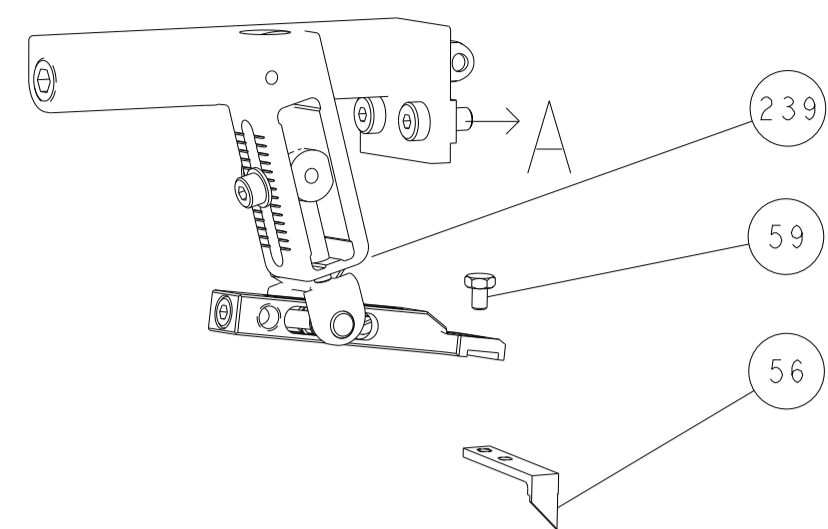
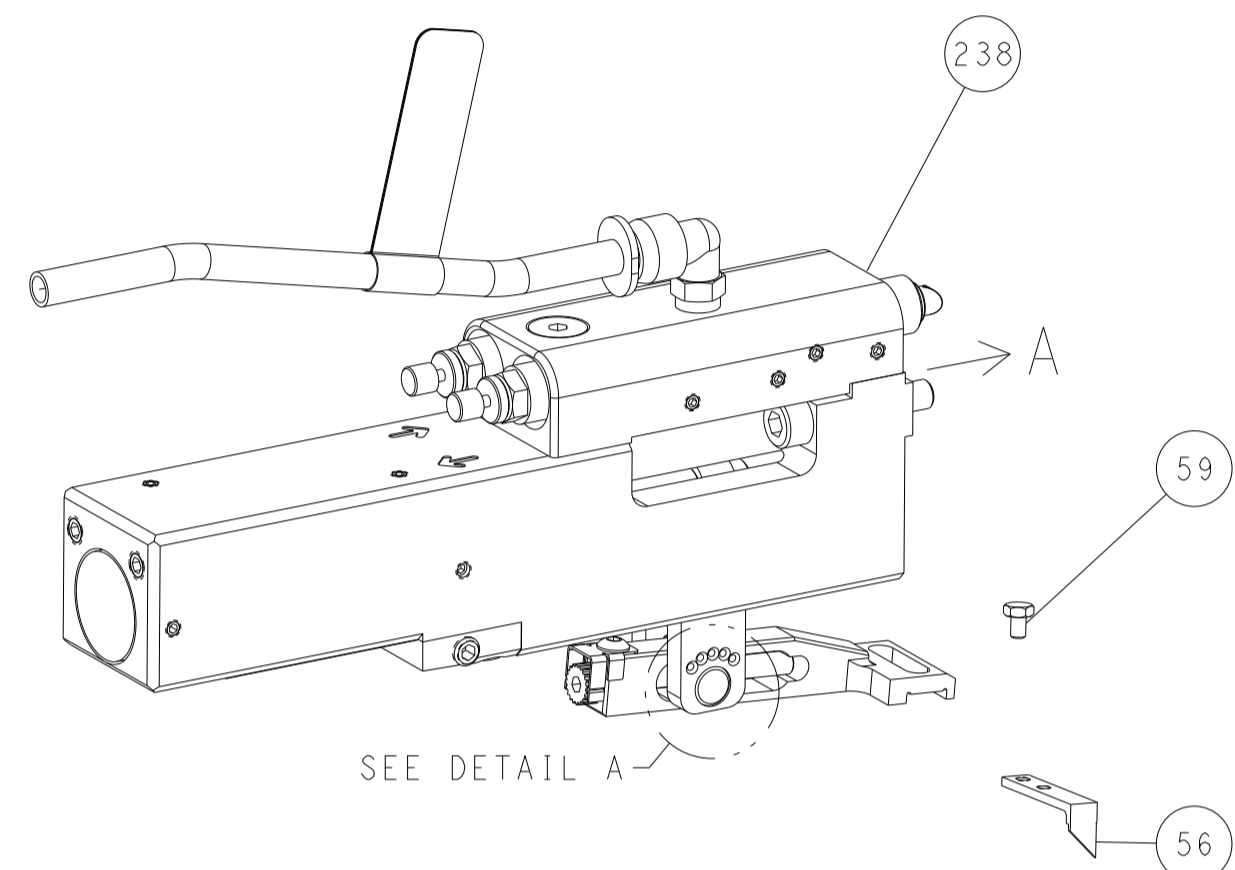


