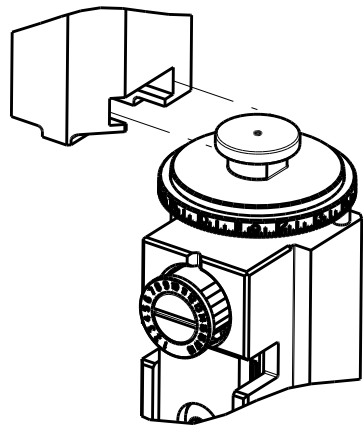


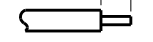
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20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151448-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151448-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151448-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151448-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151448-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.50 mm [.098]	F
INSUL	4.30 mm [1.69]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, FEMALE RECEPTACLE			
WIRE STRIP LENGTH 4.20-5.00 mm [1.65-.197 IN]		INSULATION DIAMETER RANGE Ø2.87-3.53 mm [1.13-.139 IN]	
TERMINAL APPLICATION SPECIFICATION		63900-8200 Rev B	
TERMINALS APPLIED		5	
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2025308-1	19420-0001	1949405-2	19420-0003

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: MALE PIN TERMINAL			
WIRE STRIP LENGTH 4.20-5.00 mm [1.65-.197 IN]		 INSULATION DIAMETER RANGE Ø2.87-3.53 mm [1.13-.139 IN]	
TERMINAL APPLICATION SPECIFICATION 		63900-8200 Rev B - -	
TERMINALS APPLIED 			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113009-1	19417-0011	2113009-3	19417-0027
2113009-2	19417-0025	2113009-4	19417-0029

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.50+/-0.05 [1.059+/-0.002]	6.7
16 AWG OR 1.27mm2	1.45+/-0.05 [1.057+/-0.002]	7.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.70+/-0.05 [1.067+/-0.002]	5.1
16 AWG OR 1.27mm2	1.65+/-0.05 [1.065+/-0.002]	5.2



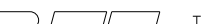
1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. TERMINAL LUBRICANT IS RECOMMENDED.
6. 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.

