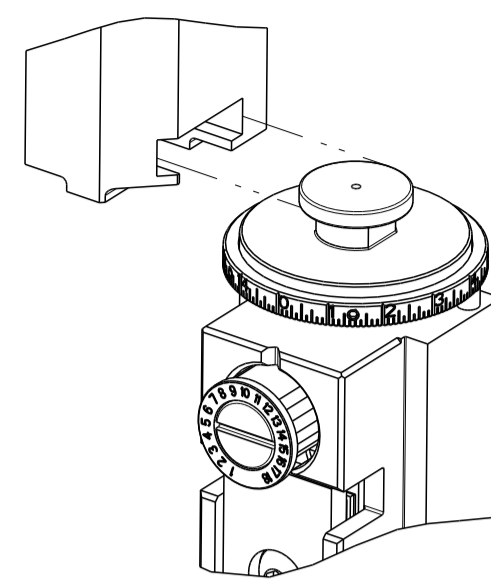


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151008-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151008-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151008-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

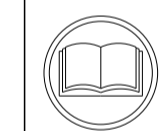


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 LIF FLAG FASTON			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-6.00 mm [.157-.236 IN]	Ø2.50-3.80 mm [.098-.150 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)1114-20088	(B)114-19025	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 180464-1	(A) 180464-2	(B) 100645-2	(B) 100645-3
(A) 180464-4	(A) 180464-5	(A) 1-180464-2	(A) 2-180464-4
(A) 180464-9	(A) 1-180464-1	(A) 2-180464-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.93+/-0.05 [.076+/-0.002]	6.1
2.00mm2	1.85+/-0.05 [.073+/-0.002]	6.9
1.50mm2	1.80+/-0.05 [.071+/-0.002]	7.1
1.00mm2	1.70+/-0.05 [.067+/-0.002]	8.0



- △ 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.
- △ 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.
- △ CUT TO LENGTH AT ASSEMBLY.
- △ QUANTITY OF ITEM 129 IS IN METERS.
- △ ALL BELLMOUTH AND CUTOFF VALUES USED SHOULD BE FROM APPLICATION SPECIFICATION 114-19025.
- 9. 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	LTN	DESCRIPTION	DATE	OWN	APVD
		A1		ECR-15-007271	11MAY2015	MR	GB
		B		ECR-18-016028	10OCT2018	FZ	KZ
		C		ECR-19-009011	07JUN2019	TB	TE

-	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
△	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	143
-	1	1	2217068-1	BRACKET, AIR BLAST	130
△	1	1	2030758-3	TUBING, POLYURETHANE	129
-	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	127
-	1	1	986220-3	CLAMP, CABLE, BLACK	126
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	455888-4	SPACER, CRIMPER	120
-	1	1	23238-1	INSERT, COUPLING	101
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	3-690712-4	FRONT STRIP GUIDE	96
△	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	455888-3	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	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	1338685-3	PAWL, FEED	56
-	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
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1-2844938-9	PLATE, STRIP GUIDE	29
-	2	2	22281-6	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	6-690754-5	DRAG, SPECIAL	25
-	1	1	7-690440-0	GUIDE, REAR STRIP	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
-	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-6	STRIPPER, SIDE FEED	19
△	1	1	3-853720-9	BLADE, SLUG	15
△	1	1	1-853721-3	BLADE, SLUG	10
△	1	1	2-1803012-8	PLATE, REAR SHEAR	9
△	1	2	1803010-3	ANVIL, SPECIAL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
△	1	2	1-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
△	1	2	4-456408-0	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

ITEM NO	PART NO	DESCRIPTION
-77-72	-2	PART NO

APPROVED	DATE	APPROVED	DATE
CHU	20JAN2015	CHU	20JAN2015
L. ZHANG	20JAN2015	L. ZHANG	20JAN2015
U. GUO	20JAN2015	U. GUO	20JAN2015

NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Ocean Side Feed Applicator	A1	00779	2151008	-

