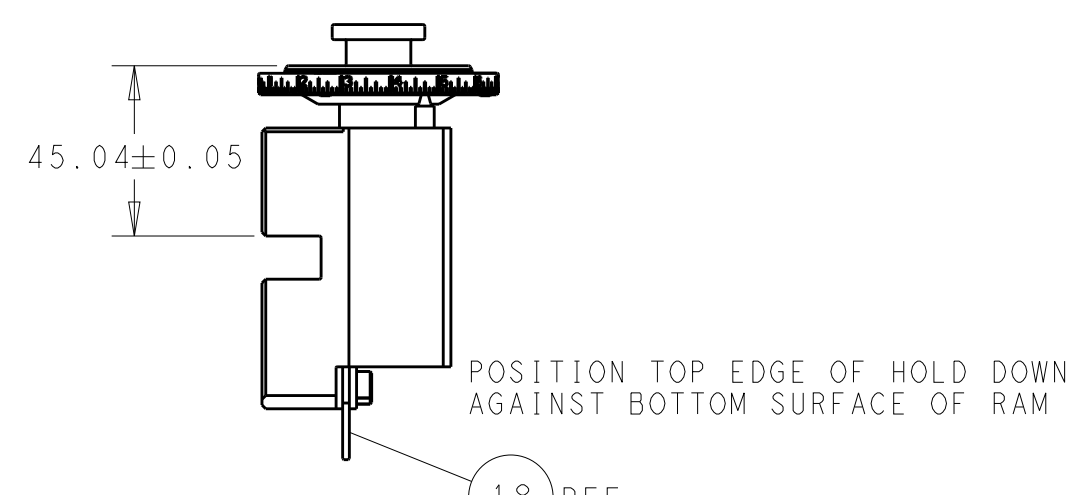
DOUBLE ACTING PNEUMATIC WITH SENSORS



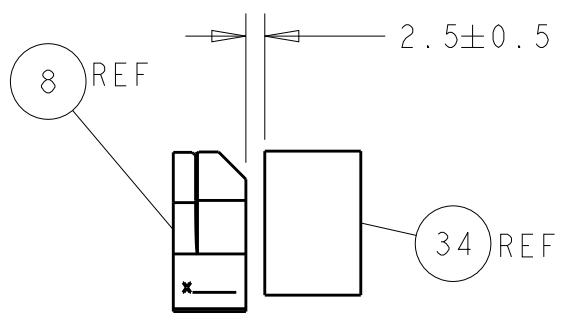
CAM POSITIONS



GROUP 1		GROUP 2	
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 928999-1 928999-5 928999-6 5-928999-1 5-928999-5 5-928999-6 6-928999-5 928918-1 928918-2 1-928918-1 1-928918-2		HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 968893-1 HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 968220-1 968220-5 968220-6 5-968220-1 5-968220-5	
2-928918-2 3-928918-2 5-928918-1 6-928918-1 6-928918-2 6-928918-3 1394702-1 1394702-2 5-1394702-1 5-1394702-2		5-968220-6 1703296-1 1703296-5 1534116-1 1534116-2 5-1534116-1	
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 1241918-1		HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 1241918-1	

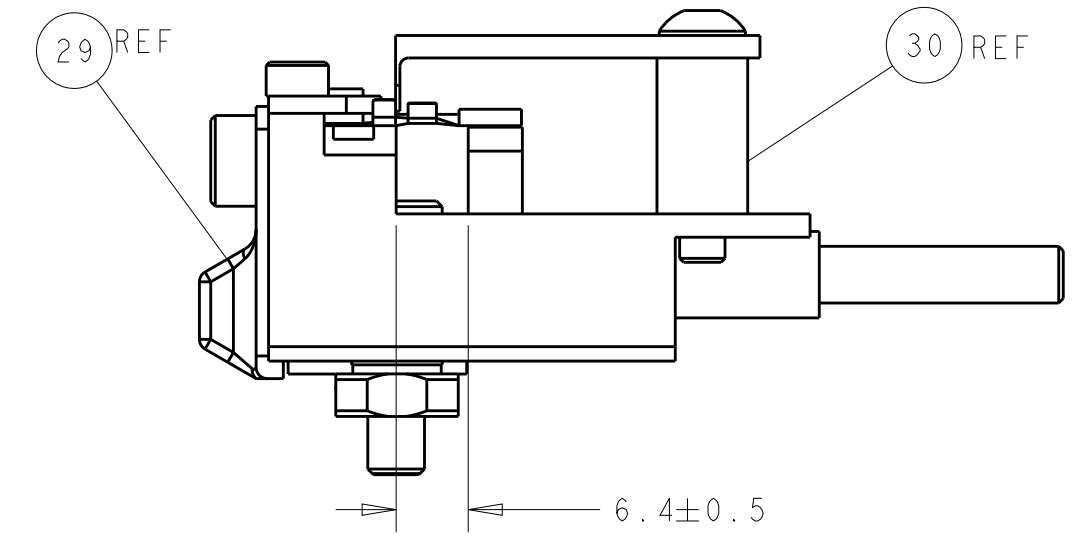


RAM AND HOLD DOWN SET-UP



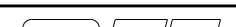
TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT
FRONT HOLES



