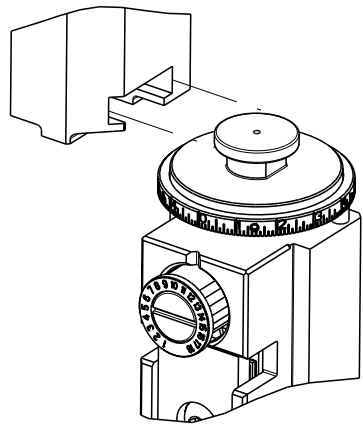




APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.45 mm [.136]	F
INSUL	4.32 mm [.170]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ASSY, TERMINAL RING TONGUE			
WIRE STRIP LENGTH 5.50-6.00 mm [.217-.236 IN]			INSULATION DIAMETER RANGE Ø3.10-4.20 mm [.122-.165 IN]
TERMINAL APPLICATION SPECIFICATION		114-37015	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1599298-1	1599298-3	1599298-4	1599298-5

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
 2.50mm2		2.57+/-0.05 [1.01+/- .002]		5.7
2.00mm2		2.43+/-0.05 [0.96+/- .002]		7.5
1.50mm2		2.33+/-0.05 [0.92+/- .002]		8.3



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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
7. MAXIMUM CMA FOR 2.50mm² IS 5000 CMA.

*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
			A	RELEASED		16AUG2013	LG	GB
			B	ECR-19-007040		03MAY2019	TB	CT
			C	ECR-19-008519		29MAY2019	MEH	GB

	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1	1-690438-0	FRONTSTRIP GUIDE	268
	-	2	2	22283-1	SPRING, COMPRESSION	267
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	266
	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	265
	-	1	1	356835-1	LEVER, DRAG RELEASE	264
	-	1	1	240792-1	DRAG, TERMINAL	263
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	262
	-	1	1	1633782-8	FENCE	261
	-	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	2119082-4	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	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
3	-	1	1	2063440-2	AIR FEED MODULE	238
	-	1	1	2-1752354-0	STANDOFF,HOLD-DOWN	180
	-	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	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	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1-22278-0	SPRING, COMPRESSION	77
	-	1	1	854769-4	HOLDER, INS	74
	-	1	1	1803607-1	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	1	1	1-1338683-1	FEED PAWL	56
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1901681-2	HOLDDOWN, TERMINAL	51
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
	-	2	2	4-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1320928-8	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	1-356885-3	STOP, SHEAR	11
△	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
△	-	1	1	454276-5	FLOATING SHEAR, FRONT	9
△	1	2	1	1-1803057-4	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
△	1	2	1	3-1633962-7	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-1	SPACER, CRIMPER	2
△	1	2	1	4-1633730-6	CRIMPER, WIRE	1
	-77-72	2		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRIFIED CORPORATION IT SHALL BE KEPT IN THE ORIGINAL FILED WITH THE PROJECT AND NOT REPRODUCED WITHOUT THE WRITTEN PERMISSION OF THE ELECTRIFIED CORPORATION		DWN 09JUN2013 CHN U_GUO 09JUN2013		 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 1 CRU7 APPLICATION SPEC	
		WEIGHT -		SIZE CASE CODE DRAWING NO A1 00779 C-2151971	
MATERIAL -		RESTRICTED TO -		SCALE 1:2 SHEET 1 OF 4 REV C	
Customer Accessible Production Drawing					

