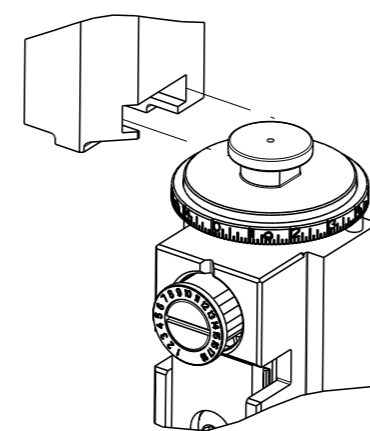


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151662-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151662-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151662-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	6.86 mm [.270]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 6.3/4.8K LITEALUM CONTACT,SWS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.30 mm [.185-.209 IN]		Ø3.56-3.74 mm [.140-.147 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94204		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2-2208094-1	2-2286832-1	1394512	
2-2208094-3	2-2286832-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	1.96+/-0.04 [.077+/- .002]	6.8

- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOCTITE TO THREADS.
- 7. 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	REV	DATE	BY	CHK
		E3	19MAR2015	KH	UG
		F	14MAR2018	JAH	JDG

-	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	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2063440-1	AIR FEED MODULE	238
-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	985575-5	SCR, FLT SKT HD CAP M3 X 16.0	57
-	1	1	1338683-8	FEED PAWL	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-3	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	1-1752356-2	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-2	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	690472-2	STRIPPER	19
	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-3	STOP, SHEAR	11
	-	1	2119805-2	SHEAR HOLDER, FRONT	10
	-	1	318059-4	FLOATING SHEAR, FRONT	9
	1	2	2-1333229-4	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2-2119781-2	DEPRESSOR, SHEAR	5
-	1	1	238011-8	BLOCK, CRIMPER SPACER	4
	1	2	2-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-5	SPACER, CRIMPER	2
	1	2	456410-4	CRIMPER, WIRE PREMIUM	1

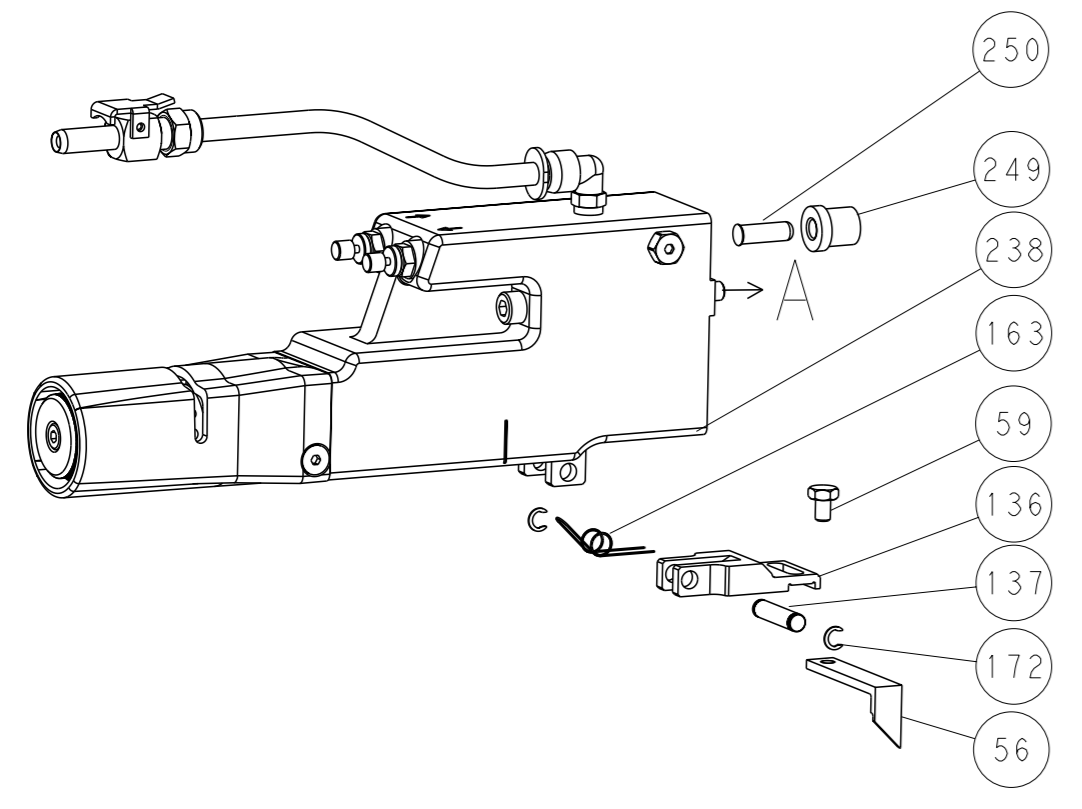
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	16MAY2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	CHK	-	
MATERIAL		FINISH		APVD	16MAY2012	NAME
				PRODUCT SPEC		Ocean Side Feed Applicator
				APPLICATION SPEC		SIZE
				WEIGHT		CAGE CODE
						DRAWING NO
						RESTRICTED TO
						00779
						©=2151662
						Customer Accessible Production Drawing
						SCALE
						1:2
						SHEET
						1 of 4
						REV
						F