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)

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DIMENSIONS:				CHG: ELBIN 08DEC2011			
mm				APVD: T. ELBIN 08DEC2011		NAME	

8		7	
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20		20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151541-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151541-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151541-2	G	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151541-7	C	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-35042		

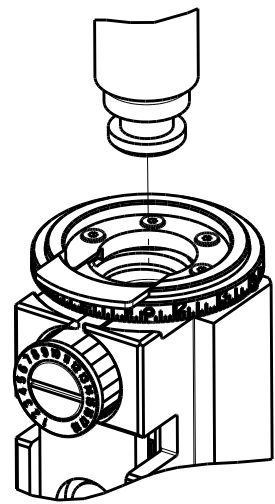
TERMINAL DATA: TE TERMINAL		TE SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.05-3.35 mm [.120-.132 IN]			Ø1.15-1.60 mm [.045-.063 IN]
TERMINAL APPLICATION	(A)114-18021	-	-
SPECIFICATION	(B)114-61024	-	-
TERMINALS APPLIED			
GROUP 1 		GROUP 2 	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
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(A) 5-928999-6	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 6-928999-5	(A) 1394702-2	(B) 2005119-1	(A) 1241918-1
(A) 928918-1	(A) 5-1394702-1		
(A) 928918-2	(A) 5-1394702-2		
(A) 1-928918-1	(A) 968893-1		
(A) 1-928918-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.76+/-0.03 [.030+/- .001]	9.3
0.25mm2	0.72+/-0.03 [.028+/- .001]	10.0
0.20mm2	0.72+/-0.03 [.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 REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm² WIRE.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

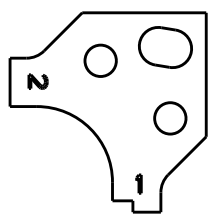
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



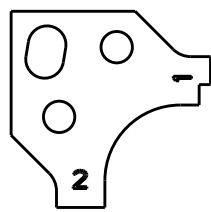
TERMINAL DATA: TE TERMINAL		TE SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM			
WIRE STRIP LENGTH 3.05-3.35 mm [.120-.132 IN]		INSULATION DIAMETER RANGE Ø 1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION		(A)114-18021 (B)114-61024	
			
TERMINALS APPLIED			
GROUP 1 		GROUP 2 	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 5-928999-5	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 5-928999-6	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 6-928999-5	(A) 1394702-2		(A) 1241918-1
(A) 928918-1	(A) 5-1394702-1		
(A) 928918-2	(A) 5-1394702-2		
(A) 1-928918-1	(A) 968893-1		
(A) 1-928918-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.92+/-0.03 [.036+/- .001]	8.3

7 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS, REFER TO SHEET 2.



8 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS, REFER TO SHEET 2.



9 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.

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

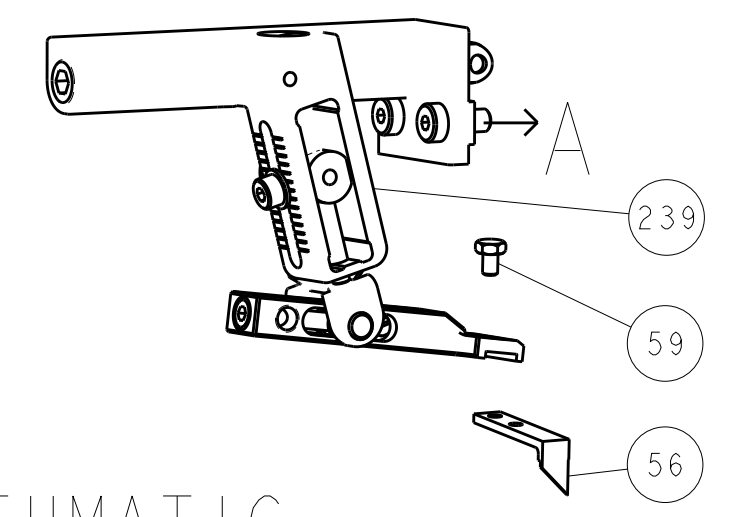
LOC		DIST		REVISONS			
A		66		P	LTR	DESCRIPTION	DATE
						SEE SHEET 1	

-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	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
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1-240641-3	SPACER	81
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1633782-2	FENCE	78
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	2119943-1	WASHER, SPACER	69
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	2217529-1	TERMINAL HOLD DOWN	18
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1333233-1	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	4-240641-2	SPACER	7
-	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	5-568176-3	CRIMPER, WIRE	1
-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO