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

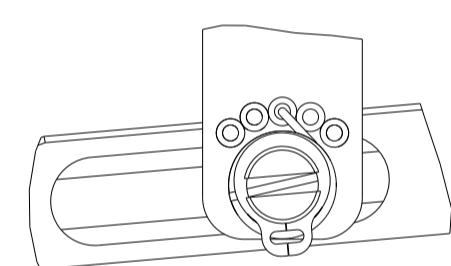
FEED TYPE MECHANICAL



PNEUMATIC

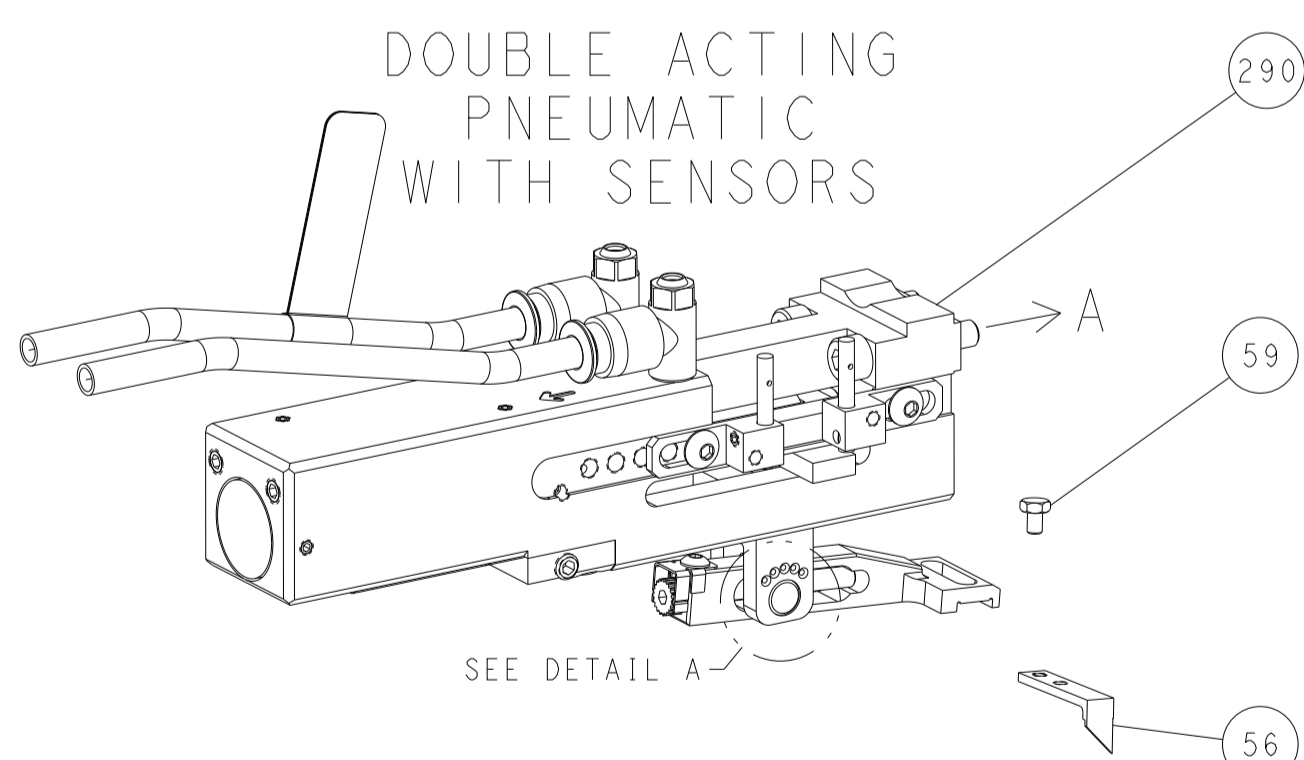


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

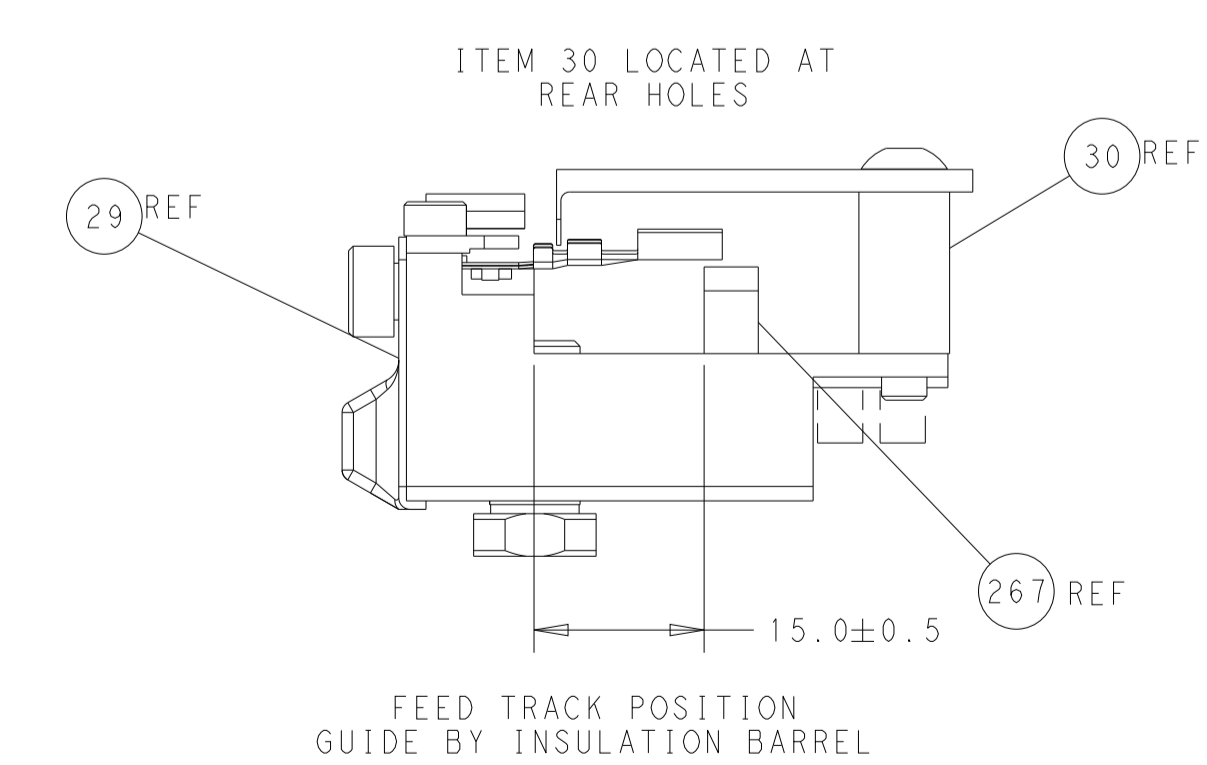
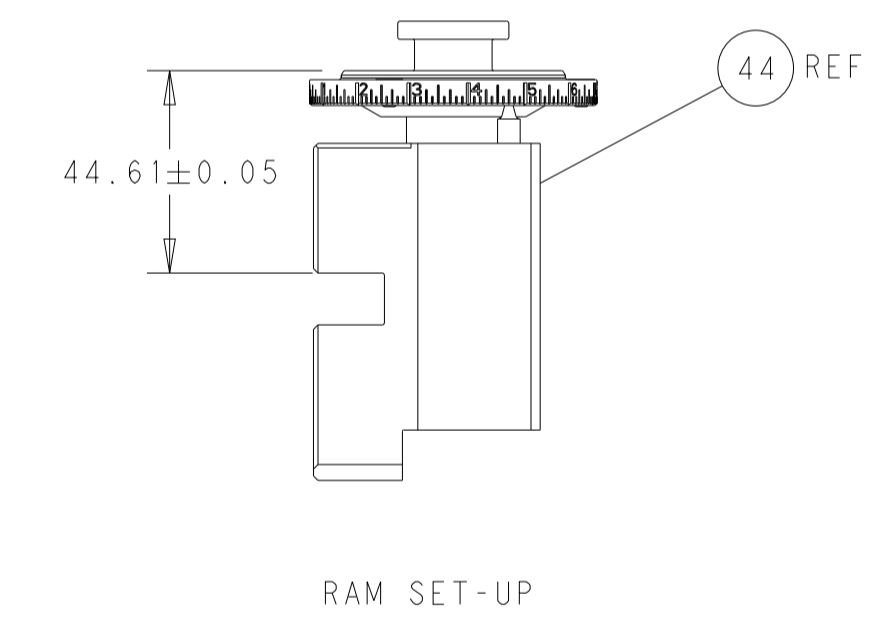