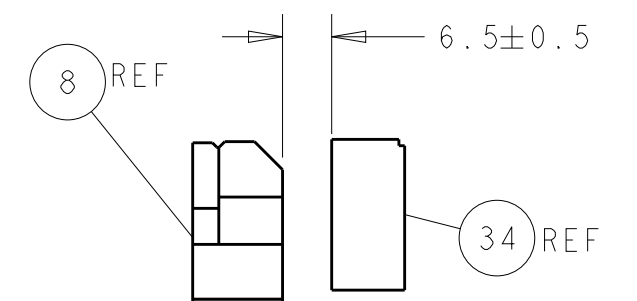
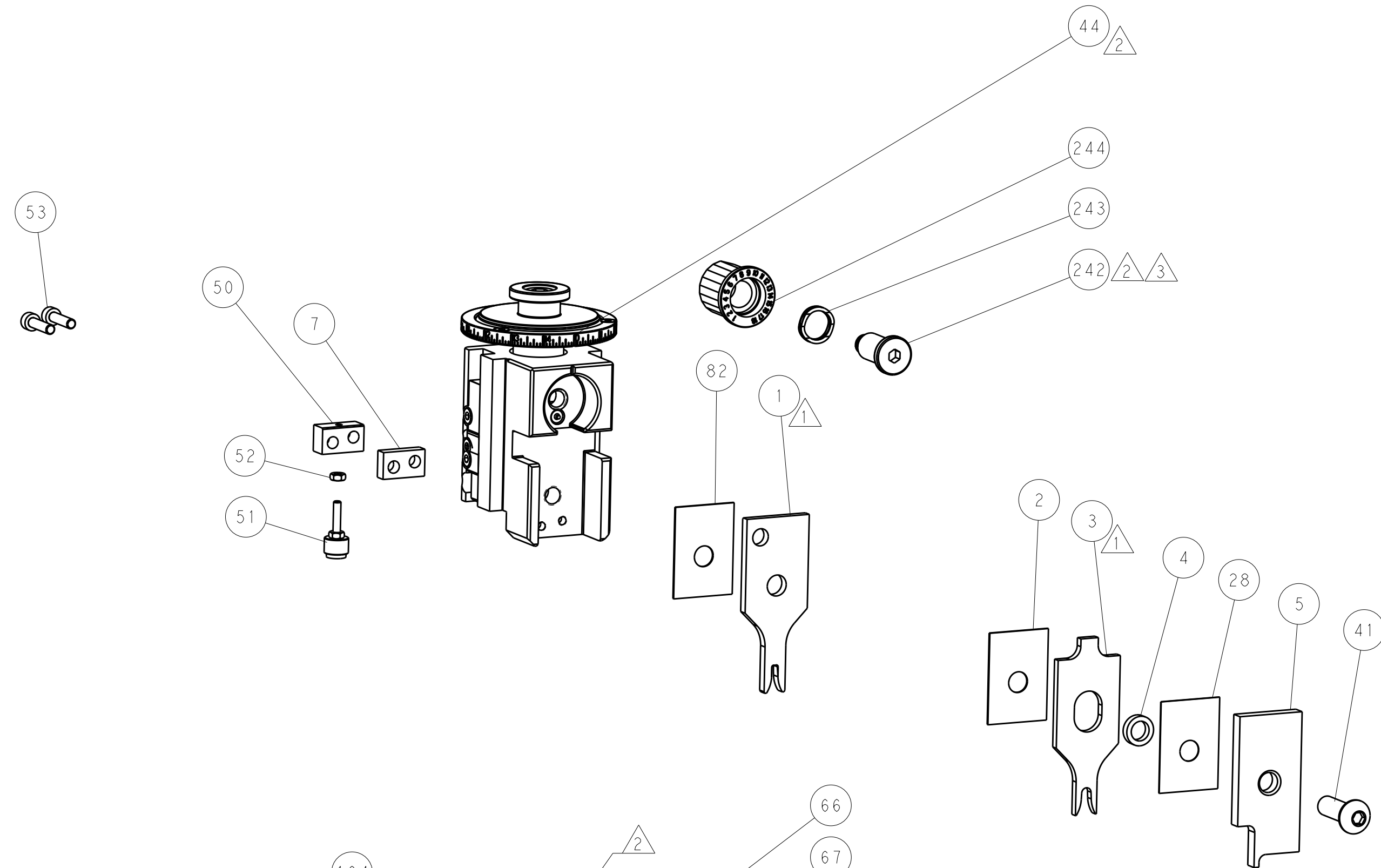
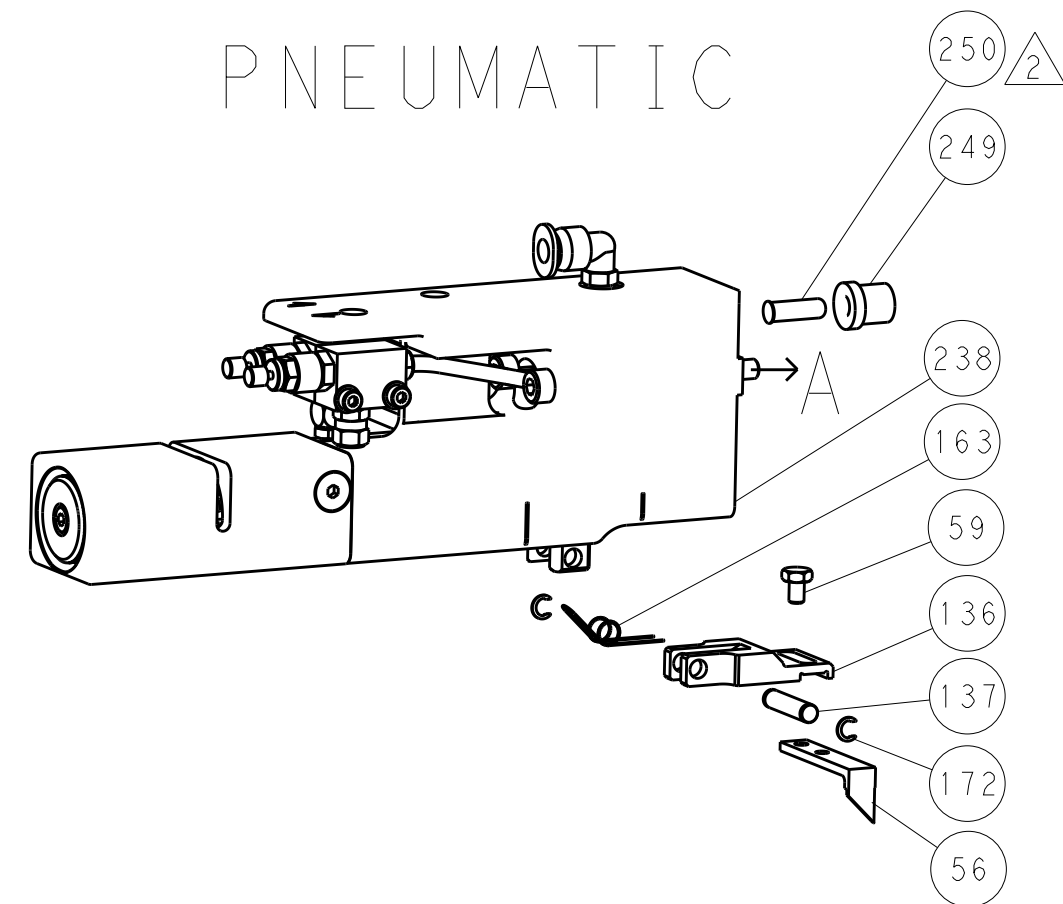
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1					
LOC	DIST	REVISIONS					
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		A		RELEASED	30 JUL 2014	LG	GB
		B		ECR-17-004075	22 MAR 2017	TB	CT
		C		ECR-19-002249	13 FEB 2019	FZ	KZ