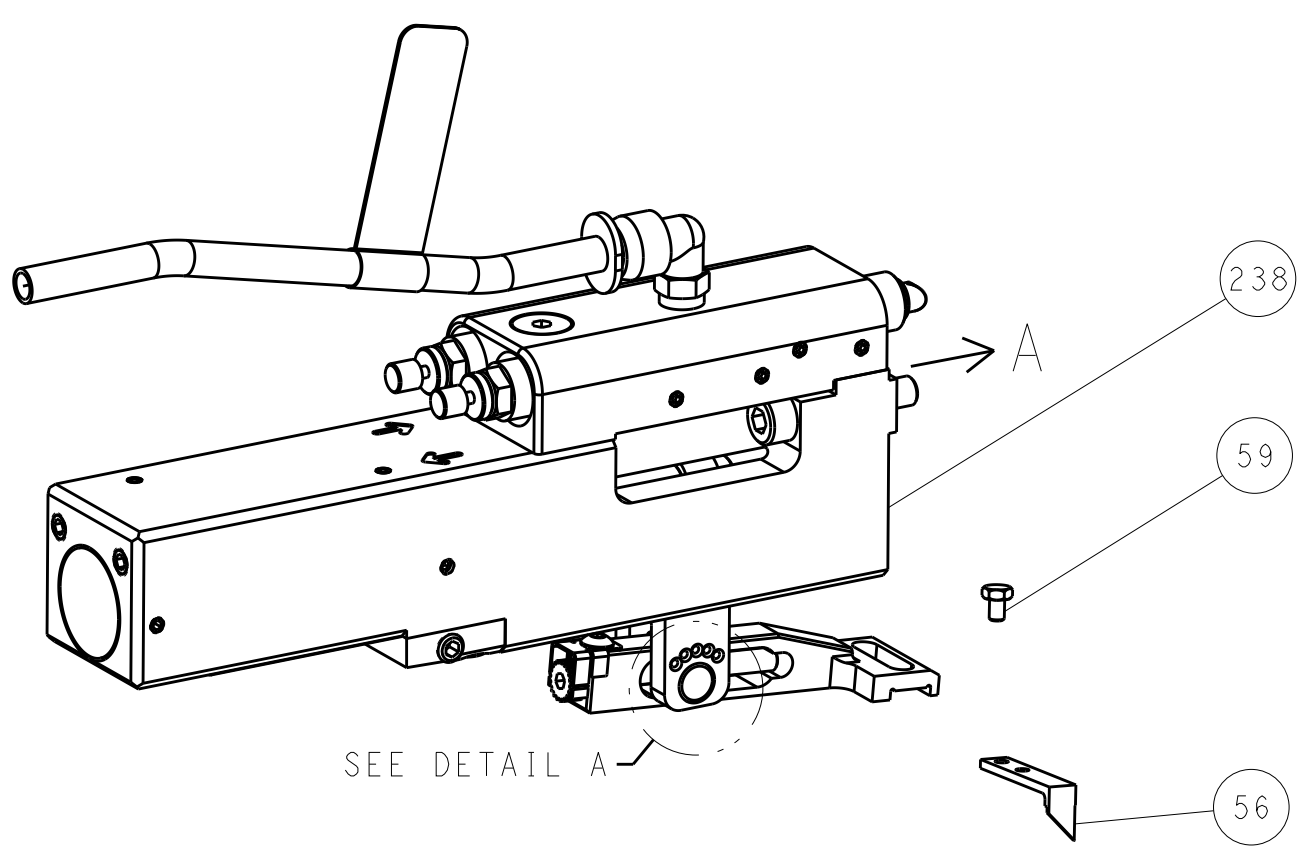
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF ANY KIND. THE USER SHALL BE CONTACTED FOR THE LATEST EDITION.		DWN	HOFFNER	07DEC2001	TE Connectivity		
		CHK	T.ELBIN	08DEC2011	Harrisburg, PA 17105-3608		
		APVD	T.ELBIN	08DEC2011	NAME Ocean Side Feed Applicator -		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC			
mm		0 PLC ±.005		APPLICATION SPEC			
		1 PLC ±.005		SIZE			
		2 PLC ±.005		CAGE CODE			
		3 PLC ±.005		DRAWING NO			
		4 PLC ±.005		RESTRICTED TO			
		ANGLES		MATERIAL			
		FINISH		WEIGHT			
				CUSTOMER DRAWING			
				SCALE			
				1:1			
				SHEET 3 OF 4			
				REV G			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