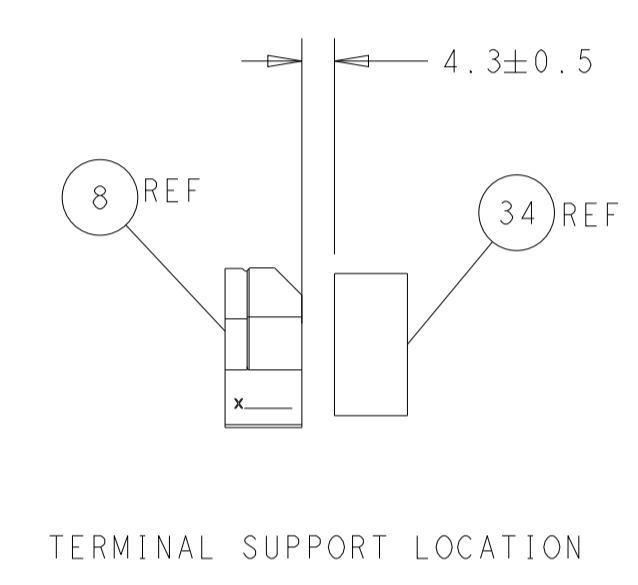
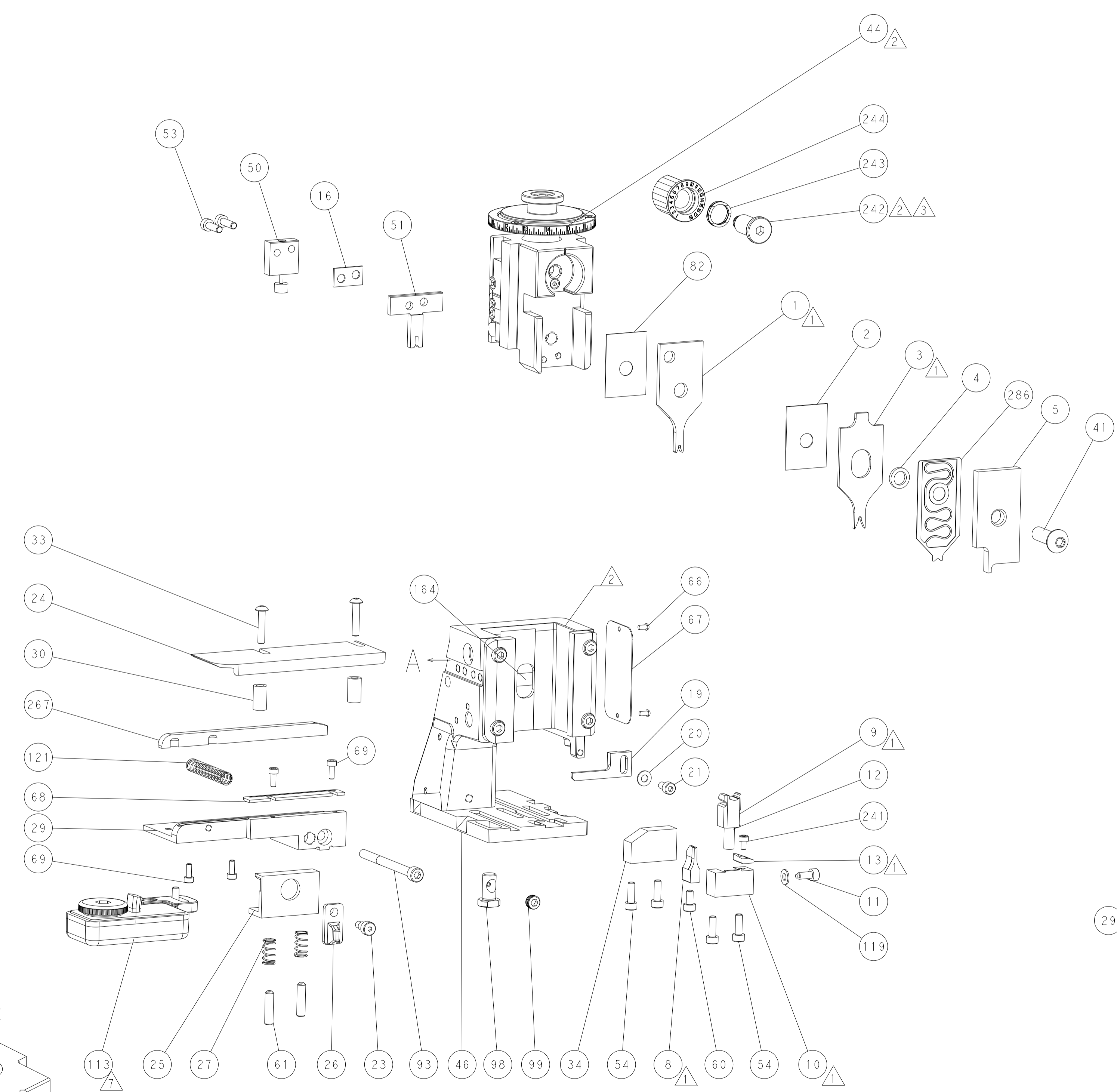
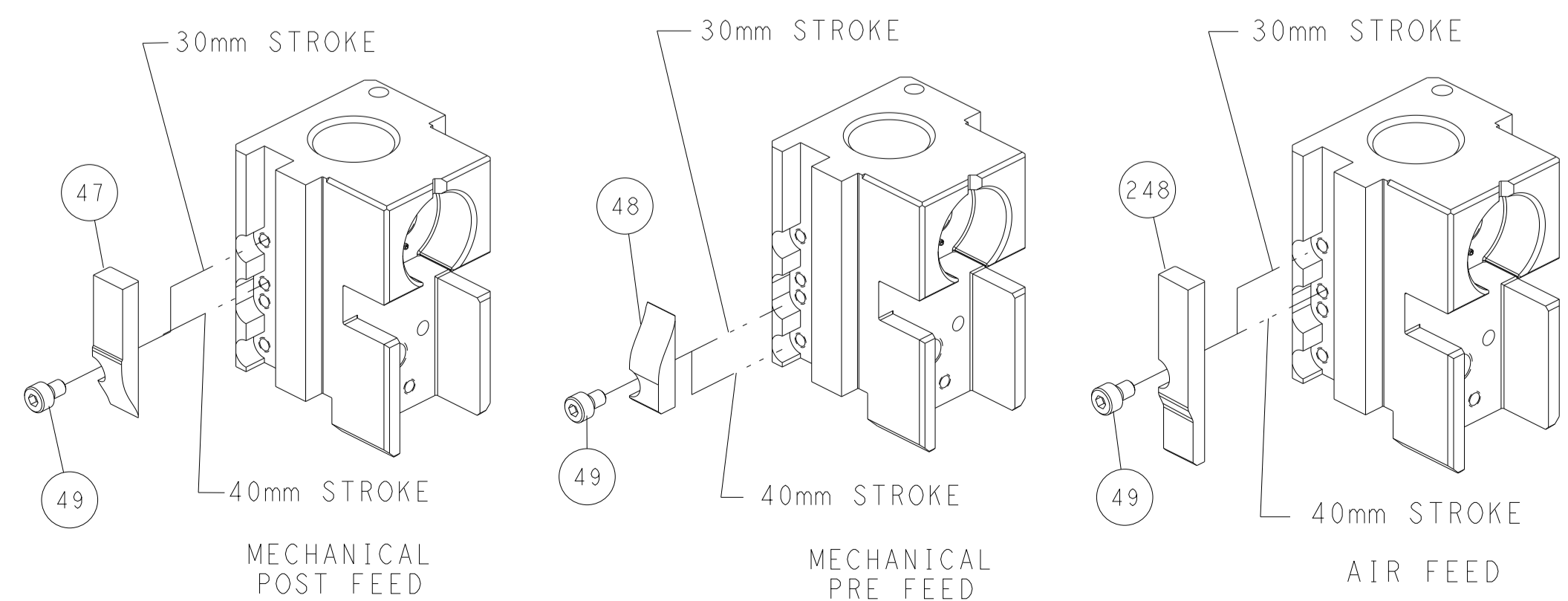


DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS



CAM POSITIONS

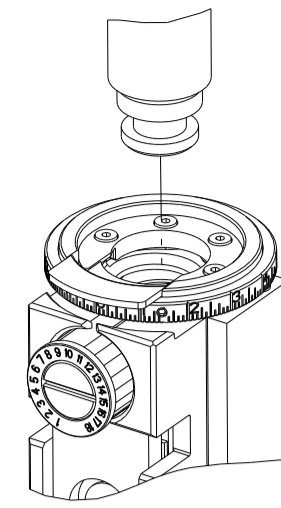


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. STAKEM 14NOV2011 CHK G. BAILEY 14NOV2011 APVD T. ELBIN 14NOV2011		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean Side Feed Applicator	
	ANGLES ±	FINISH ±	MATERIAL		SIZE CAGE CODE DRAWING NO A1 00779 C=2151540		RESTRICTED TO
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:2	SHEET 2 OF 4	REV P1	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151540-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151540-2	P	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151540-2	P	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151540-7	J	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: SIEMENS TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.10-4.70 mm [1.61-.185 IN]	Ø1.10-1.65 mm [.043-.065 IN]		
TERMINAL APPLICATION SPECIFICATION	114-13060		
TERMINALS APPLIED			
TE TERMINAL	SIEMENS TERMINAL	TE TERMINAL	SIEMENS TERMINAL
1393364-1	V23540X7000Y10	1-1438299-0	
1393367-1	V23540X7000Y11	1393364-2	
1438299-2	V23540X7000Y31	1393367-2	
1438299-1	V23540X7000Y30		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.97 +/- 0.04 [.038 +/- .002]	7.7
22 AWG	0.95 +/- 0.04 [.037 +/- .002]	7.9
0.22mm2	0.89 +/- 0.04 [.035 +/- .002]	8.7

- 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 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
- 6 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

***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	REVISONS
A	66	

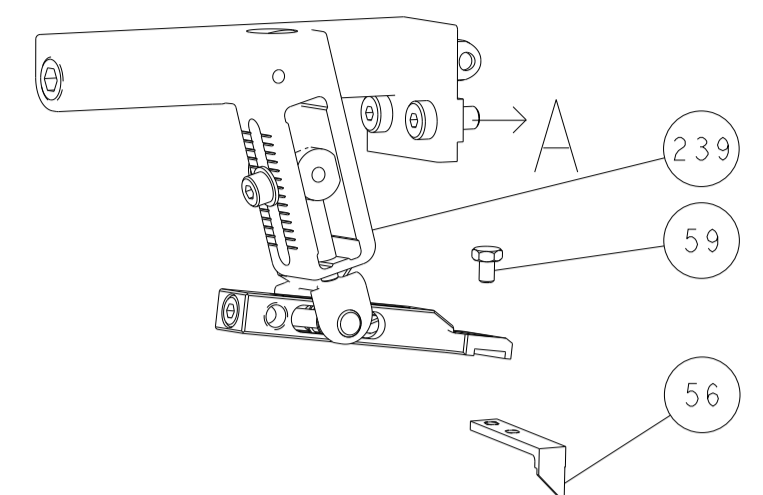
QTY	REF	REF	REF	PART NO	DESCRIPTION	ITEM NO
-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	1	1	1633782-2	FENCE	267
-	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	69
-	1	1	1	2-690438-2	FRONT STRIP GUIDE	68
-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1-1463053-0	HOLDER, TERMINAL	51
-	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	-	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	1-1752356-8	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844938-5	PLATE, STRIP GUIDE	29
-	2	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-2	DRAG, TERMINAL	25
-	1	1	1	1320928-6	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	6-240641-7	SPACER	16
-	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	1-318707-4	FLOATING SHEAR, FRONT	9
1	1	1	1	1-1333201-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	2119757-2	DEPRESSOR, SHEAR	5
-	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	3-1633966-0	CRIMPER, INSULATION O	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	3-1803224-5	CRIMPER, WIRE	1