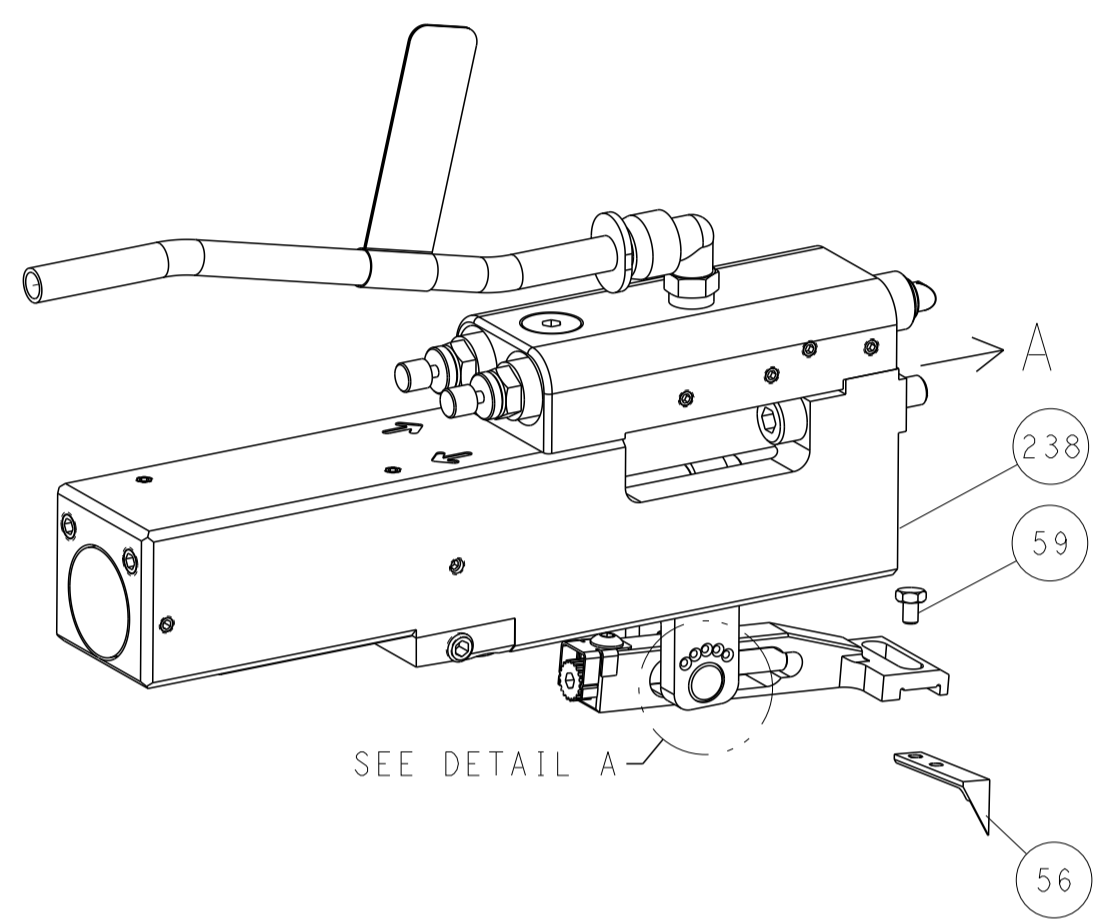
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV C

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

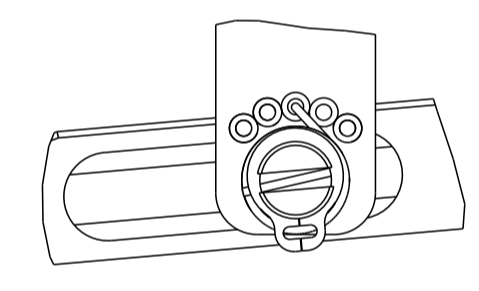
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