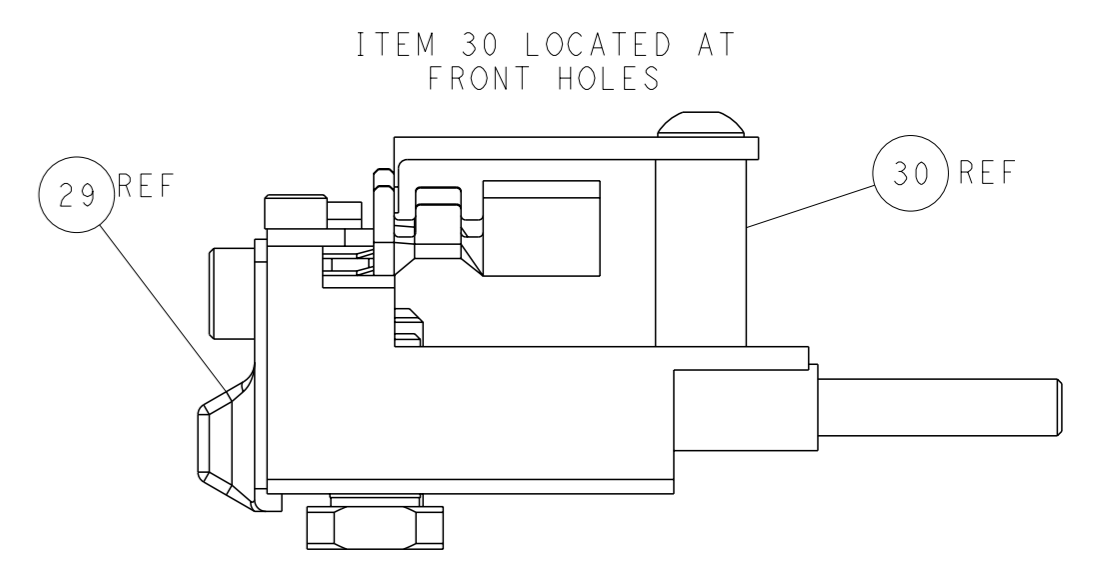
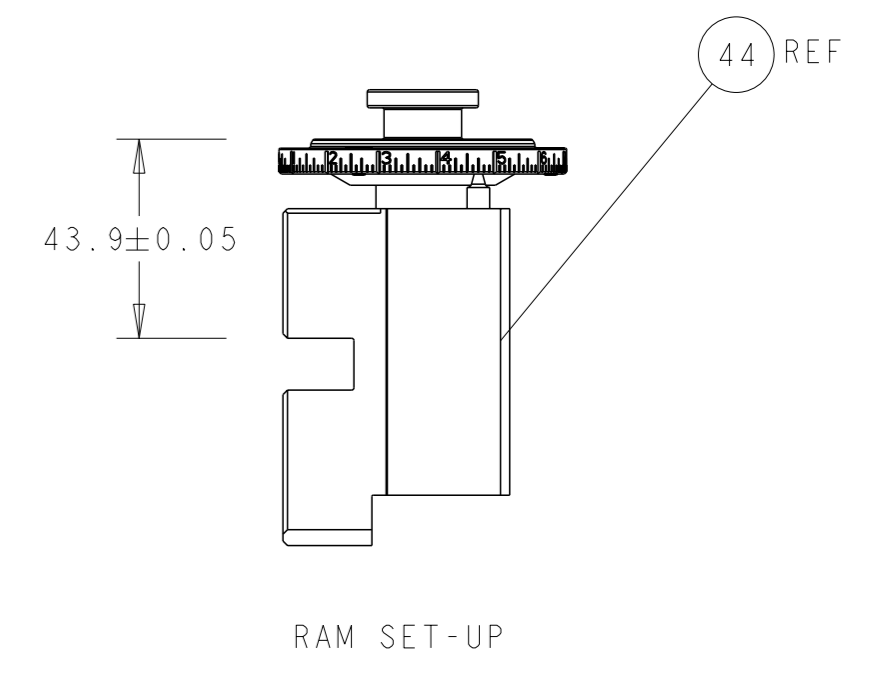
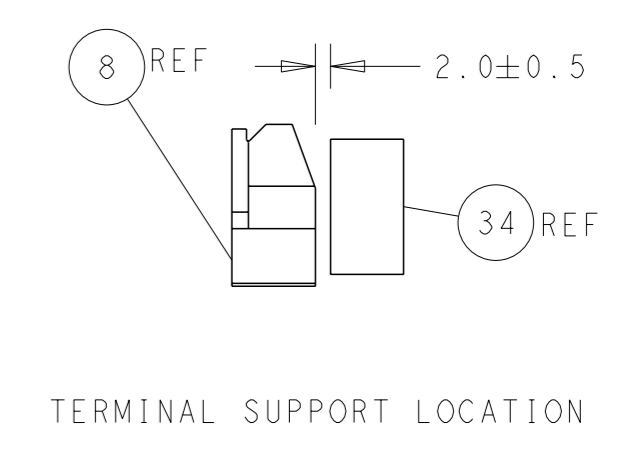