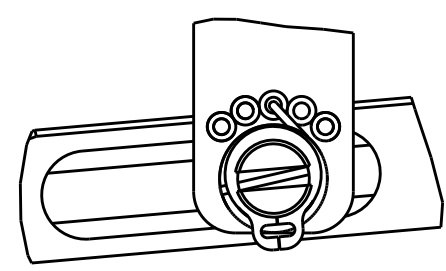
FEED TYPE MECHANICAL



PNEUMATIC

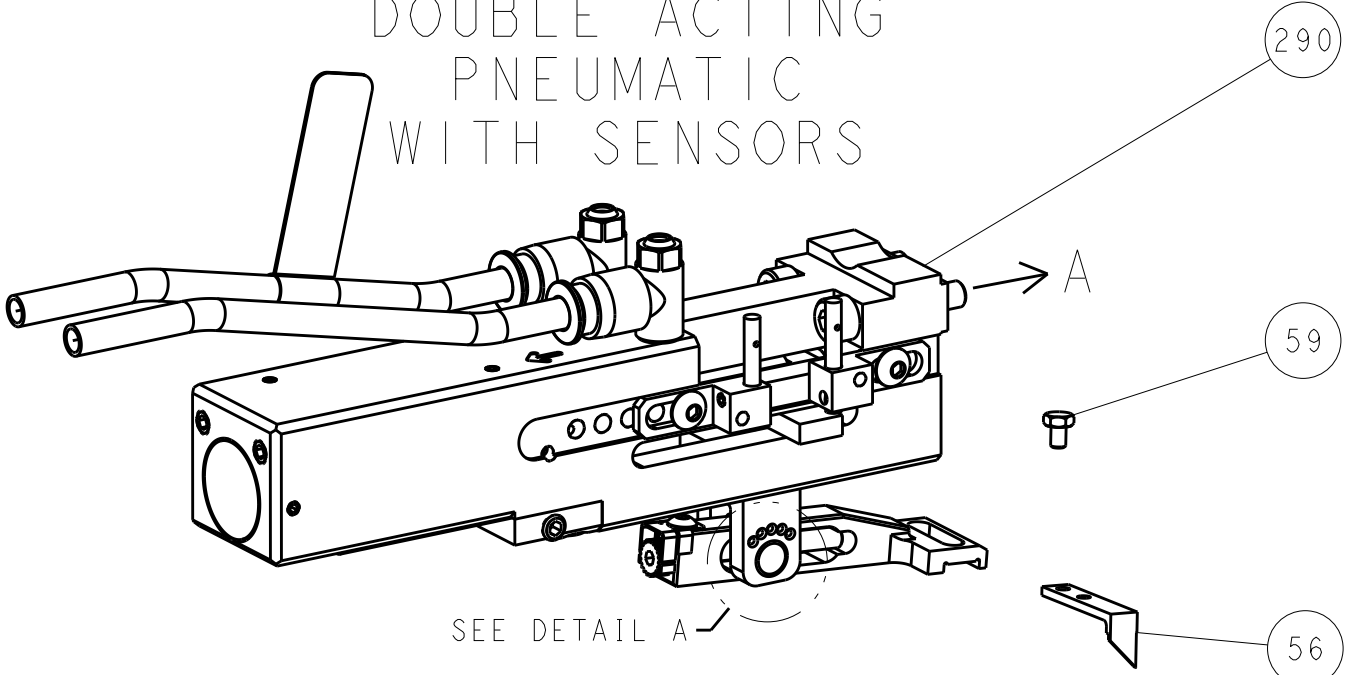


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



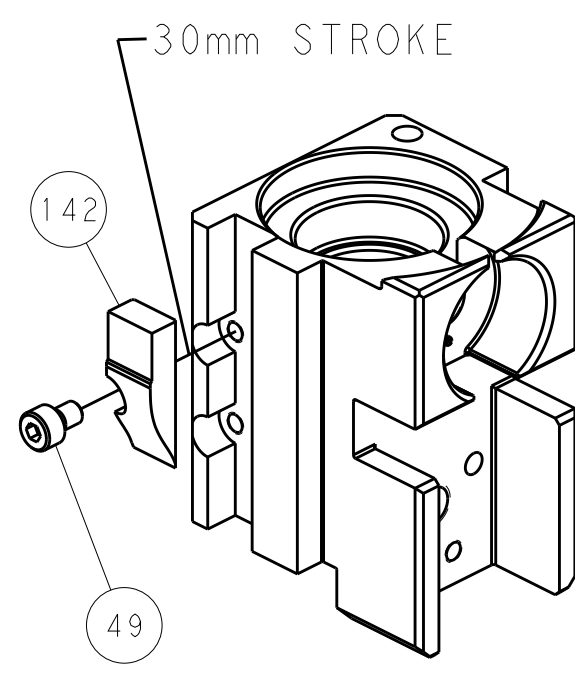
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