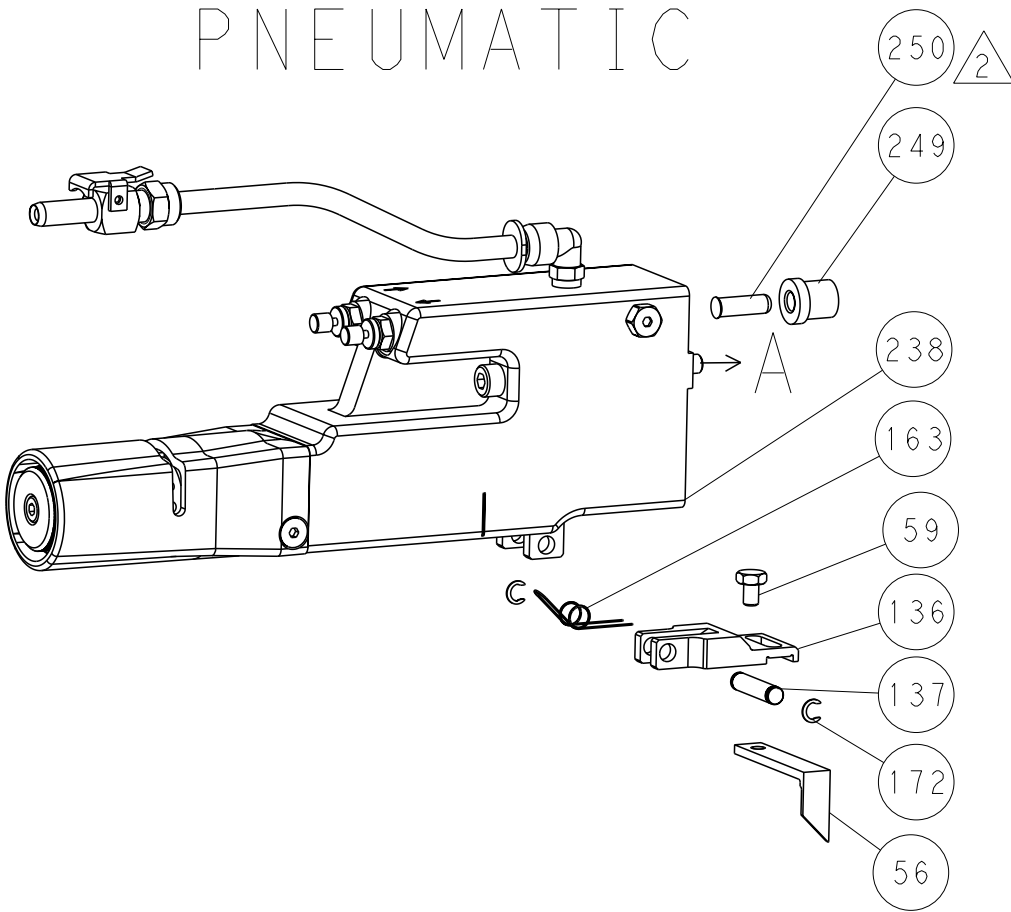
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