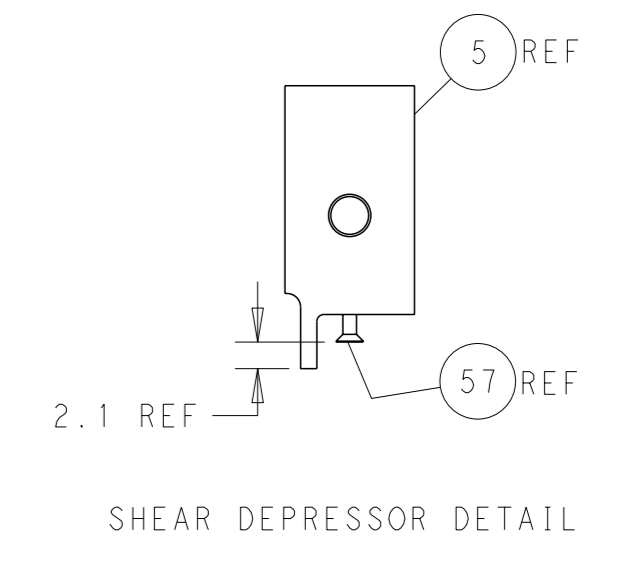
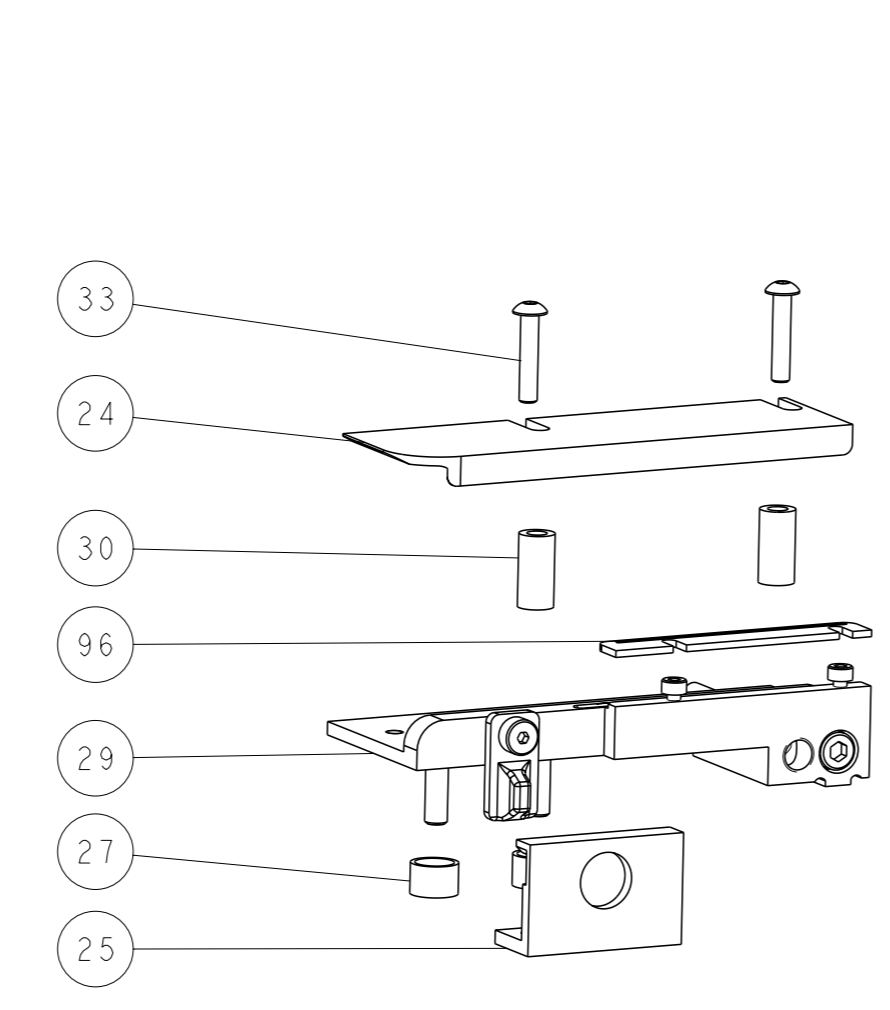
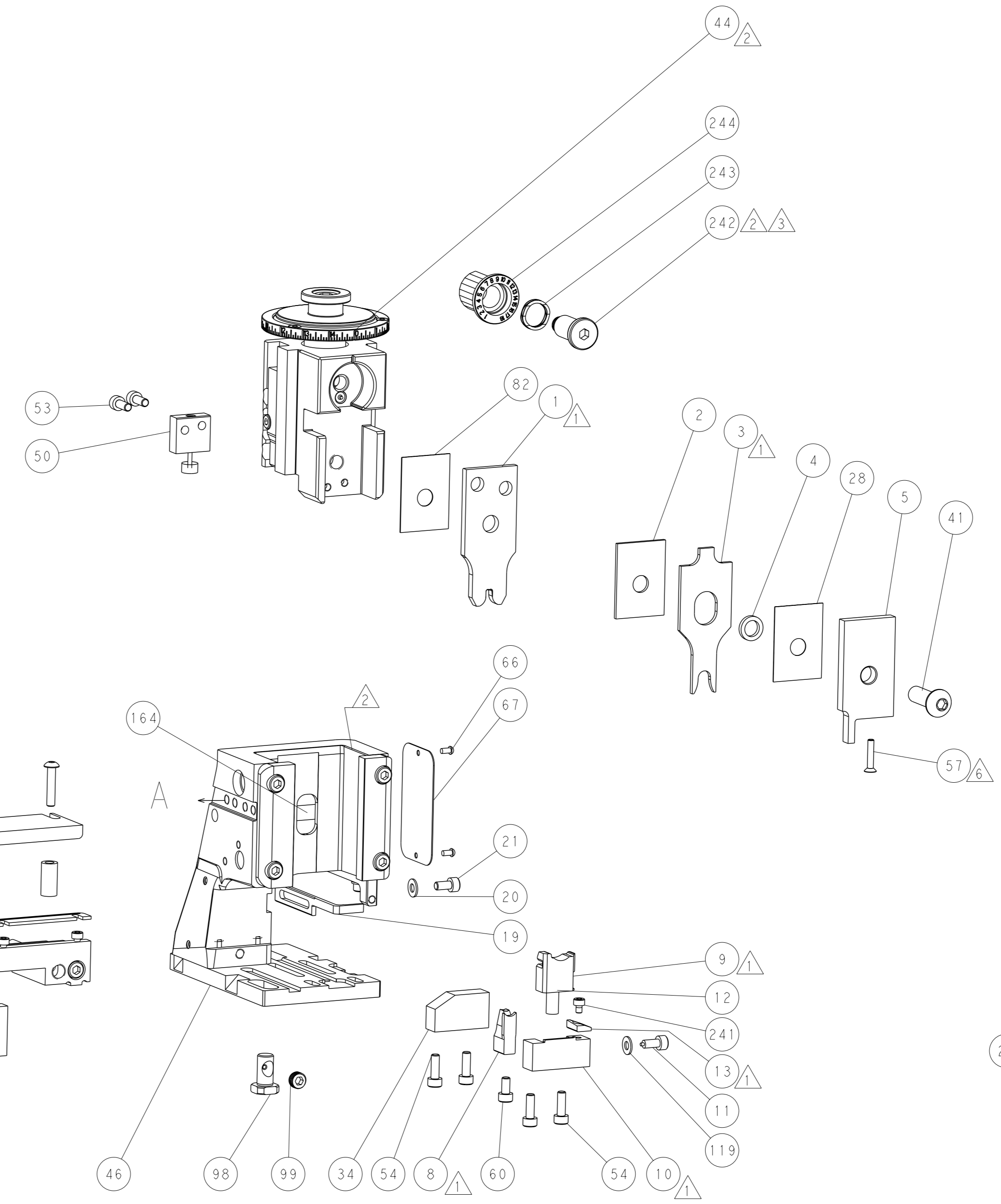