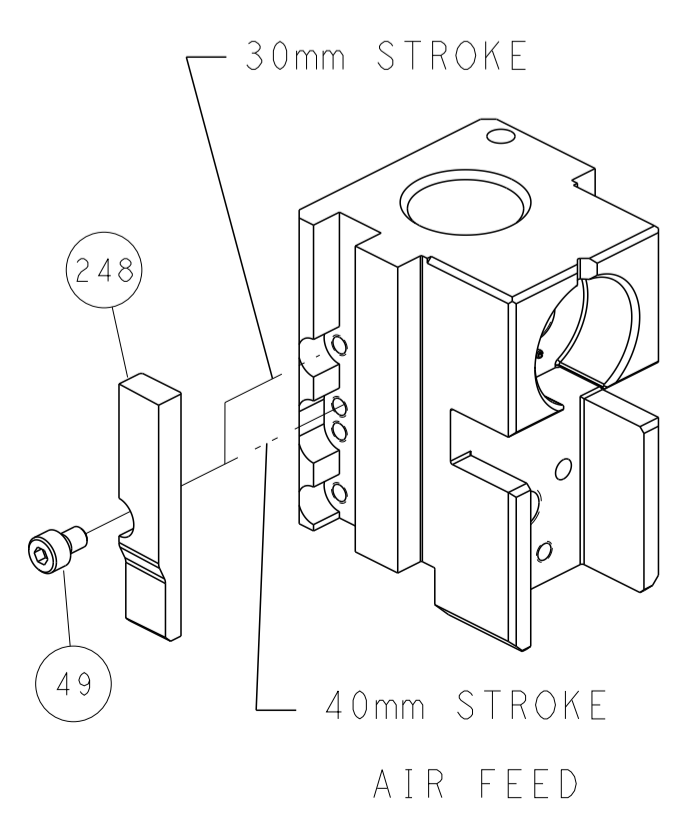


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

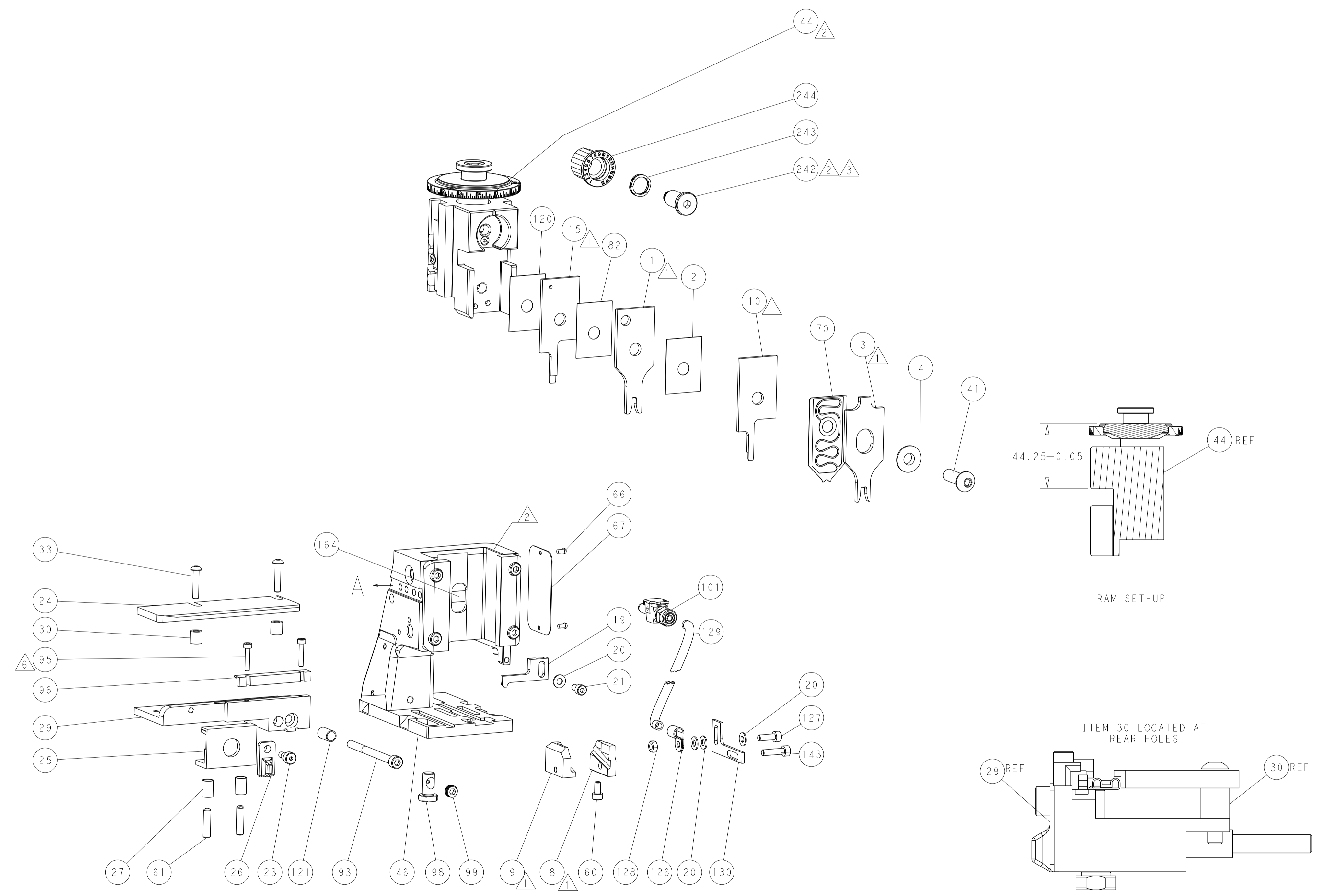


DETAIL A

CAM POSITION



AIR FEED



RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES

FEED TRACK POSITION GUIDE BY INSULATION AND BODY

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 20. BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN R. HUANG 20JAN2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		CHK L. ZHANG 20JAN2015	NAME Ocean Side Feed Applicator
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD H. GUO 20JAN2015	SIZE A1 CAGE CODE 00779 DRAWING NO. C=2151008
MATERIAL		WEIGHT	RESTRICTED TO Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151008-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151008-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .250 LIF FLAG FASTON

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.00-6.00 mm [.157-.236 IN]	∅2.50-3.80 mm [.098-.150 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 180464-1	(A) 180464-2	(B) 100645-2	(B) 100645-3
(A) 180464-4	(A) 180464-5	(A) 1-180464-2	(A) 2-180464-4
(A) 180464-9	(A) 1-180464-1	(A) 2-180464-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.93+/-0.05 [.076+/- .002]	6.1
2.00mm2	1.85+/-0.05 [.073+/- .002]	6.9
1.50mm2	1.80+/-0.05 [.071+/- .002]	7.1
1.00mm2	1.70+/-0.05 [.067+/- .002]	8.0



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 CUT TO LENGTH AT ASSEMBLY.
- 7 QUANTITY OF ITEM 129 IS IN METERS.
- 8 ALL BELLMOUTH AND CUTOFF VALUES USED SHOULD BE FROM APPLICATION SPECIFICATION 114-19025.
- 9. 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)