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

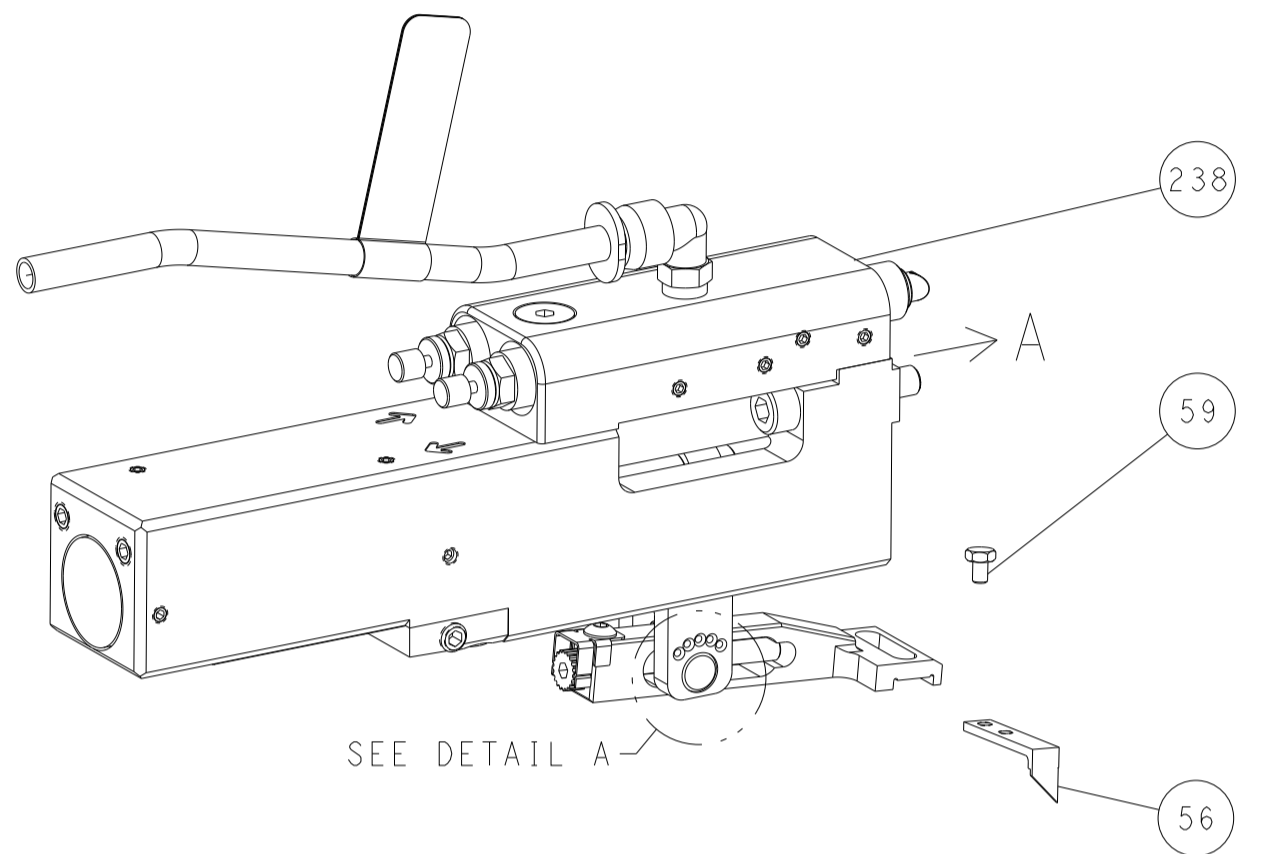
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1 PLC	±	0.15	±		
2 PLC	±	0.15	±		
3 PLC	±	0.15	±		
4 PLC	±	0.15	±		
ANGLES	±		±		
FINISH					
MATERIAL		FINISH		WEIGHT	
				A1	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE		SHEET 3 OF 4	
		1:2		REV P1	