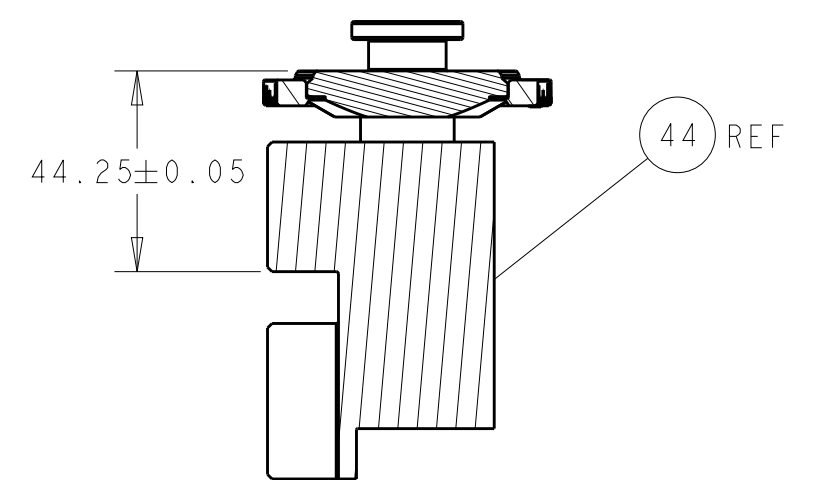
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-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	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	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	5-1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
-	1	2	2	1	1-1633620-6	ANVIL, COMBINATION	8
-	1	1	1	1	2-240641-9	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1-1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	2	1	1633588-1	CRIMPER, WIRE	1

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST EDITION.		DWN	R. HUANG	31MAY2012	 TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS:		CHK	-	-	NAME		
mm		APVD	S. XI	31MAY2012	Ocean Side Feed Applicator -		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE			
0 PLC		±		CAGE CODE			
1 PLC		±		DRAWING NO			
2 PLC		±		RESTRICTED TO			
3 PLC		±		00779			
4 PLC		±		2151448			
ANGLES		±		Customer Accessible Production Drawing			
FINISH		-		SCALE			
-		-		1:2			
-		-		SHEET			
-		-		1 OF 4			
-		-		REV			
-		-		C			

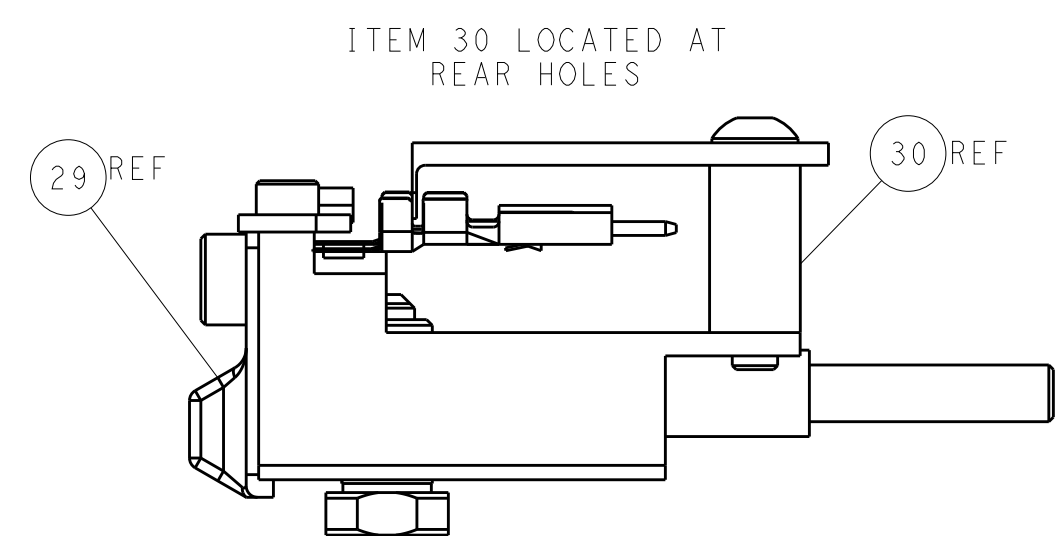
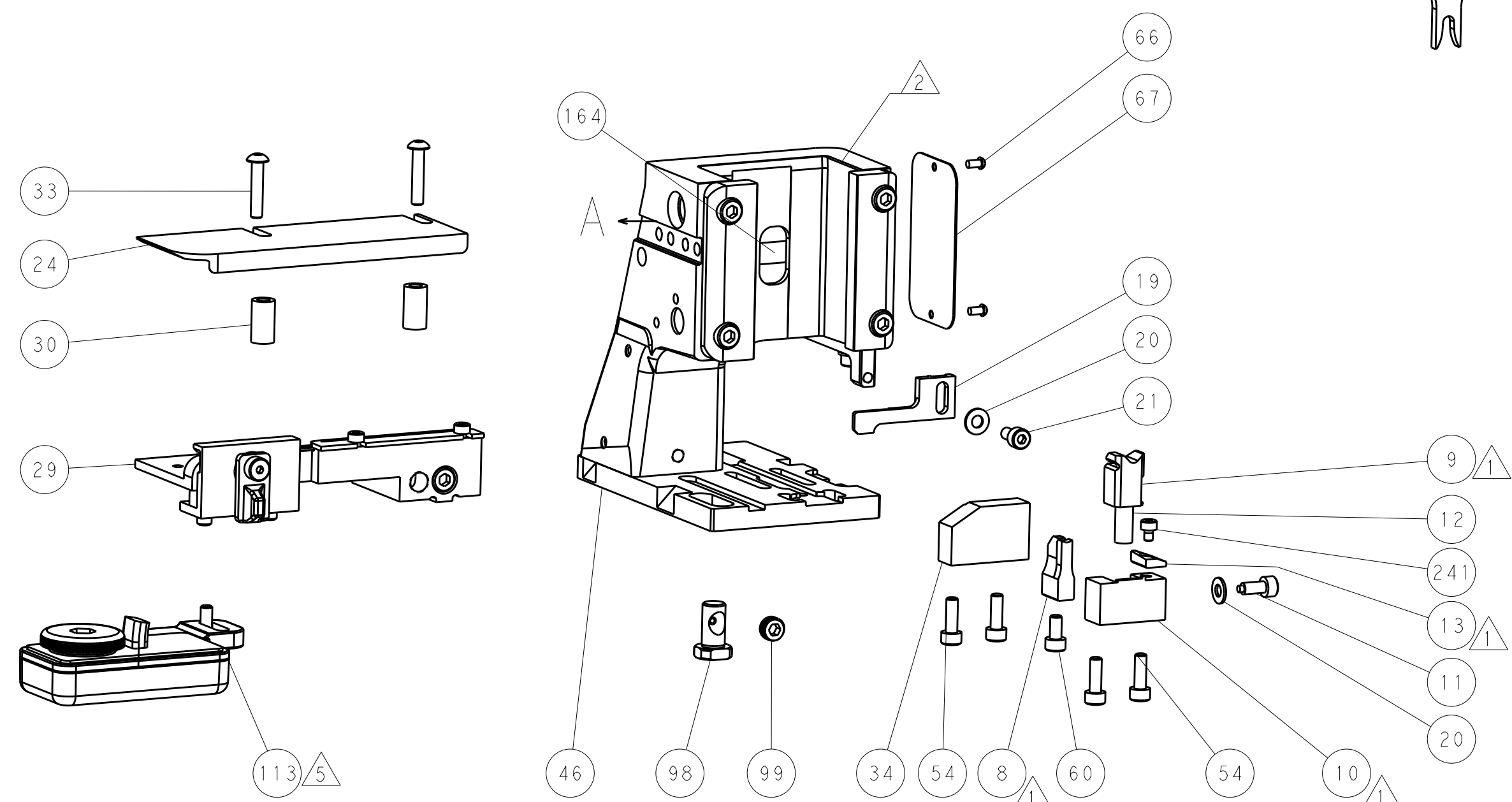
PNEUMATIC