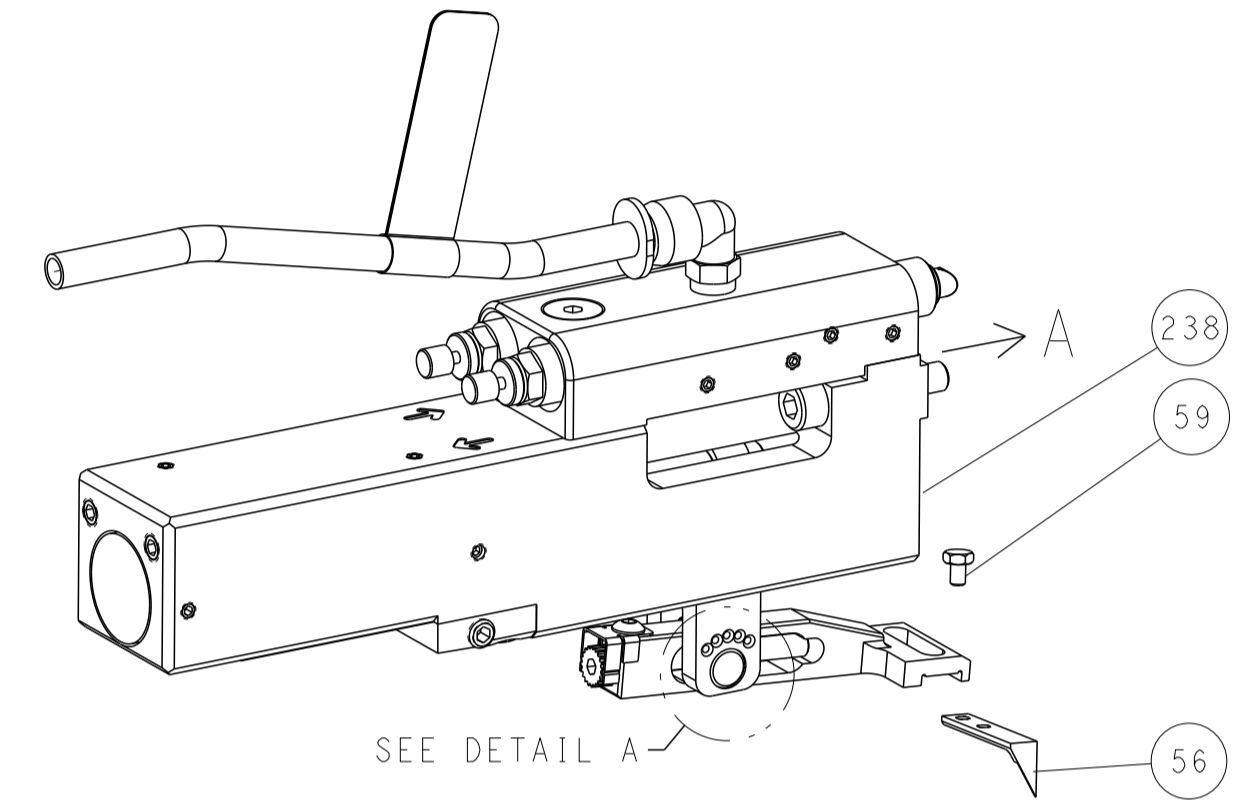
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	2119082-3		CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1		WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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
-	1	2168083-8		SCR, SKT HD CAP, RoHS, M4 X 16	143
-	1	1-1803583-0		APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1		RAM ASSEMBLY, SF PACIFIC	140
-	1	2217068-1		BRACKET, AIR BLAST	130
-	1	2030758-3		TUBING, POLYURETHANE	129
-	1	5018030-2		NUT, HEX, REG, RoHS, M4	128
-	1	2168083-3		SCR, SKT HD CAP, RoHS, M4 X 12.0	127
-	1	986220-3		CLAMP, CABLE, BLACK	126
-	1	1-22281-8		SPRING, COMPRESSION	121
-	1	455888-4		SPACER, CRIMPER	120
-	1	23238-1		INSERT, COUPLING	101
-	1	2844908-1		SCREW, LOCKING	99
-	1	2844907-1		POST, LOCKING	98
-	1	3-690712-4		FRONT STRIP GUIDE	96
-	2	1-2168083-3		SCR, SKT HD CAP, RoHS, M3 X 16	95
-	1	2168083-6		SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	455888-3		SPACER, CRIMPER	82
-	1	1803607-3		DOCUMENTATION PACKAGE	71
-	1	2119791-9		DEPRESSOR, WIRE	70
-	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	1338685-3		PAWL, FEED	56
-	1	18023-9		SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1		SCR, BHSC, RoHS (M8 X 25)	41
-	2	2079383-5		SCR, BHSC, RoHS (M4 X 20)	33
-	2	2844962-2		SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1-2844938-9		PLATE, STRIP GUIDE	29
-	2	22281-6		SPRING, COMPRESSION	27
-	1	356835-1		LEVER, DRAG RELEASE	26
-	1	6-690754-5		DRAG, SPECIAL	25
-	1	7-690440-0		GUIDE, REAR STRIP	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
-	4	1-18028-2		WASHER, FLAT, REG M4	20
-	1	2119533-6		STRIPPER, SIDE FEED	19
-	1	3-853720-9		BLADE, SLUG	15
-	1	1-853721-3		BLADE, SLUG	10
-	1	2-1803012-8		PLATE, REAR SHEAR	9
-	1	1803010-3		ANVIL, SPEICAL, COMBINATION	8
-	-	-		-	7
-	-	-		-	6
-	-	-		-	5
-	1	238009-1		BLOCK, FL CRIMPER SPACER	4
-	1	9-2119582-2		CRIMPER, INSULATION F PREMIUM	3
-	1	455888-4		SPACER, CRIMPER	2
-	1	4-456408-0		CRIMPER, WIRE PREMIUM	1
-	77	22		PART NO	
-	-	-		DESCRIPTION	
-	-	-		ITEM NO	

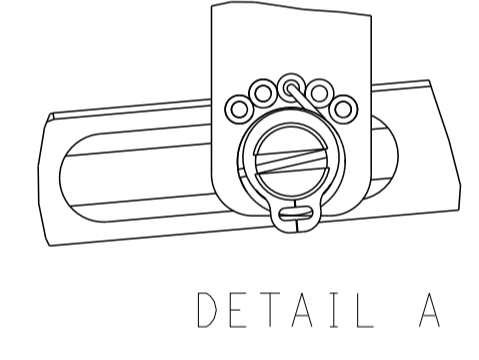
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN: H. HUANG 20JAN2015 CHK: L. ZHANG 20JAN2015 APVD: J. GUO 20JAN2015	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151008 SCALE: 1:2 SHEET: 3 OF 4 REV: C
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LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