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

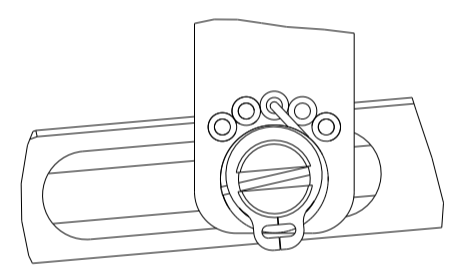
FEED TYPE MECHANICAL



PNEUMATIC

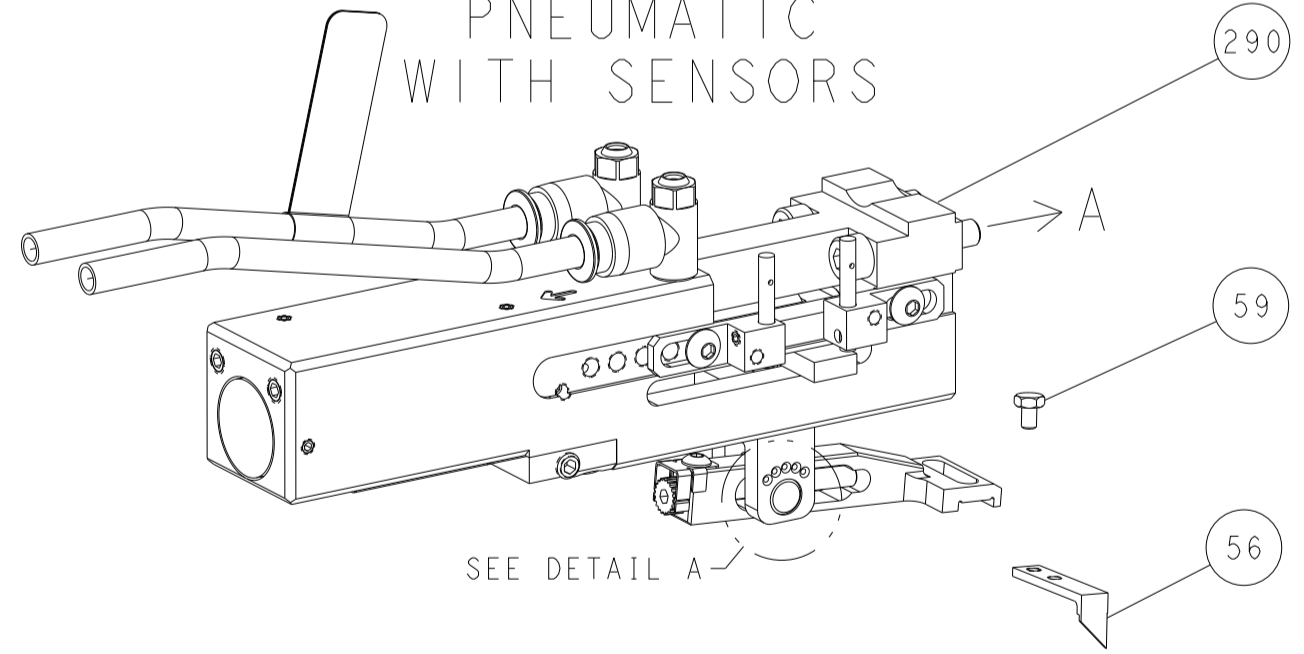


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



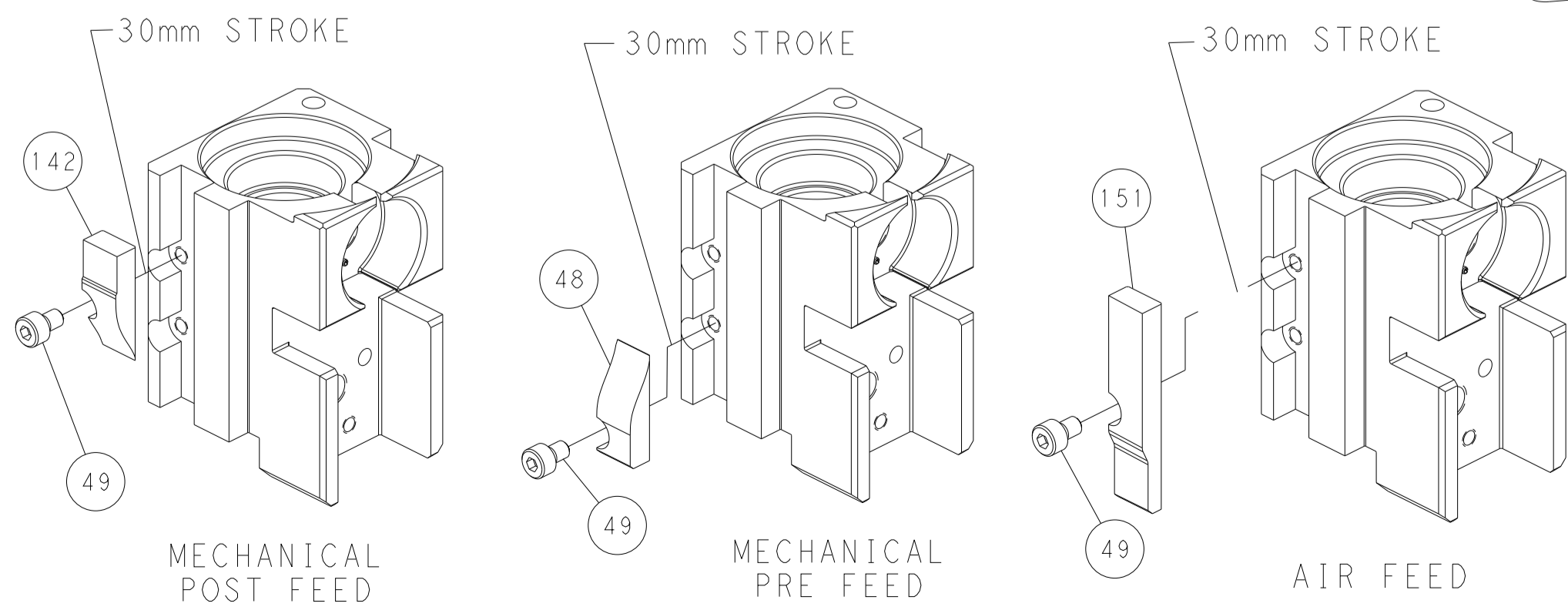
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS



SEE DETAIL A

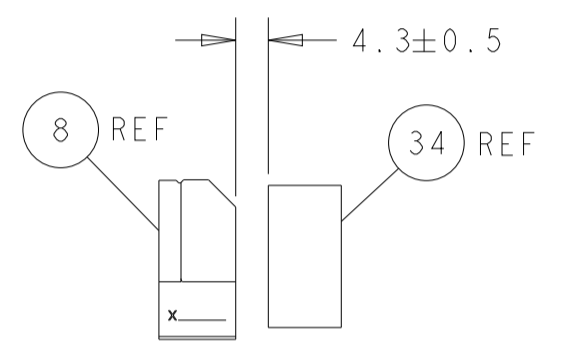
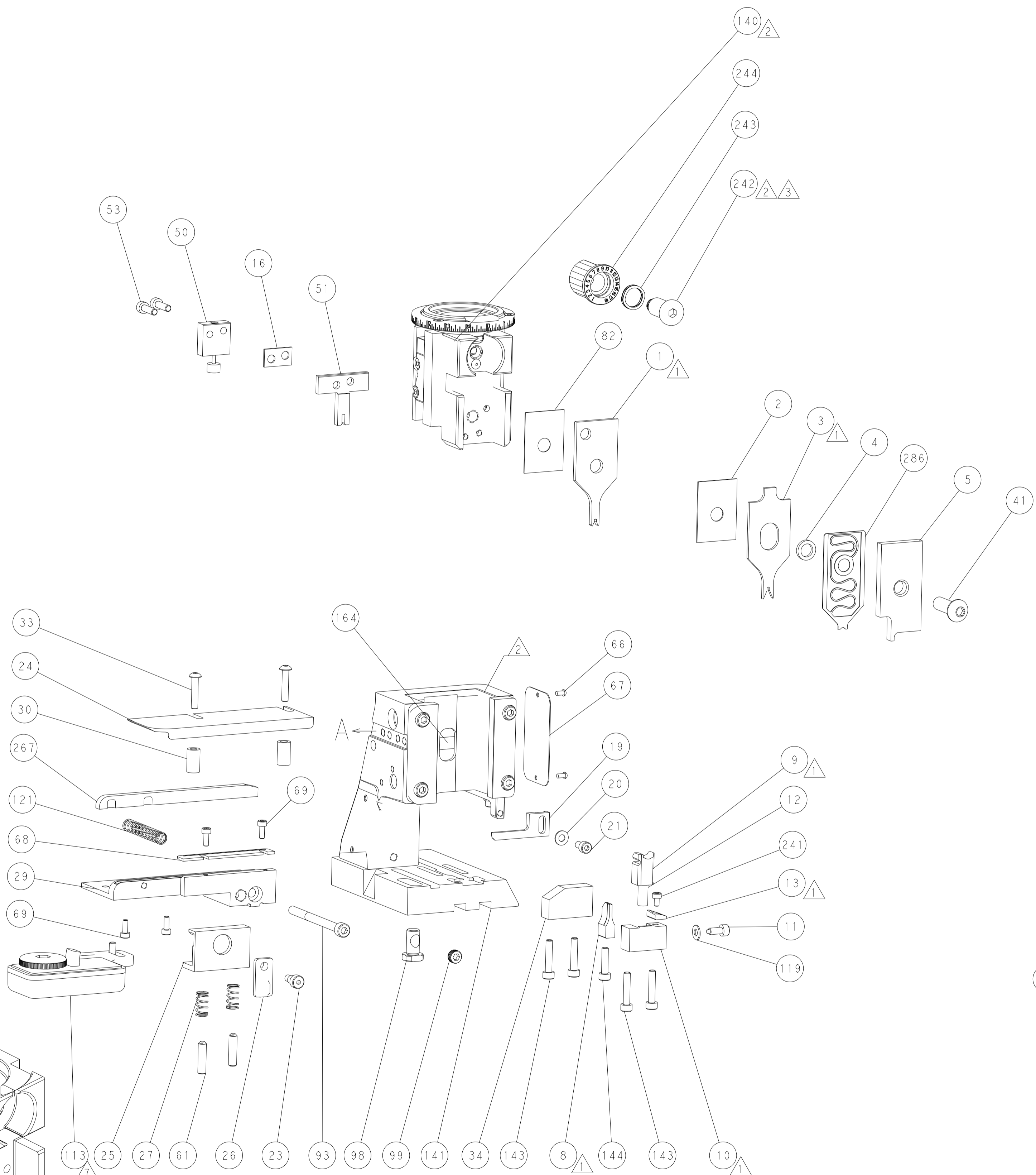
CAM POSITIONS