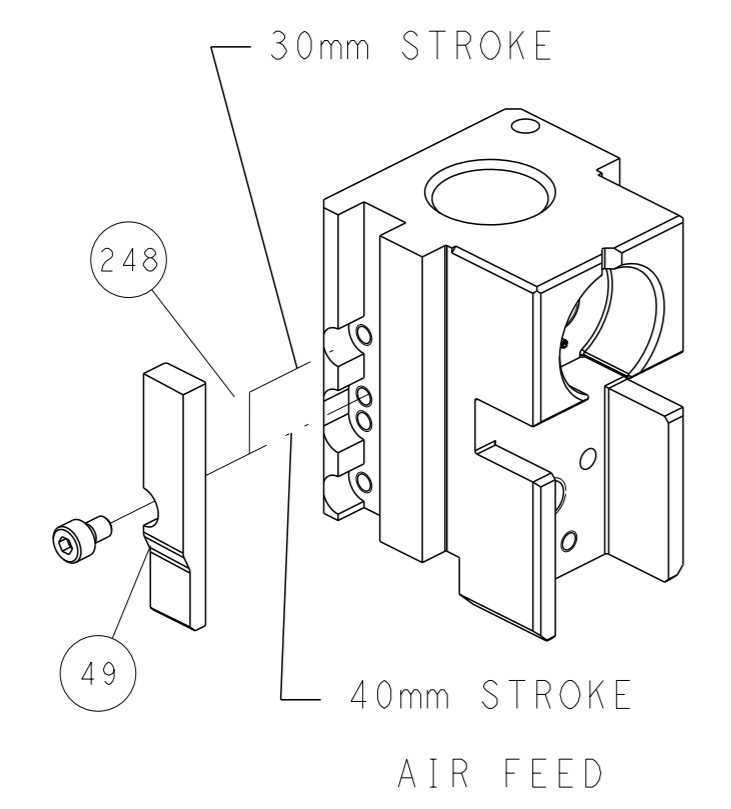
LOC	DIST	REVISIONS			
		REV	DATE	BY	APPV
A	66	1	SEE SHEET 1	-	-