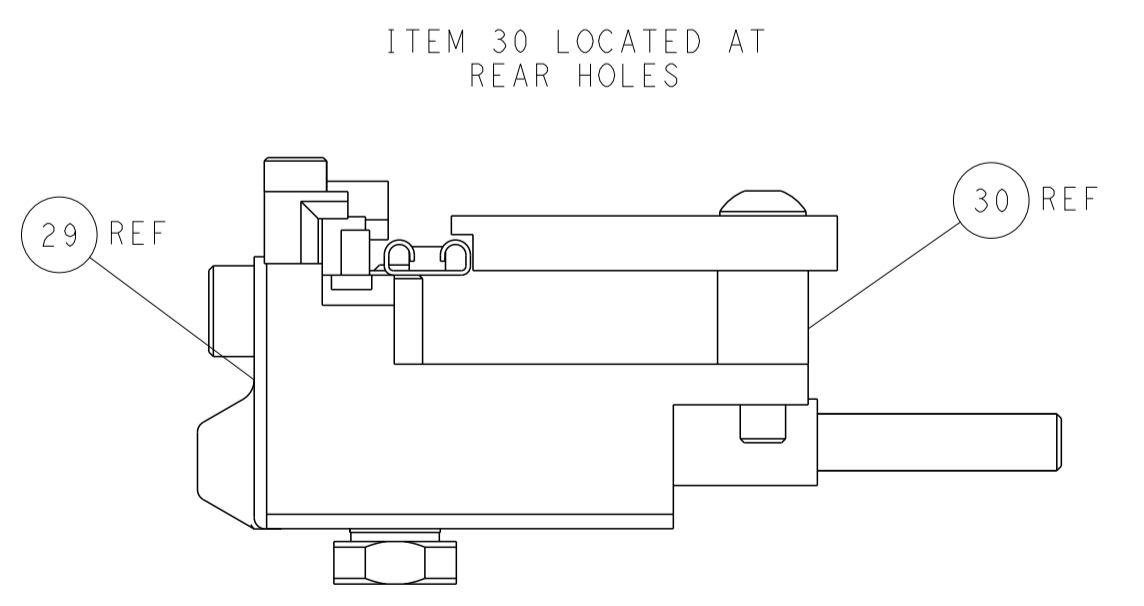
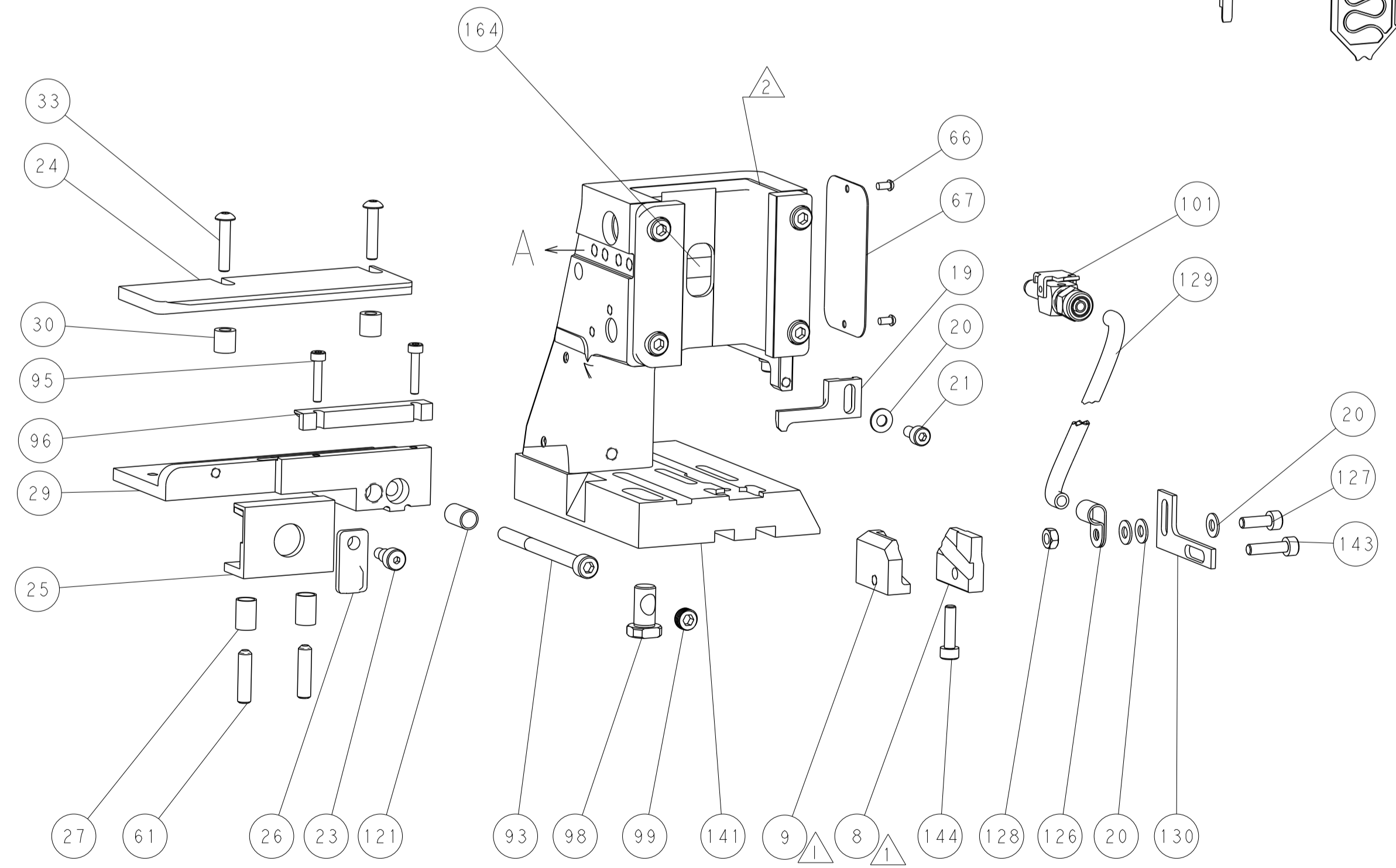