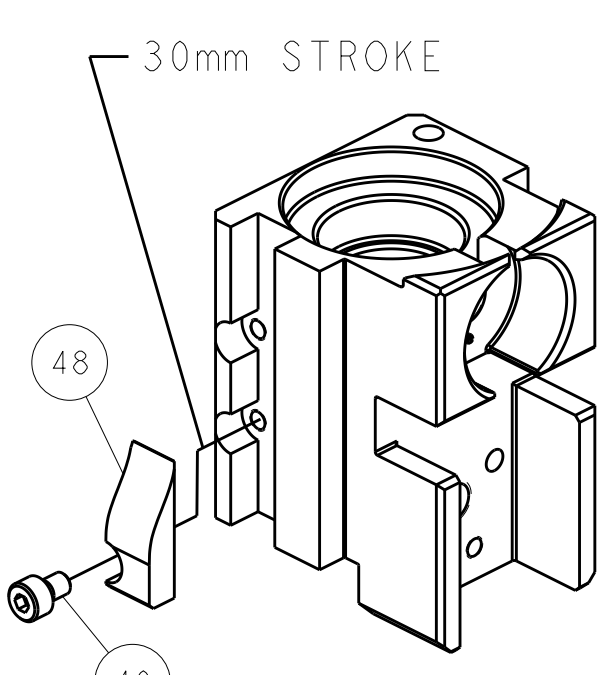


SEE DETAIL A

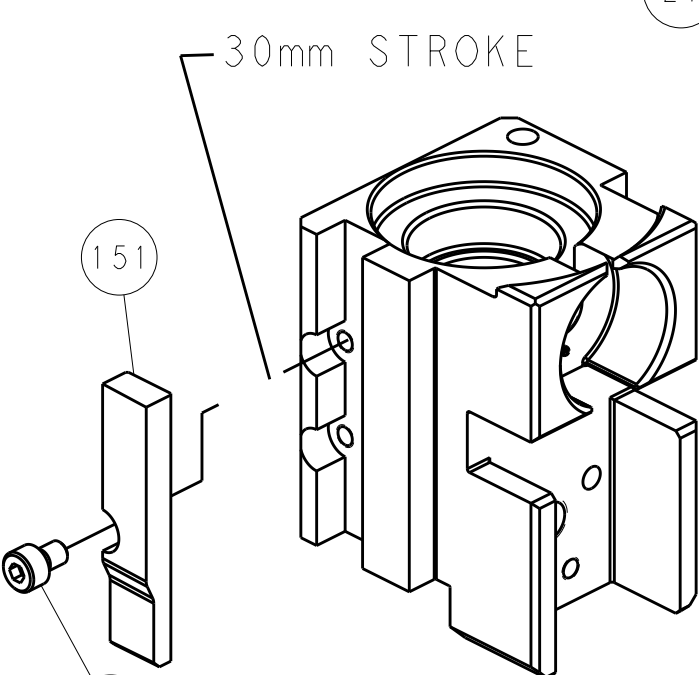
CAM POSITIONS



MECHANICAL
POST FEED