FEED TYPE

PNEUMATIC



CAM POSITION

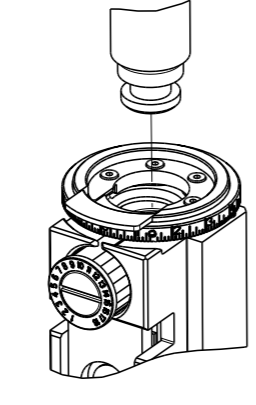


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: F	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151662-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151662-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	6.86 mm [.270]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: AMP MCP 6.3/4.8K LITEALUM CONTACT,SWS

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.70-5.30 mm [.185-.209 IN]	Ø3.56-3.74 mm [.140-.147 IN]

TERMINAL APPLICATION SPECIFICATION 114-94204

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2-2208094-1	2-2286832-1	1394512	
2-2208094-3	2-2286832-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	1.96+/-0.04 [.077+/-0.002]	6.8



- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOCTITE TO THREADS.
- 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: A DIST: 66

REVISIONS				
#	LY#	DESCRIPTION	DATE	OWN APVD
-	-	SEE SHEET 1	-	-

-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2063440-1	AIR FEED MODULE	238
-	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	1803583-4	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	455888-4	SPACER, CRIMPER	82
-	1	1803607-1	DOCUMENTATION PACKAGE	71
-	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	985575-5	SCR, FLT SKT HD CAP M3 X 16.0	57
-	1	1338683-8	FEED PAWL	56
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1-1752356-2	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	2	22283-1	SPRING, COMPRESSION	27
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-2	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	690472-2	STRIPPER	19
-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-3	STOP, SHEAR	11
-	1	2119805-2	SHEAR HOLDER, FRONT	10
-	1	318059-4	FLOATING SHEAR, FRONT	9
-	1	2-1333229-4	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	2-2119781-2	DEPRESSOR, SHEAR	5
-	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	2-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1-455888-5	SPACER, CRIMPER	2
-	1	456410-4	CRIMPER, WIRE PREMIUM	1
-	77	-22	PART NO	ITEM NO