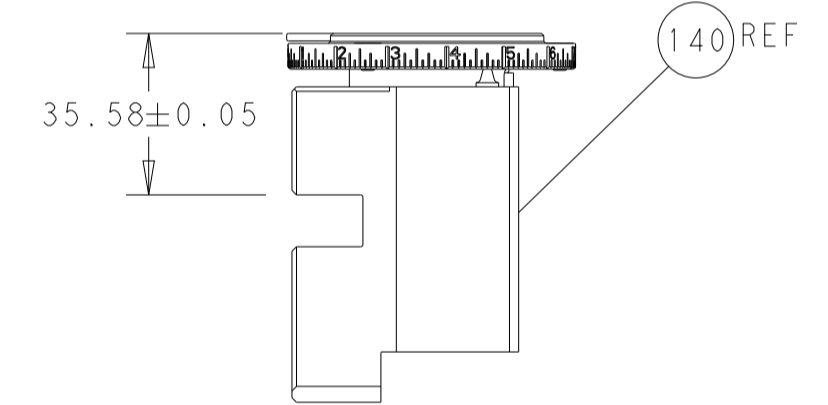
MECHANICAL POST FEED

MECHANICAL PRE FEED

AIR FEED

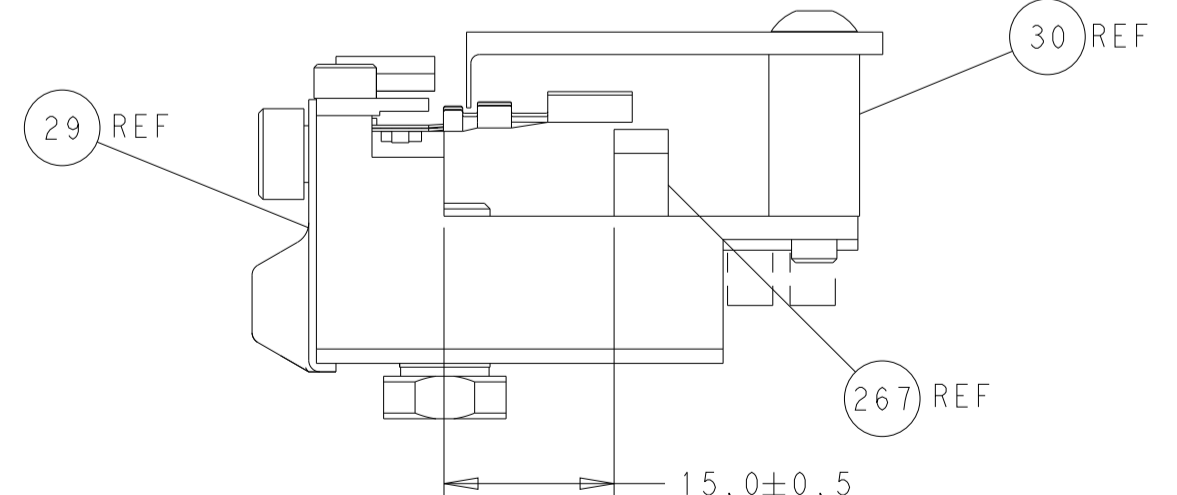


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R. STAKEM 14NOV2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: G. BAILEY 14NOV2011		NAME: Ocean Side Feed Applicator	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2		APVD: T. ELBIN 14NOV2011		RESTRICTED TO:	
SIZE: A1		CAGE CODE: 00779		DRAWING NO: C-2151540		SHEET 4 OF 4	
REV: P1		SCALE: 1:2		SHEET 4 OF 4		REV: P1	

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