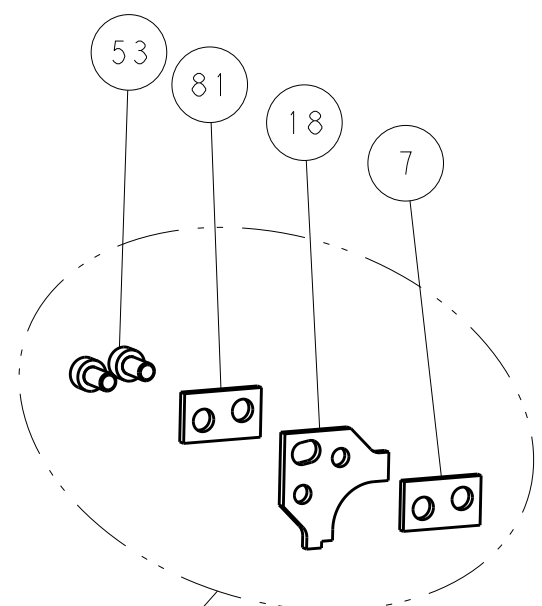


MECHANICAL
PRE FEED

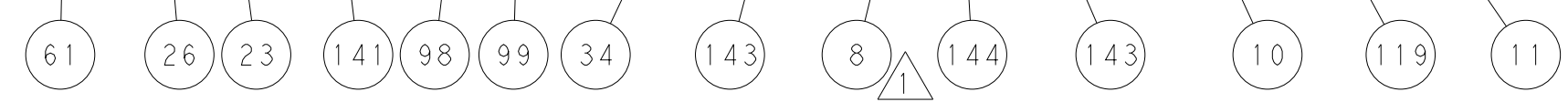
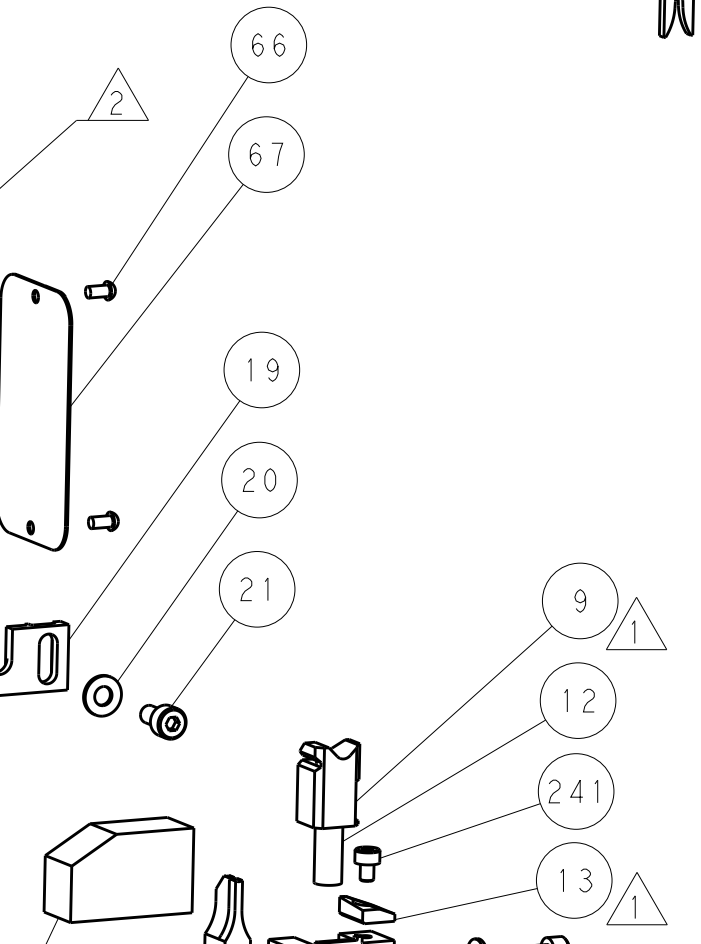