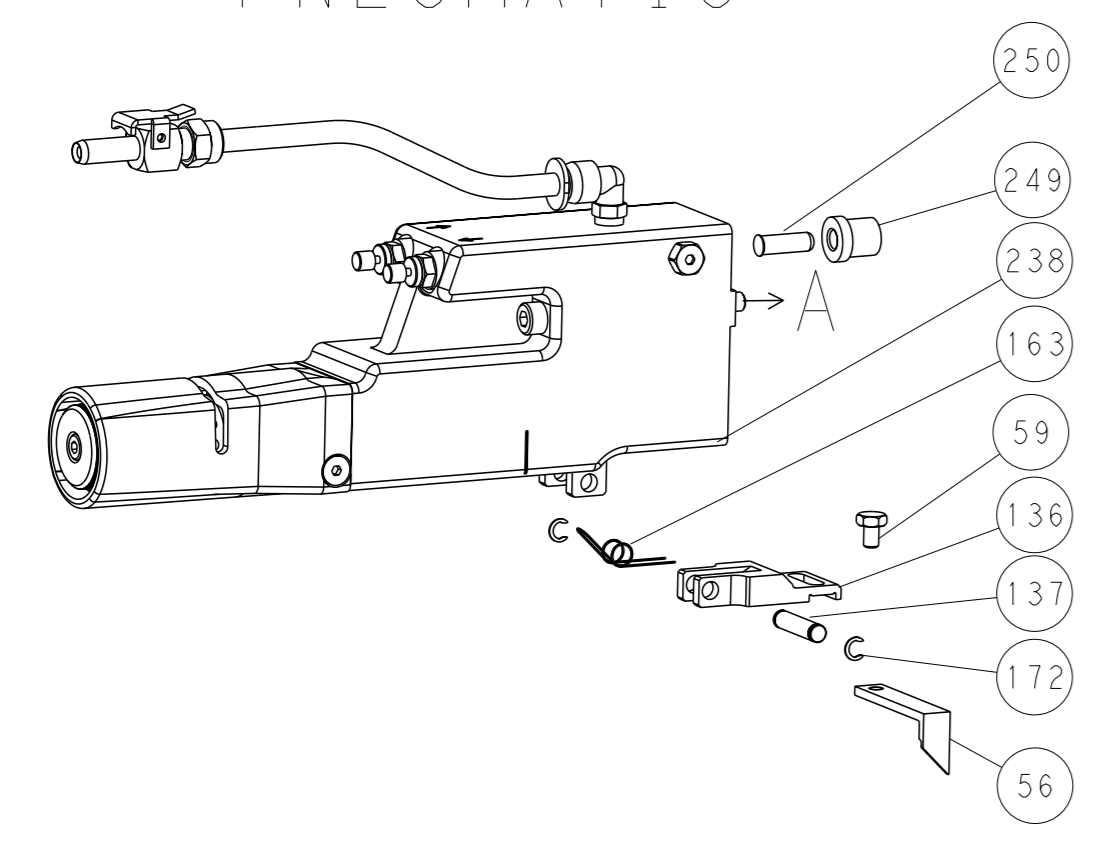
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

<p>THE DRAWING IS UNPUBLISHED DOCUMENT FOR THE USE OF THE CUSTOMER. IT IS SUBJECT TO CHANGE AND THE CUSTOMER'S RESPONSIBILITY TO VERIFY THE DRAWING INFORMATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</p>		OWN: H. HUANG 16MAY2012 CHK: S. XI 16MAY2012 APVD: S. XI 16MAY2012	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151662 SCALE: 1:2 SHEET: 3 OF 4 REV: F
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	APPLICATION SPEC: - WEIGHT: - RESTRICTED TO: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