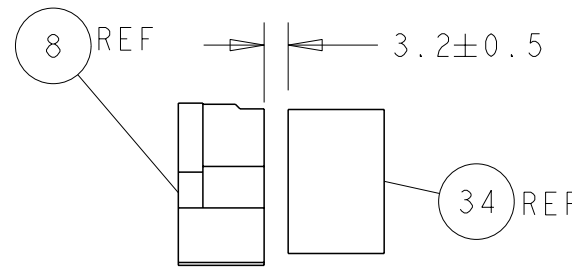
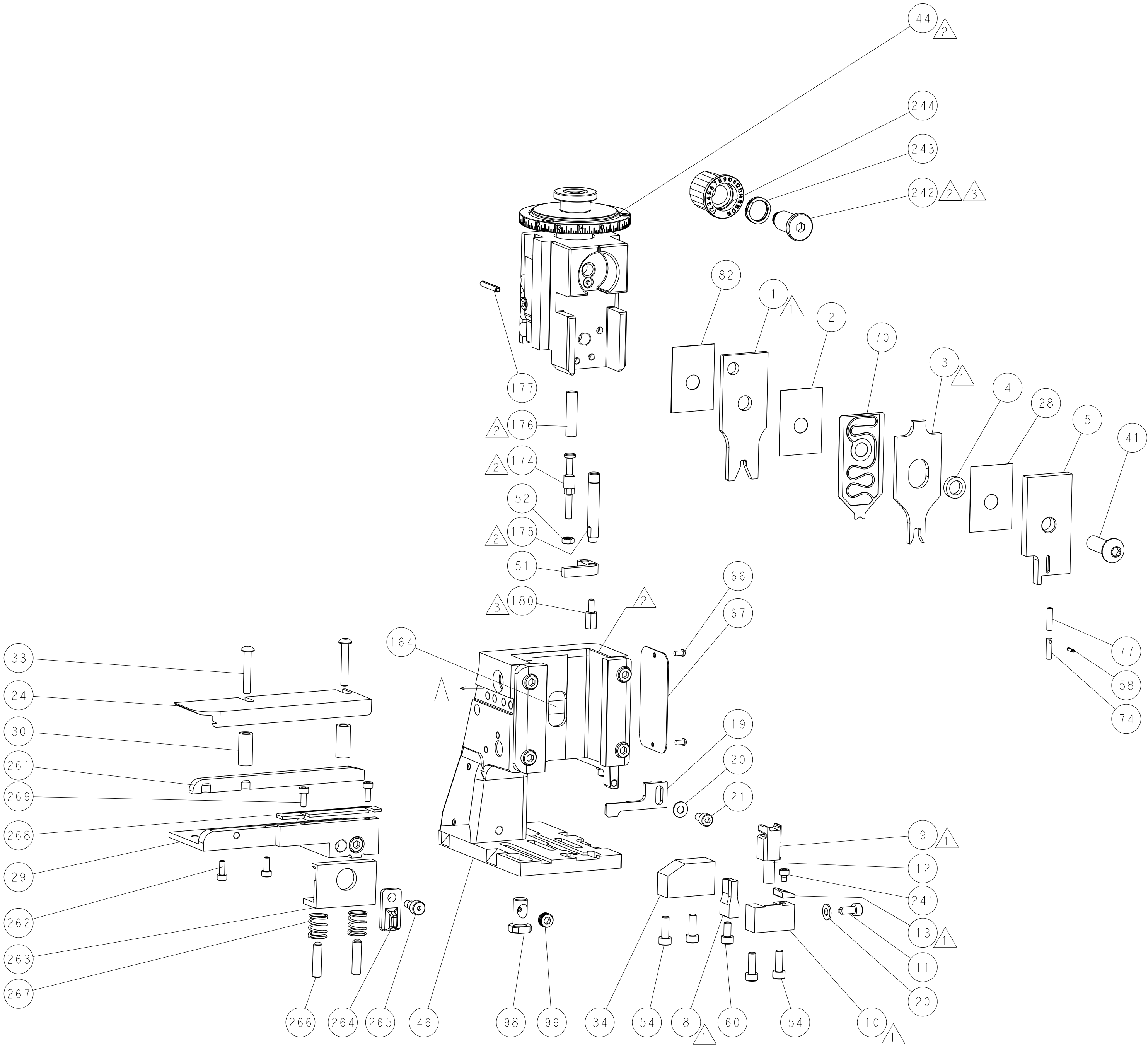
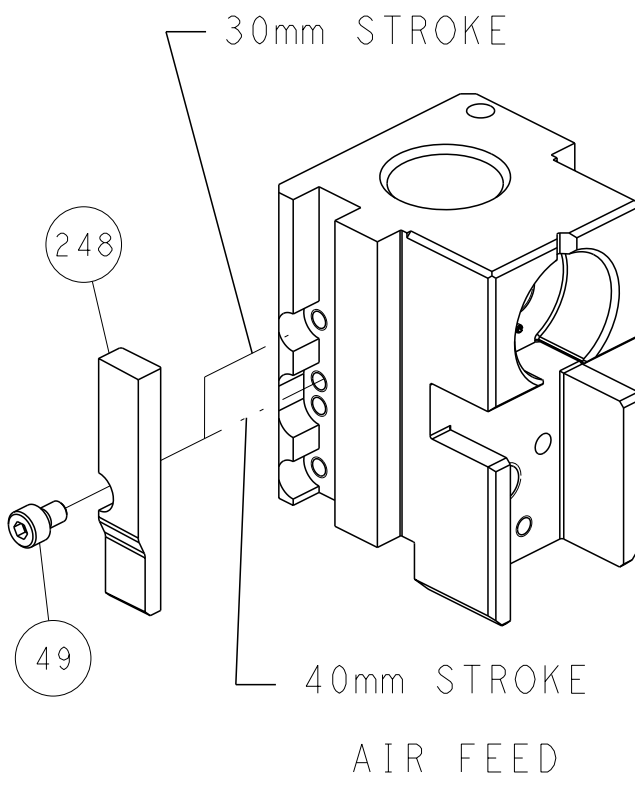
LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	DWN	APVD
A	66		-	SEE SHEET 1	-	-	-