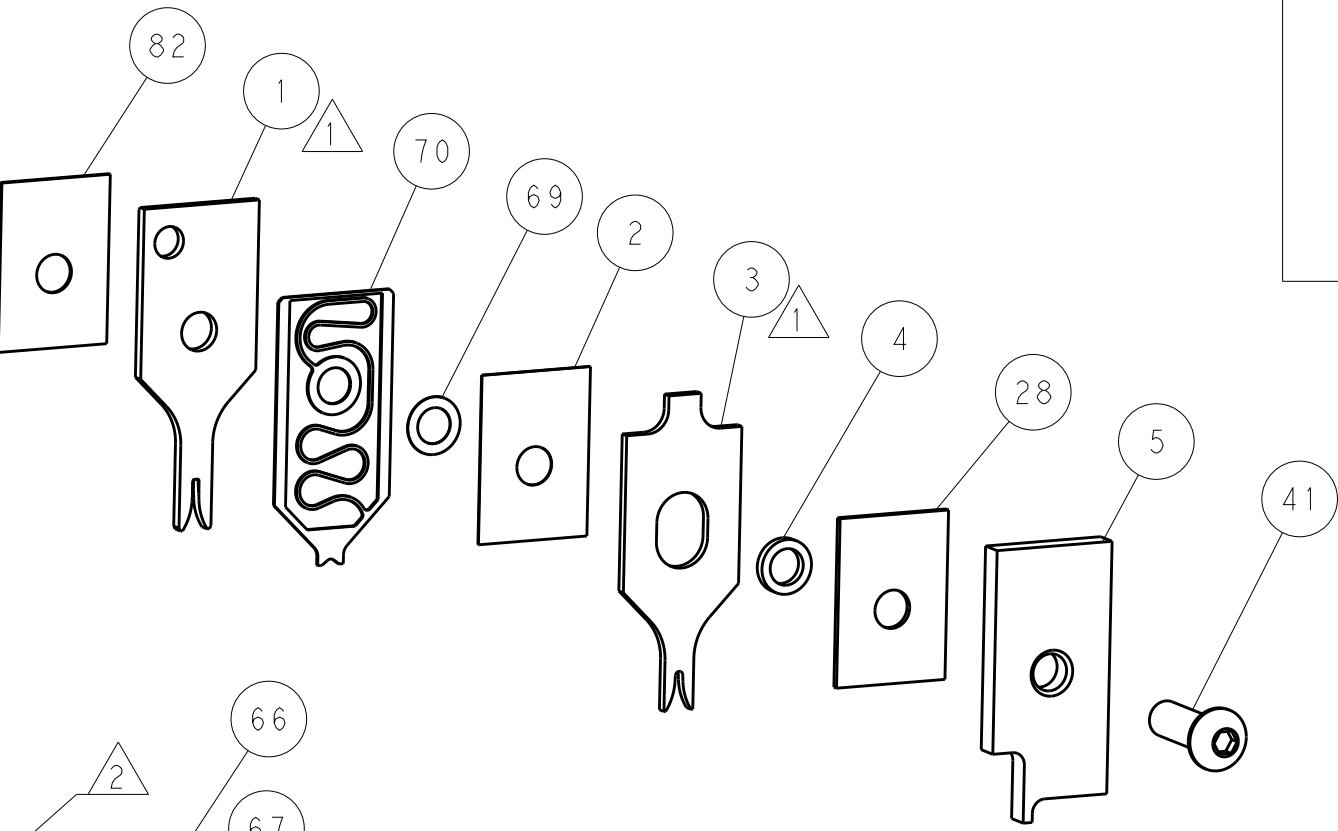
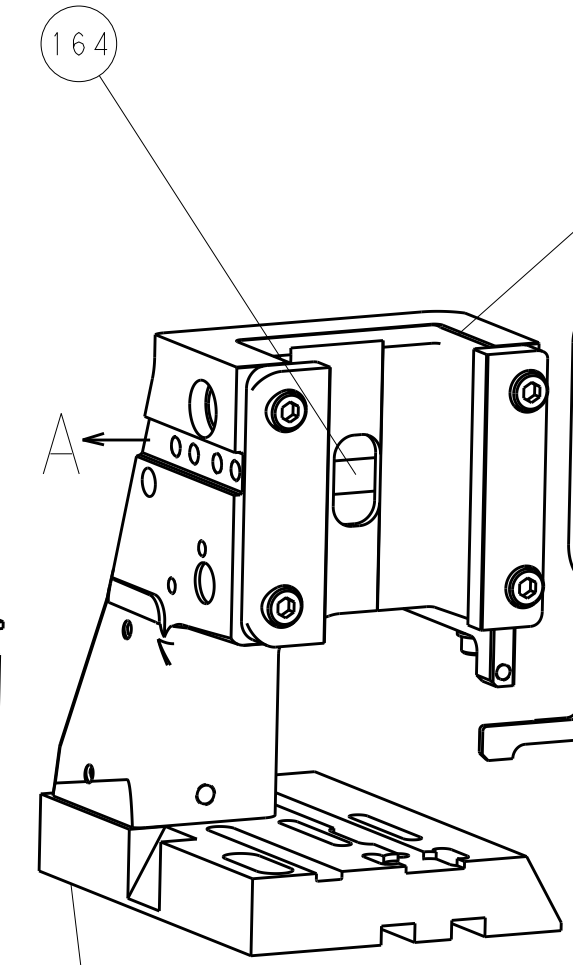
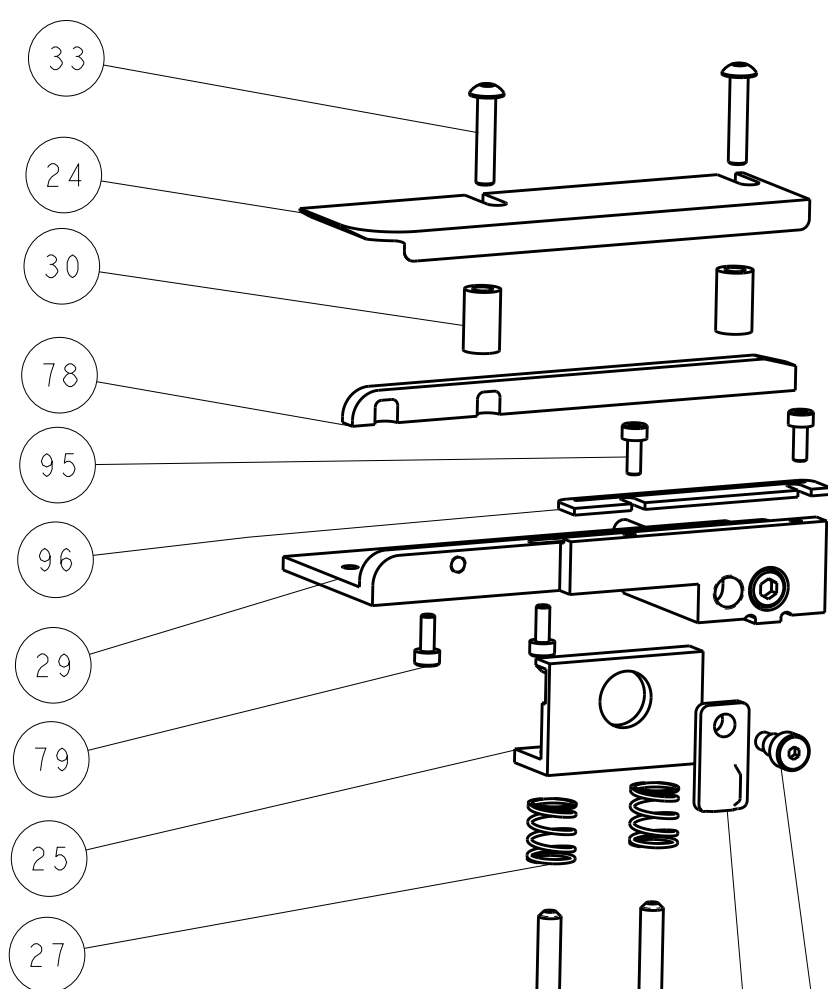