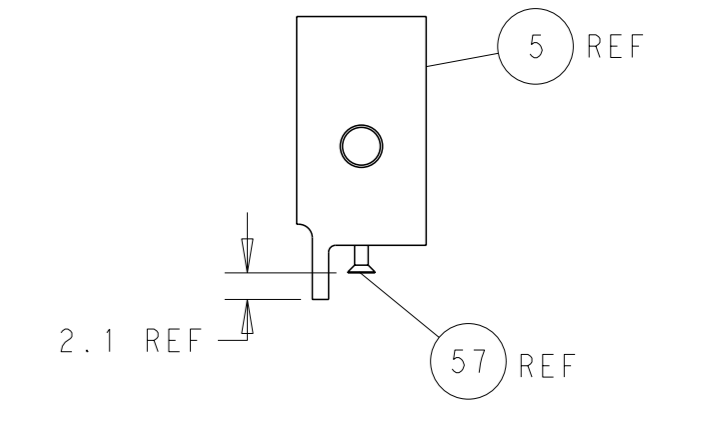
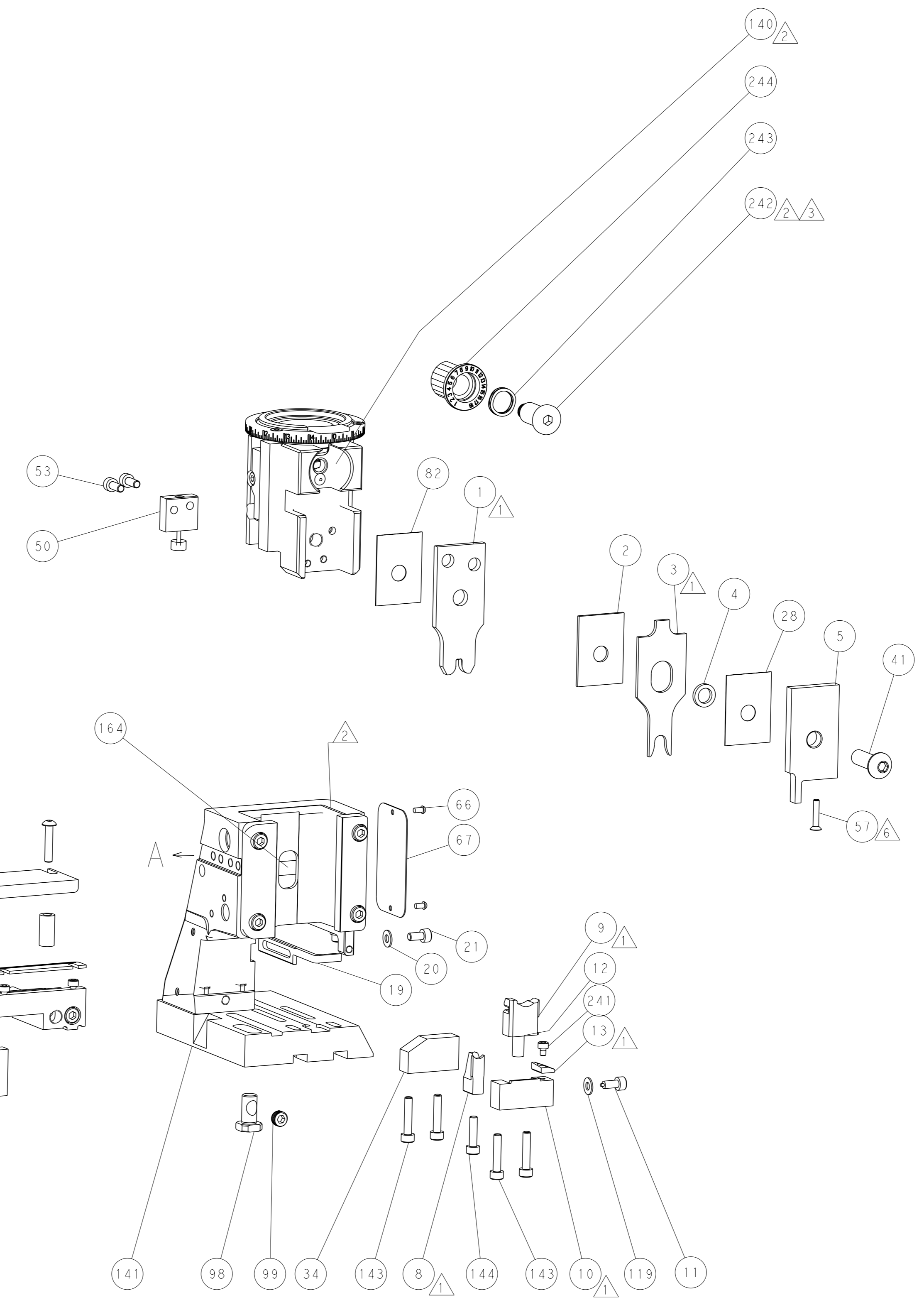
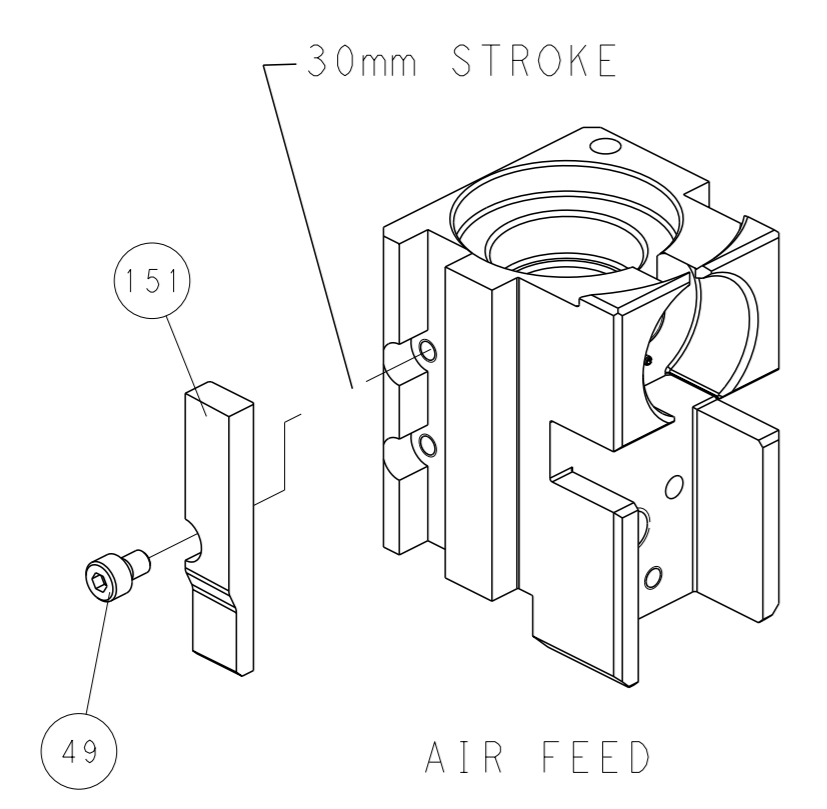
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