FEED TYPE

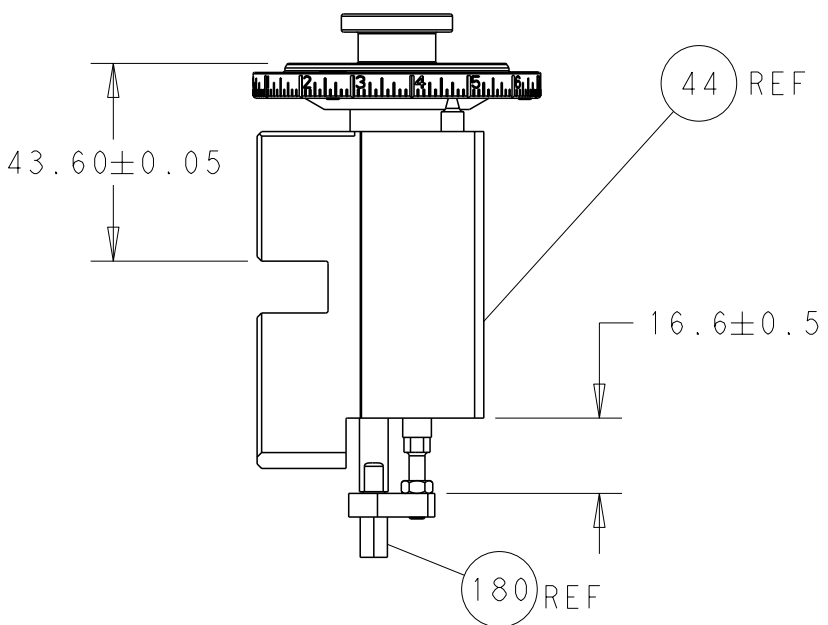
PNEUMATIC



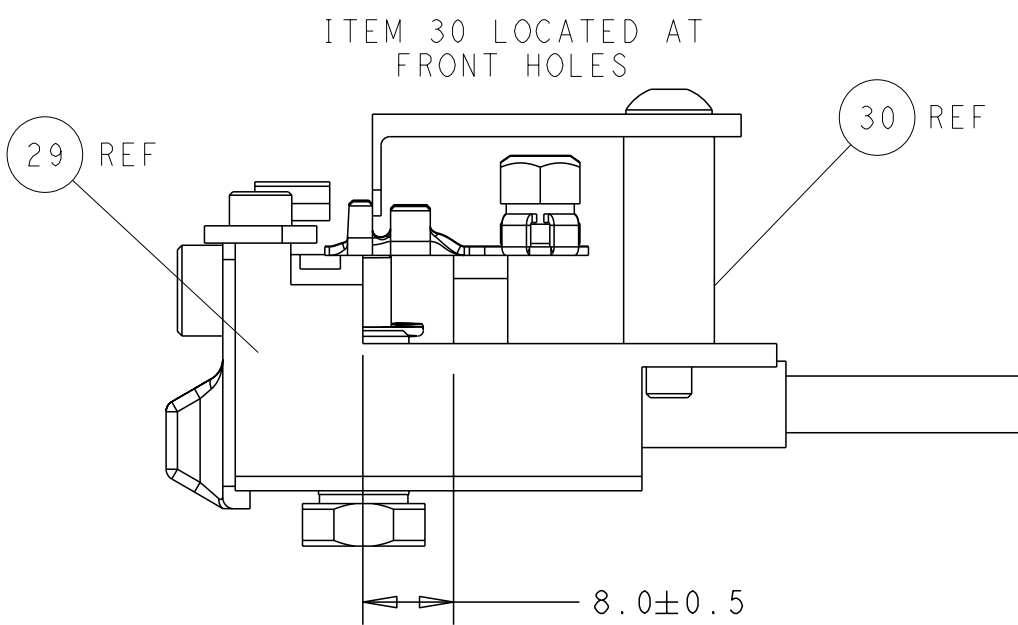
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



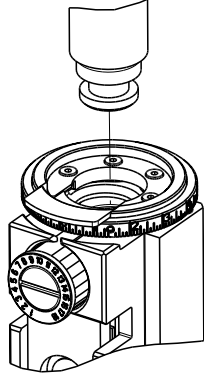
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

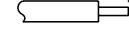
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.		DWN C. CHEN 09JUN2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK U. GUO 09JUN2013		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD J. CRUZ 09JUN2013	NAME Ocean Side Feed Applicator	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
		APPLICATION SPEC -	CAGE CODE 00779	
		WEIGHT -	DRAWING NO. C-2151971	
		Customer Accessible Production Drawing	SCALE 1:2	SHEET 2
			OF 4	REV C

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151971-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151971-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.45 mm [.136]	F
INSUL	4.32 mm [.170]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ASSY, TERMINAL RING TONGUE			
WIRE STRIP LENGTH 5.50-6.00 mm [.217-.236 IN]			INSULATION DIAMETER RANGE Ø3.10-4.20 mm [.122-.165 IN]
TERMINAL APPLICATION SPECIFICATION	114-37015	-	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1599298-1	1599298-3	1599298-4	1599298-5

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		2.57+/-0.05 [.101+/- .002]		5.7
2.00mm2		2.43+/-0.05 [.096+/- .002]		7.5
1.50mm2		2.33+/-0.05 [.092+/- .002]		8.3



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- MAXIMUM CMA FOR 2.50mm2 IS 5000 CMA.

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

	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1-690438-0	FRONT STRIP GUIDE	268
	-	2	22283-1	SPRING, COMPRESSION	267
	-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	266
	-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	265
	-	1	356835-1	LEVER, DRAG RELEASE	264
	-	1	240792-1	DRAG, TERMINAL	263
	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	262
	-	1	1633782-8	FENCE	261
	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1803259-1	BUSHING, FLANGED	249
	-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2063440-2	AIR FEED MODULE	238
3	-	1	2-1752354-0	STANDOFF,HOLD-DOWN	180
	-	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	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	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	2119799-1	HOLDER,FEED FINGER, AF	136
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	455888-5	SPACER, CRIMPER	82
	-	1	1-22278-0	SPRING, COMPRESSION	77
	-	1	854769-4	HOLDER, INS	74
	-	1	1803607-1	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	1	1-1338683-1	FEED PAWL	56
	-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1901681-2	HOLDDOWN, TERMINAL	51
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
	-	2	4-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
	-	1	455888-3	SPACER, CRIMPER	28
	-	1	1320928-8	STRIP GUIDE	24
	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	2119806-1	INSERT, SHEAR	13
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-3	STOP, SHEAR	11
1	-	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	454276-5	FLOATING SHEAR, FRONT	9
1	1	1	1-1803057-4	ANVIL, COMBINATION	8
	-	-	-	-	7
	-	-	-	-	6
	-	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	3-1633962-7	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-1	SPACER, CRIMPER	2
1	1	1	4-1633730-6	CRIMPER, WIRE	1

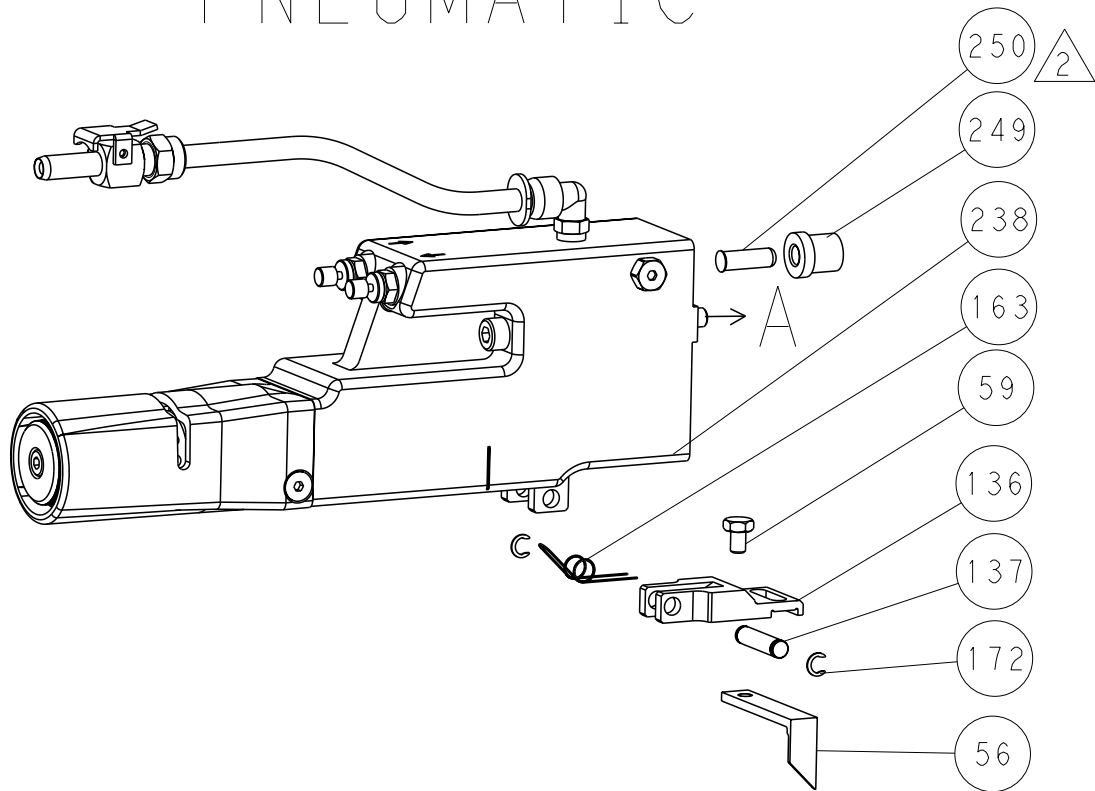
- 77 - 22		PART NO		DESCRIPTION		ITEM NO	
NOT ELECTRONIC COMPONENTS TEST REVISION		OWN 09JUN2013		STE TE Connectivity Harrisburg, PA 17105-3608			
CHK 09JUN2013							
U GUO							
APVD 09JUN2013							
NAME							
PRODUCT SPEC							
APPLICATION SPEC							
SIZE		CAGE CODE	DRAWING NO		RESTRICTED TO		
WEIGHT		A1 00779		C=2151971		-	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 3 OF 4		REV C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