AIR FEED

SEE TERMINAL HOLD DOWN AND SPACER
SETUP CHART ON THIS SHEET
AND NOTES



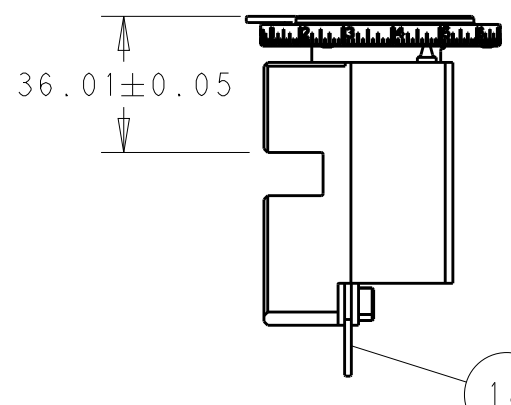
7/8



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

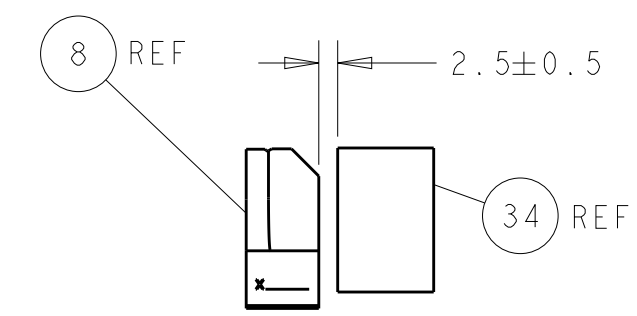
LOC		DIST		REV		DATE		BY		CHKD	
A		66		-		-		-		-	
-		-		-		-		-		-	
-		-		-		-		-		-	
-		-		-		-		-		-	

GROUP 1		GROUP 2	
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 928999-1 2-928918-2 928999-5 3-928918-2 928999-6 5-928918-1 5-928999-1 6-928918-1 5-928999-5 6-928918-2 5-928999-6 6-928918-3 6-928999-5 1394702-1 928918-1 1394702-2 928918-2 5-1394702-1 1-928918-1 5-1394702-2 1-928918-2		HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 968893-1 5-968220-6 1703296-1 1703296-5 1534116-1 1534116-2 5-1534116-1	
POSITION 1		POSITION 2	

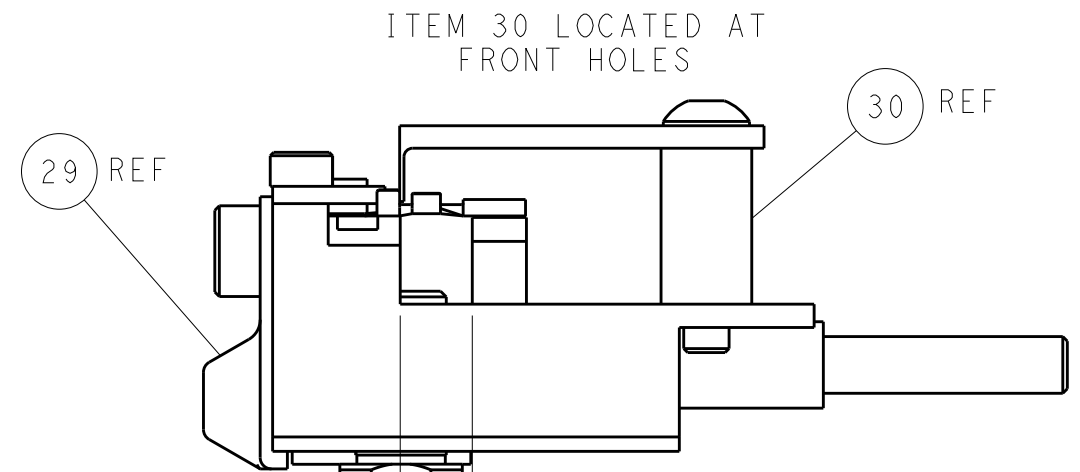


POSITION TOP EDGE OF HOLD DOWN
AGAINST BOTTOM SURFACE OF RAM

RAM AND HOLD DOWN SET-UP



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		CHKD	
mm		0 PLC ±		HOFFNER		T.ELBIN	
1 PLC ±		2 PLC ±		08DEC2011		08DEC2011	
3 PLC ±		4 PLC ±		PRODUCT SPEC		NAME	
MATERIAL		FINISH		APPLICATION SPEC		Ocean Side Feed Applicator	
-		-		WEIGHT		SIZE	
-		-		CUSTOMER DRAWING		CAGE CODE	
-		-		SCALE		DRAWING NO	
-		-		5:1		00779	
-		-		SHEET		REV	
-		-		4		G	
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-		-		4		-	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION