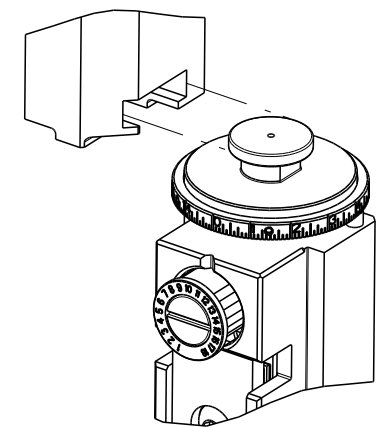


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151693-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151693-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151693-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

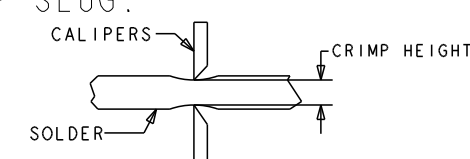


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.136 [3.45 mm]	D
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

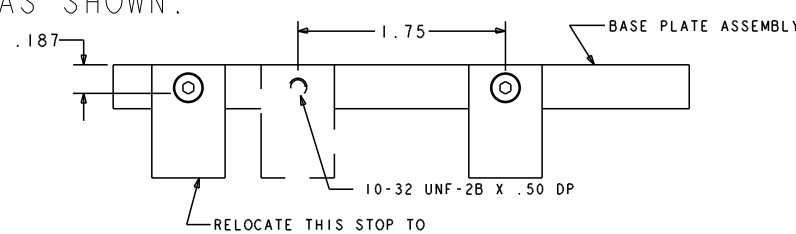
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.265-.297 IN [6.73-7.54 mm]		∅ .105 MAX	
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
7-520365-2			

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
22	0.065+/-0.002 [1.65+/-0.05]	6.0	.12 IN [3.05mm]
24 OR 26	0.060+/-0.002 [1.52+/-0.05]	7.4	.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.
- ITEM 5, 22 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- 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.
 - ITEMS NOT SHOWN.
 - ITEM 261 REQUIRED WHEN APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN AMP-O-LECTRIC* TERMINATING UNIT.
13. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		C		ECR-18-016937	30OCT2018	JAH	CT
		D		ECR-19-011879	29JUL2019	FZ	TE
		E		ECR-19-014579	18SEP2019	FZ	TE
		F		ECR-23-192107	09NOV2023	FZ	JAH

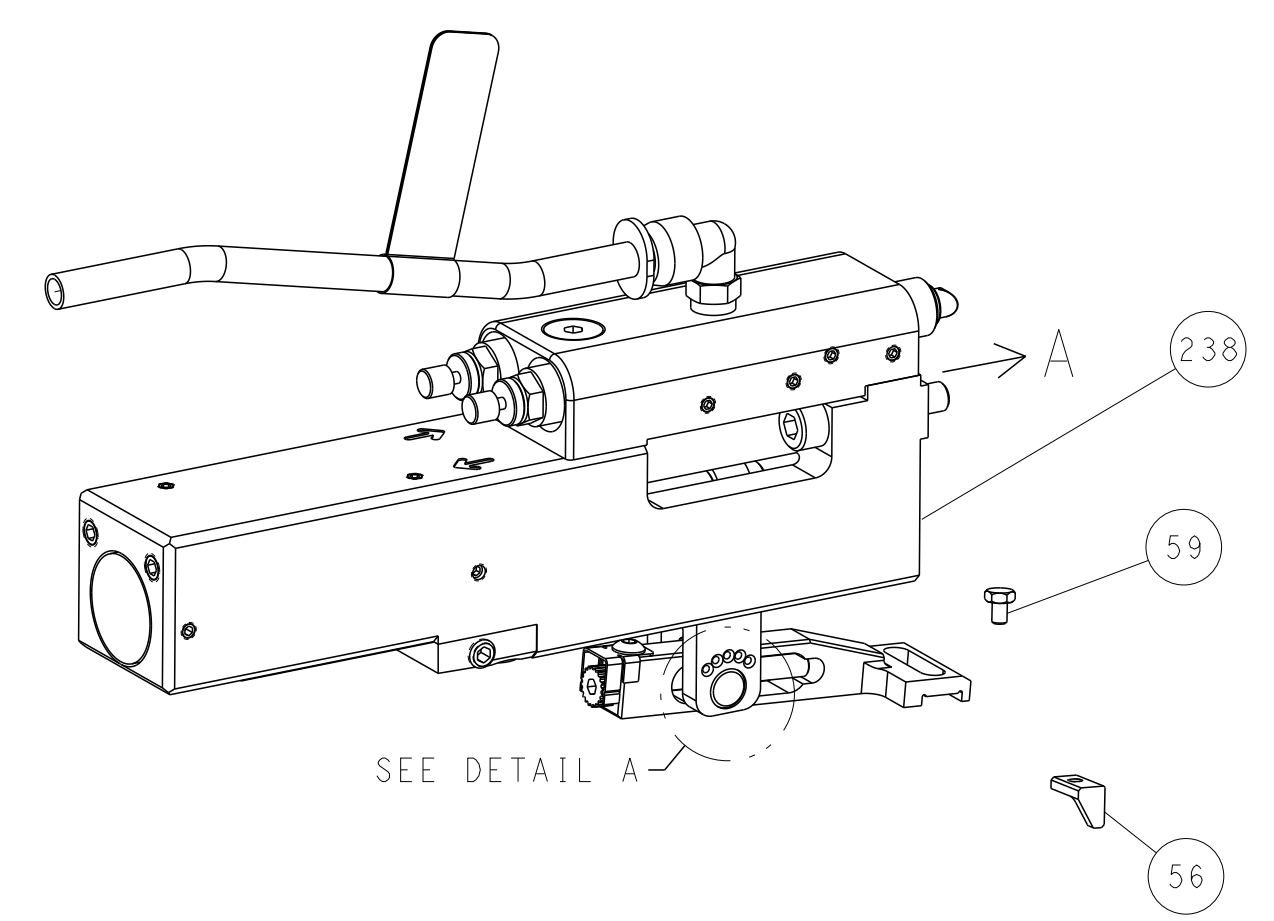
	-	1	1	1-18023-1	SCR, SHC, M4x10		262
	-	1	1	803931-1	BRACKET, HOLD DOWN		261
	-	REF	REF	462992-7	GUARD ASSEMBLY		257
	-	REF	REF	679532-1	INSERT, GUARD		256
	-	1	1	189728-1	BRACKET, SPACER		255
	-	1	1	568681-1	SPACER, BASE PLATE		253
	-	1	1	2119641-1	FEED CAM, AIR FEED		248
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
	-	1	1	2844940-1	AIR FEED MODULE		238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8		192
	-	REF	REF	994970-2	COUNTER, MAGNETIC		164
	-	1	1	1-22281-8	SPRING, COMPRESSION		121
	-	1	1	2844908-1	SCREW, LOCKING		99
	-	1	1	2844907-1	POST, LOCKING		98
	-	1	1	1-690438-0	FRONT STRIP GUIDE		96
	-	6	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65		93
	-	1	1	455888-4	SPACER, CRIMPER -		82
	-	1	1	240641-9	SPACER		81
	-	1	1	1803607-3	DOCUMENTATION PACKAGE		71
	-	1	1	2161332-3	DEPRESSOR, WIRE FUNNEL		70
	-	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR		69
	-	2	2	1-18028-4	WASHER, FLAT, REG M3		68
	-	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	2079383-4	SCR, BHSC, RoHS (M4 X 8)		60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
	-	1	1	462427-2	FINGER, FEED		56
	-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12		54
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		53
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
	-	1	1	1-1803583-9	APPLICATOR BASIC ASSEMBLY, SF		46
	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC		44
	-	1	1	462433-9	SUPPORT, INSULATION		42
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
	-	2	2	5-22278-1	SPRING, COMPRESSION		33
	-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5		30
	-	1	1	2161336-2	PLATE, REAR STRIP GUIDE		29
	-	2	2	22281-9	SPRING, COMPRESSION		27
	-	1	1	356835-1	LEVER, DRAG RELEASE		26
	-	1	1	240792-1	DRAG, TERMINAL		25
	-	1	1	684042-4	GUIDE, STRIP, FRONT		24
	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
	-	1	1	462431-6	WIRE FUNNEL		22
	-	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	463460-2	HOLD DOWN, TERMINAL		18
	-	1	1	469542-3	REAR FLOATING SHEAR		17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6		16
	-	1	1	2161335-2	SHEAR PLATE, REAR		15
	-	1	1	2119862-2	SHEAR HOLDER, REAR		14
	-	1	1	2280441-1	INSERT, SHEAR		13
	-	1	1	3-22280-3	SPRING, COMPRESSION		12
	-	1	1	356885-4	STOP, SHEAR		11
	-	1	1	462843-8	TERMINAL SUPPORT		9
	1	2	1	464291-6	ANVIL, SAND-BLASTED 22-18		8
	-	1	1	803925-2	GUIDE, CARRIER SCRAP		7
	-	1	1	2-690468-5	DEPRESSOR SHEAR, REAR		6
	-	1	1	462431-3	WIRE FUNNEL		5
	-	1	1	2-238011-2	BLOCK, CRIMPER SPACER		4
	1	2	1	464290-2	CRIMPER, SEMI-FLAT 22-18		1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WEIGHT	SCALE	1:1	SHEET 1 OF 4
MATERIAL		FINISH		WEIGHT		SCALE		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1	

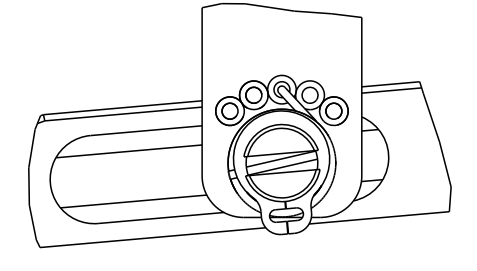
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

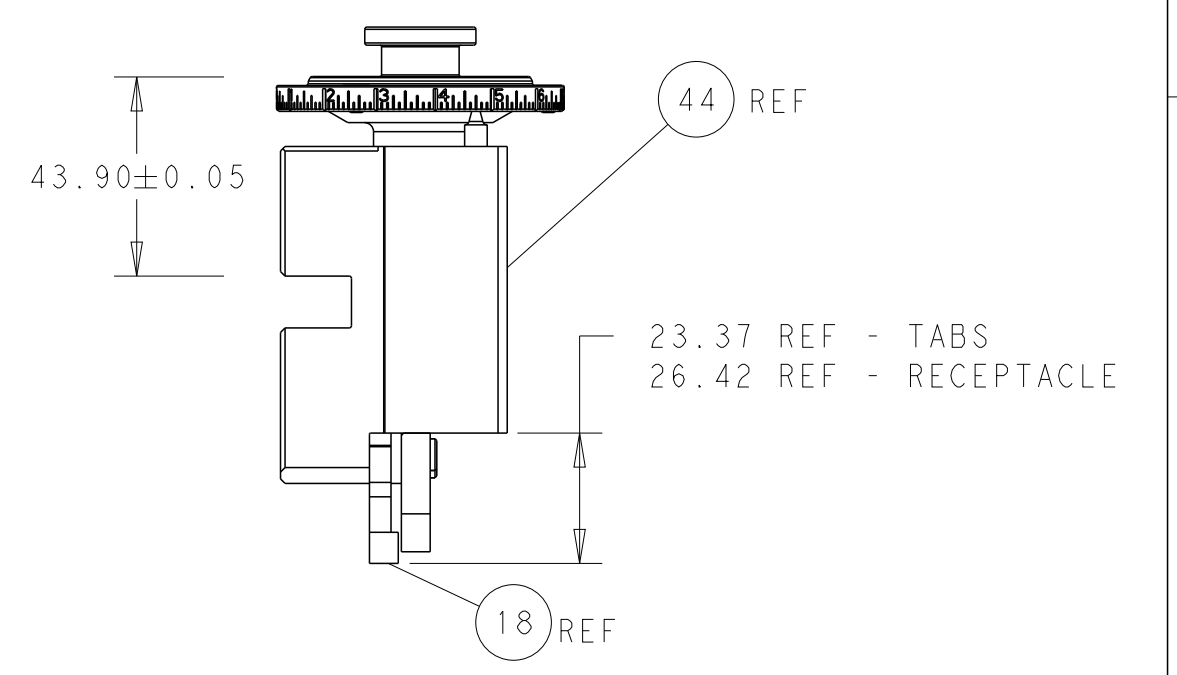
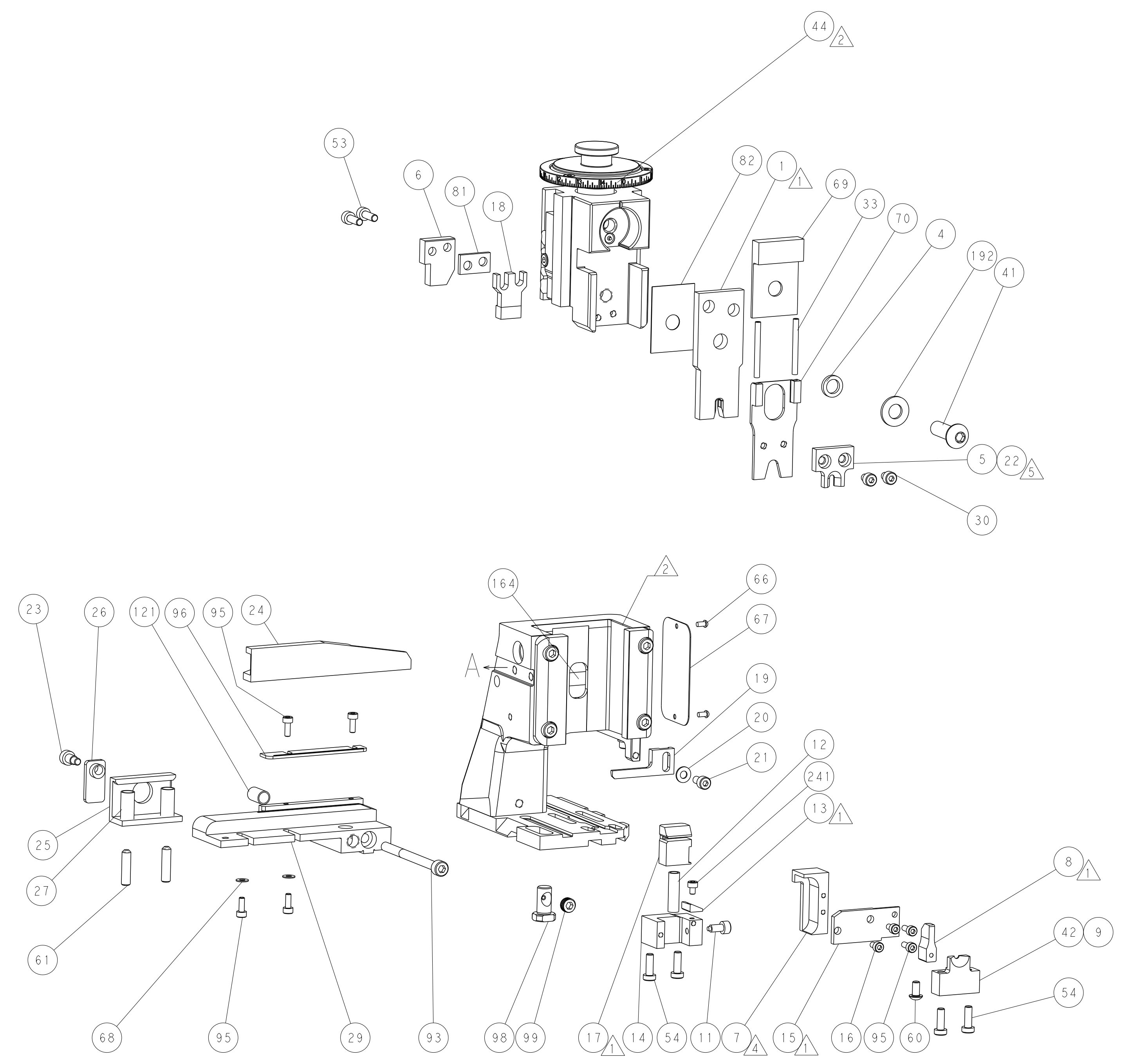
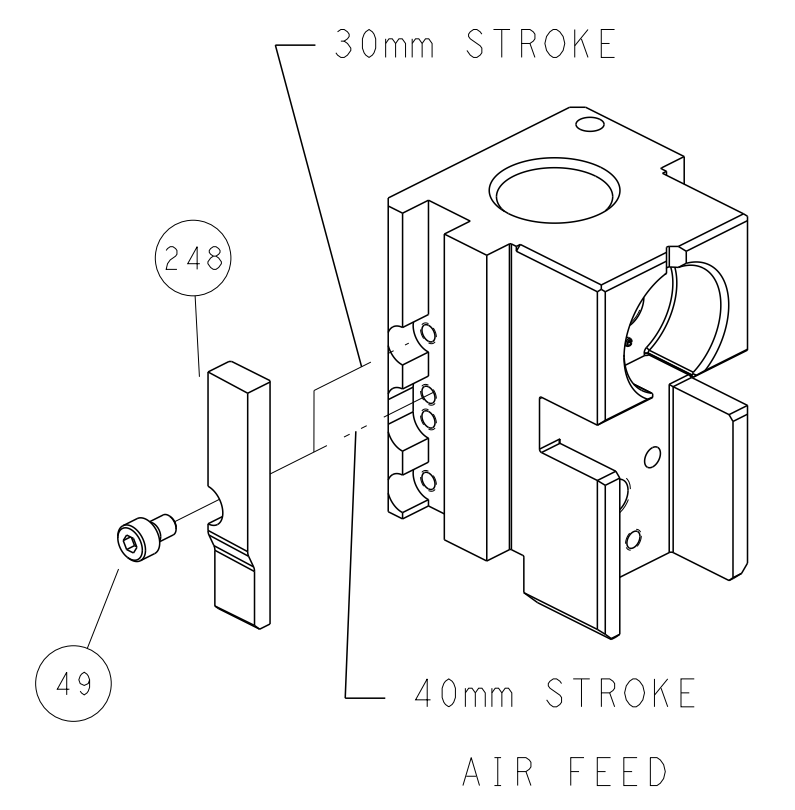


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

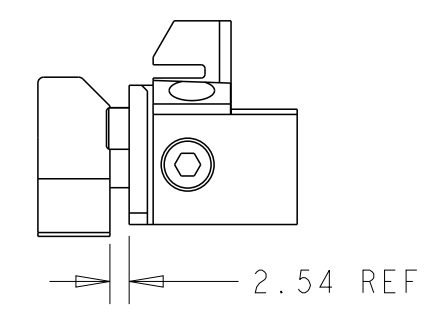


DETAIL A

CAM POSITION



RAM & HOLDDOWN SET-UP



LOWER TOOLING SET-UP

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN B. WEAVER 12JUN2012 CHK G. HOFENER 12JUN2012 APVD T. ELBIN 12JUN2012		NAME Ocean Side Feed Applicator	
MATERIAL: - FINISH: -		WEIGHT: -		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151693		RESTRICTED TO: - SCALE: 1:1 SHEET: 2 OF 4 REV: F	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				TE Connectivity Harrisburg, PA 17105-3608			