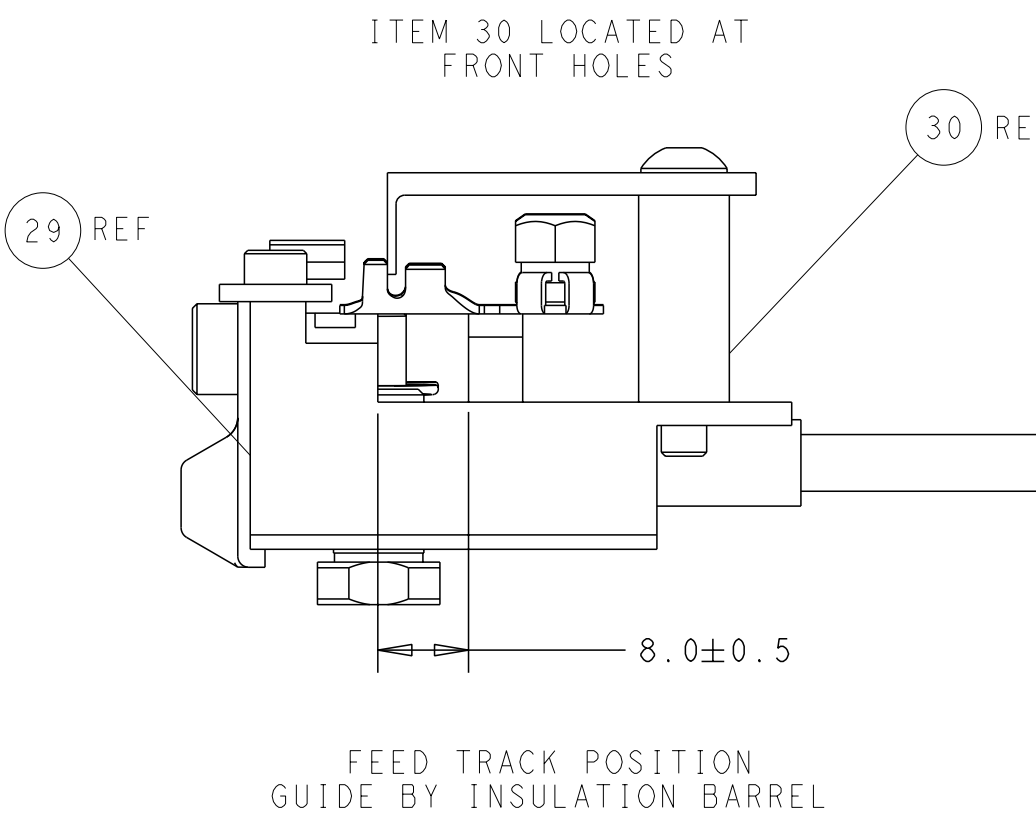
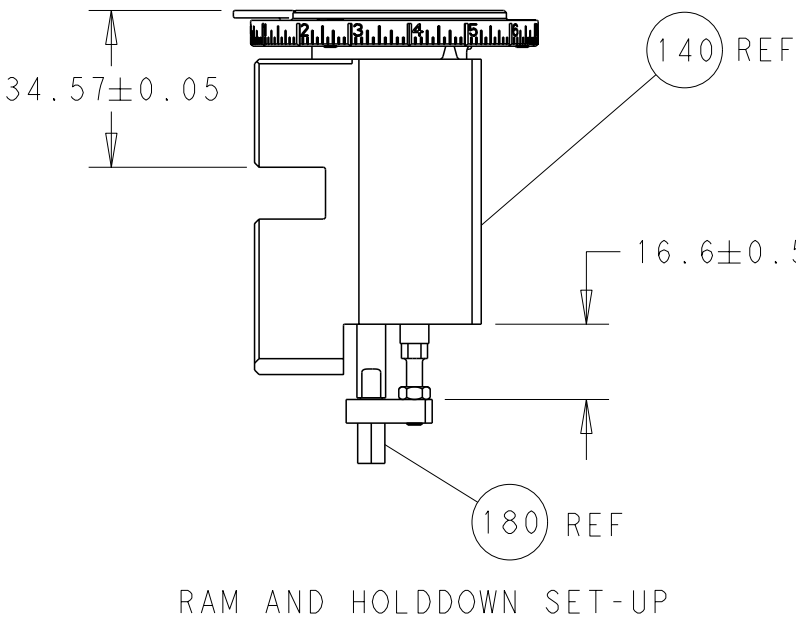
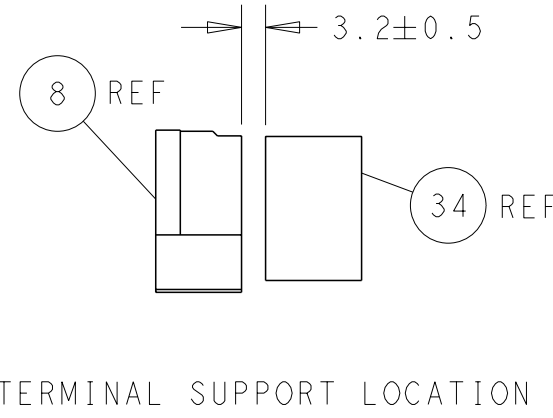
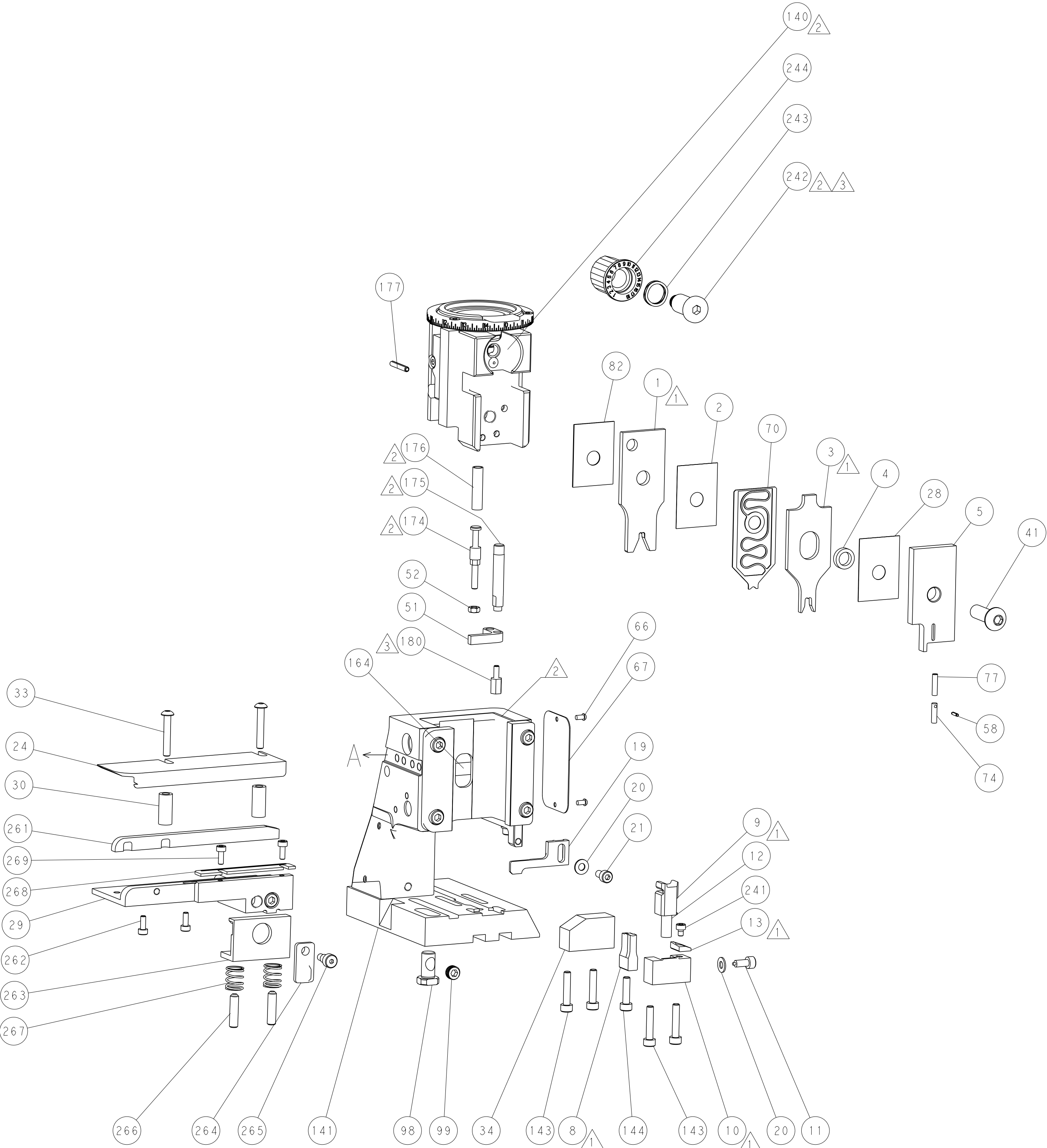
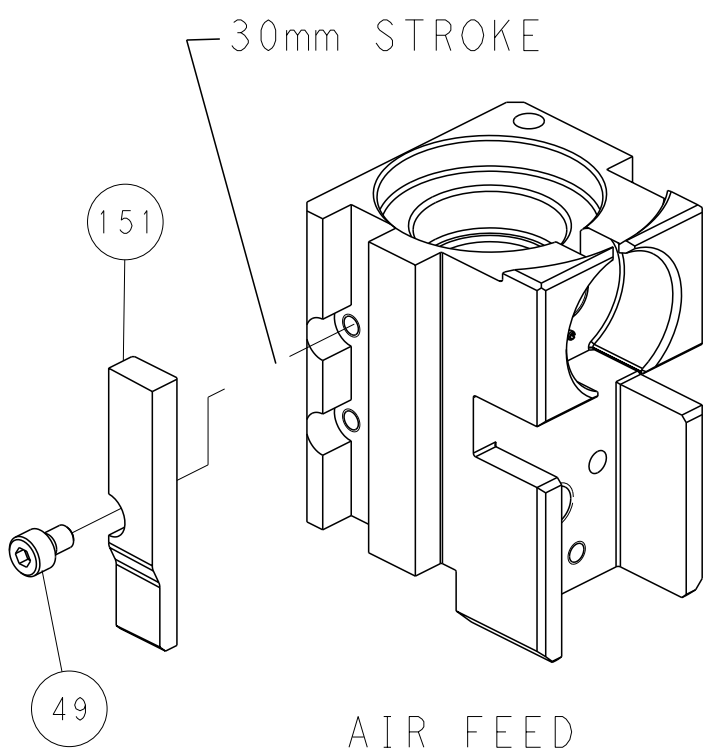
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC



CAM POSITION



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

1111 DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DEPARTMENT SHALL BE CONTACTED FOR THE LATEST REVISION				DWN C. CHEN 09JUN2013	TE Connectivity Harrisburg, PA 17105-3608		
				CHK U. GUO 09JUN2013			
				APVD J. CRUZ 09JUN2013	NAME Ocean Side Feed Applicator		
DIMENSIONS: mm				PRODUCT SPEC	SIZE A1		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				APPLICATION SPEC	CAGE CODE 00779		
MATERIAL -				WEIGHT -	DRAWING NO C=2151971		
				Customer Accessible Production Drawing	SCALE 1:2	SHEET 4	REV C