FEED TYPE

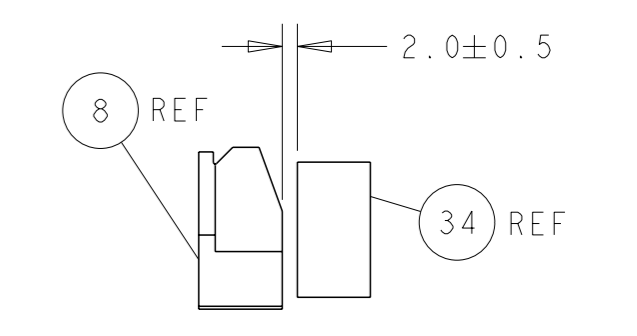
PNEUMATIC



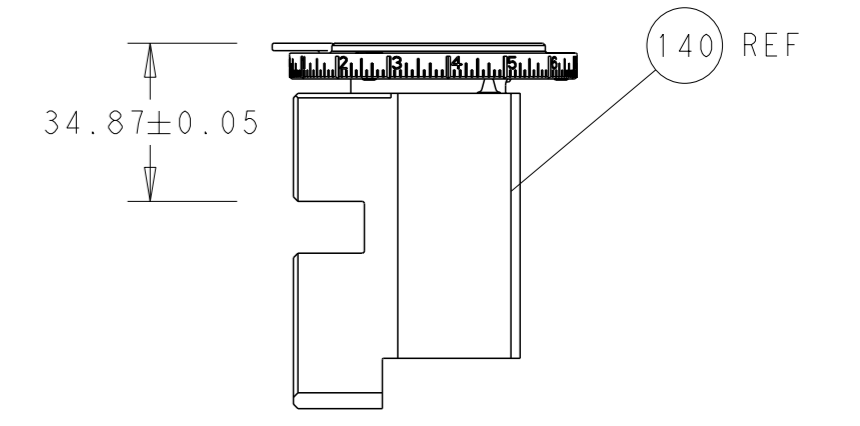
CAM POSITION



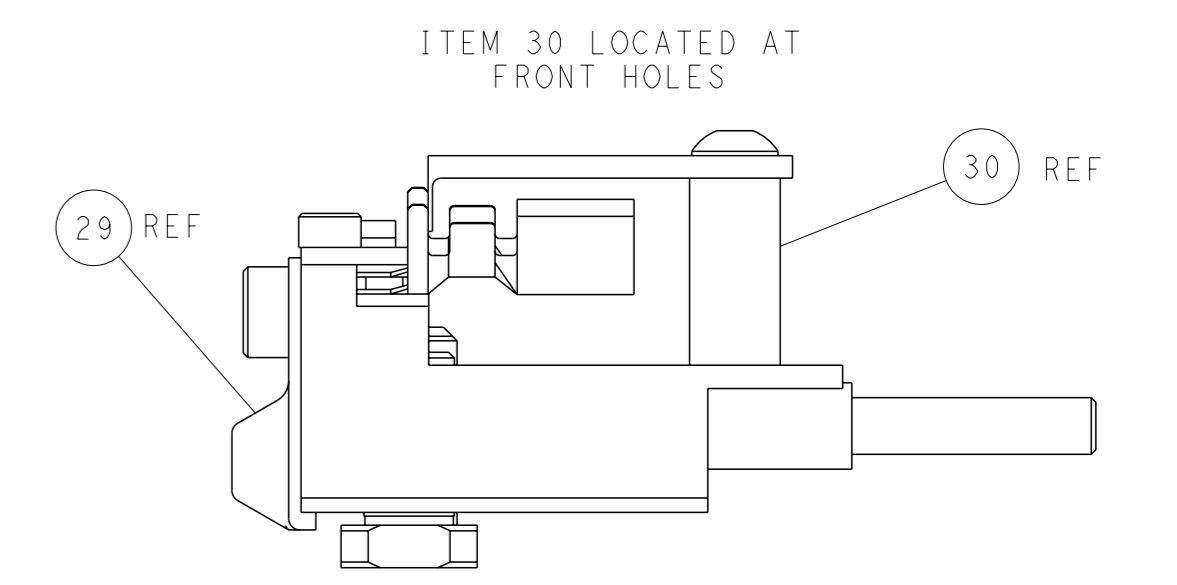
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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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