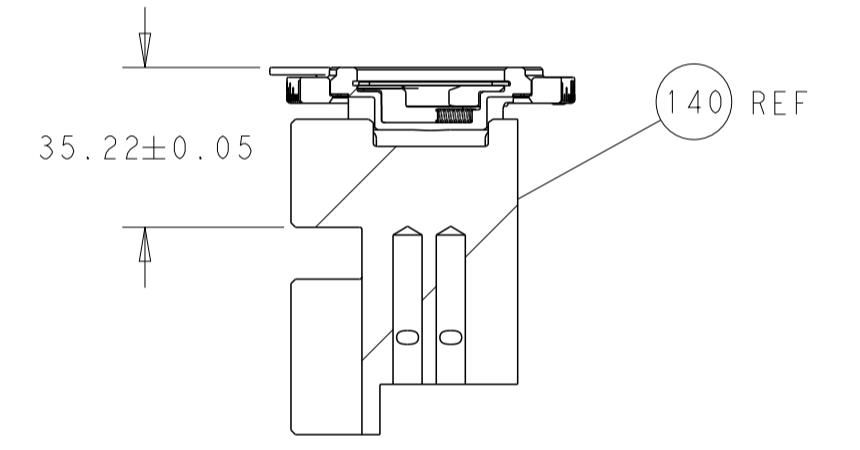
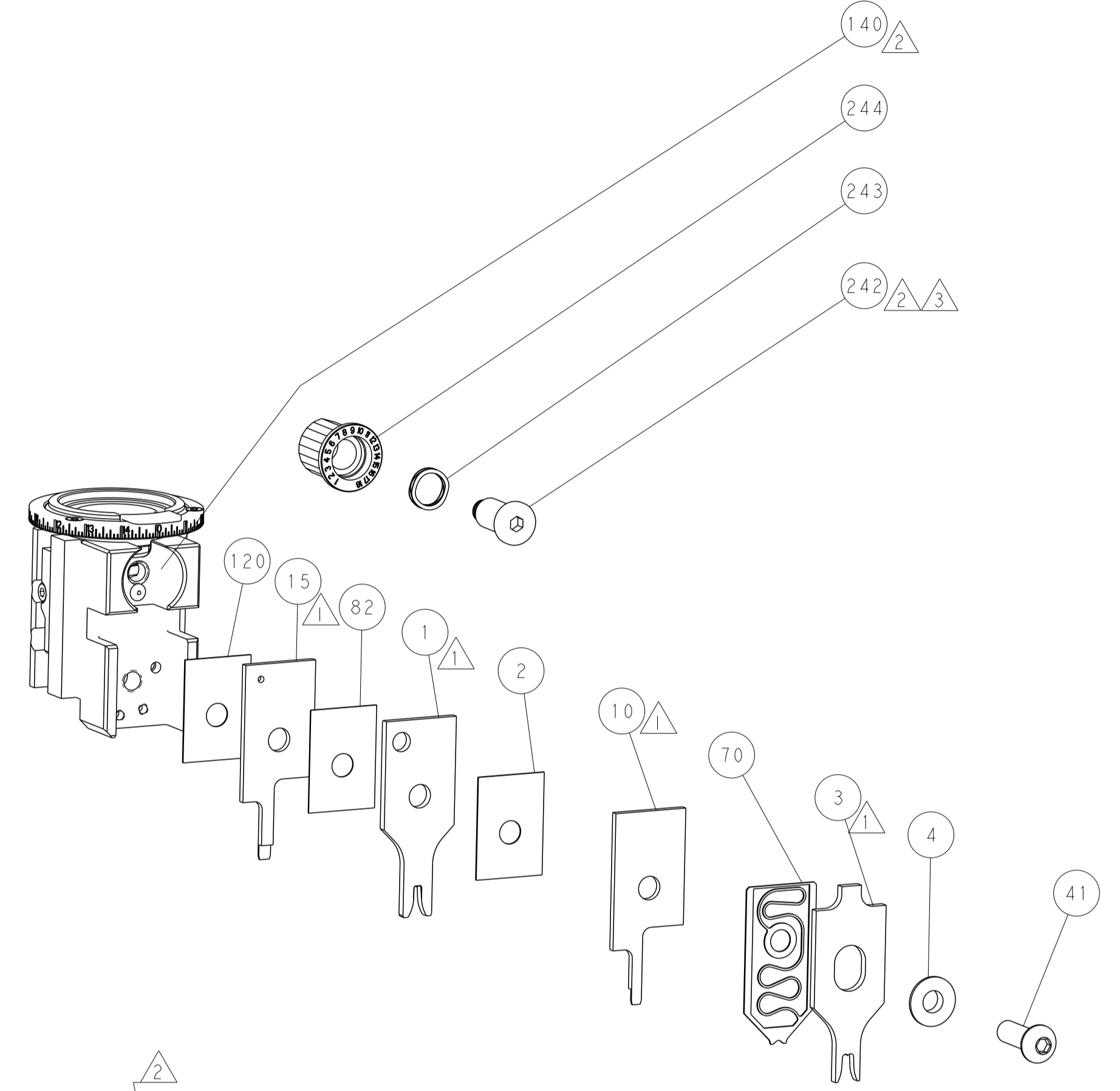
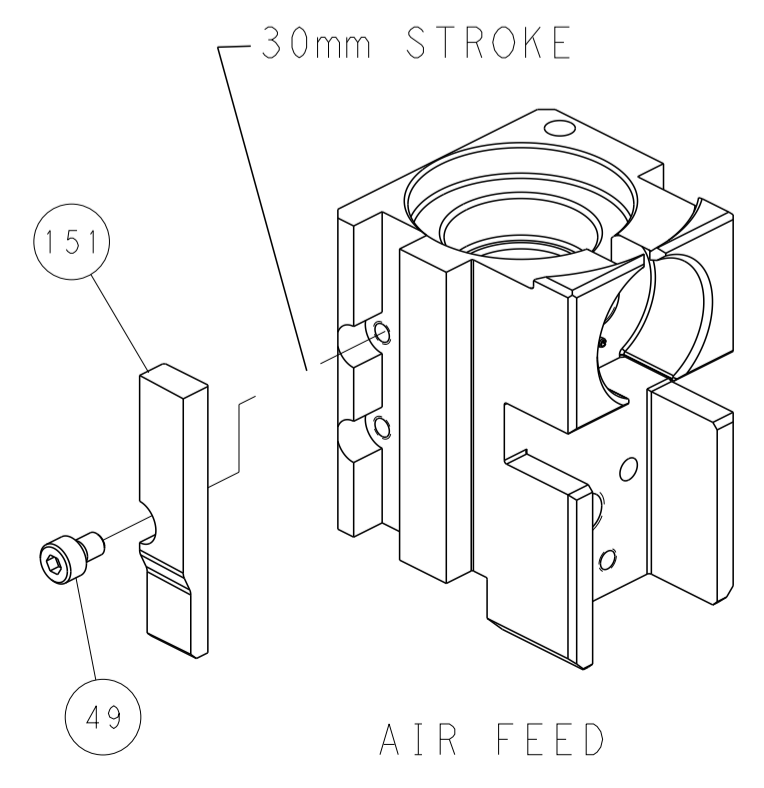
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151008 SHEET 4 OF 4	RESTRICTED TO: C