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

30mm STROKE

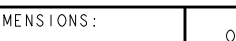
248

49

40mm STROKE

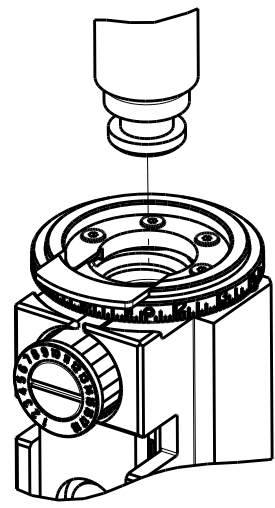
AIR FEED

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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S.XI		NAME	
mm				PRODUCT SPEC		Ocean Side Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APPLICATION SPEC			
MATERIAL		FINISH		WEIGHT		RESTRICTED TO	
-		-		-		-	
Customer Accessible Production Drawing				SIZE A1		CAGE CODE 00779	
				DRAWING NO C-2151448		SCALE 1:2	
				SHEET 2		OF 4	
				REV C			

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151448-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151448-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151448-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.50 mm [.098]	F
INSUL	4.30 mm [.169]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, FEMALE RECEPTACLE			
WIRE STRIP LENGTH 4.20-5.00 mm [.165-.197 IN]		INSULATION DIAMETER RANGE Ø2.87-3.53 mm [.113-.139 IN]	
TERMINAL APPLICATION  63900-8200 Rev B			
SPECIFICATION			
TERMINALS APPLIED 			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2025308-1	19420-0001	1949405-2	19420-0003

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
14 AWG OR 2.00mm2			1.50+/-0.05 [0.059+/- .002]		6.7
16 AWG OR 1.27mm2			1.45+/-0.05 [0.057+/- .002]		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 TERMINAL LUBRICANT IS RECOMMENDED.

6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: MALE PIN TERMINAL			
WIRE STRIP LENGTH 4.20-5.00 mm [1.165-.197 IN]		INSULATION DIAMETER RANGE Ø2.87-3.53 mm [1.113-.139 IN]	
TERMINAL APPLICATION SPECIFICATION 63900-8200 Rev B		- -	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113009-1	19417-0011	2113009-3	19417-0027
2113009-2	19417-0025	2113009-4	19417-0029

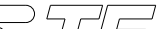
WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
14 AWG OR 2.00mm2			1.70+/-0.05 [0.067+/-0.002]		5.1
16 AWG OR 1.27mm2			1.65+/-0.05 [0.065+/-0.002]		5.2

```
*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)

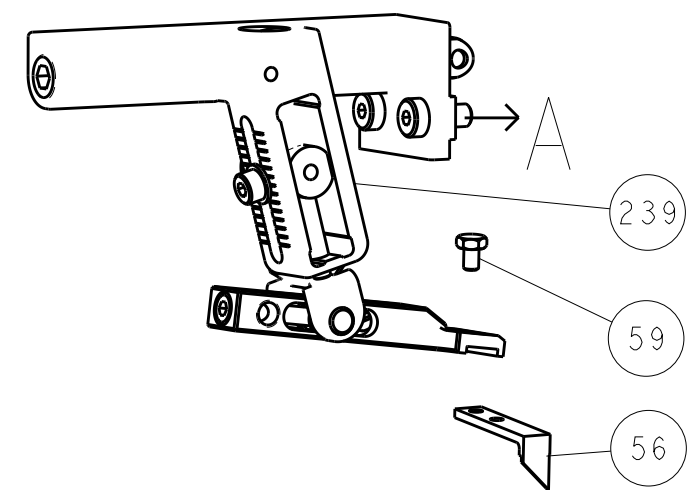
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	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2063440-1	AIR FEED MODULE	238
	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	161
	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	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
5	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-5	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	690753-2	SPACER, TONKER	50
	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	5-1752356-1	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1320928-6	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	1	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
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	-	1	1	2-240641-9	SPACER	7
	-	-	-	-	-	6
	-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	3-1633965-2	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1633588-1	CRIMPER, WIRE	1

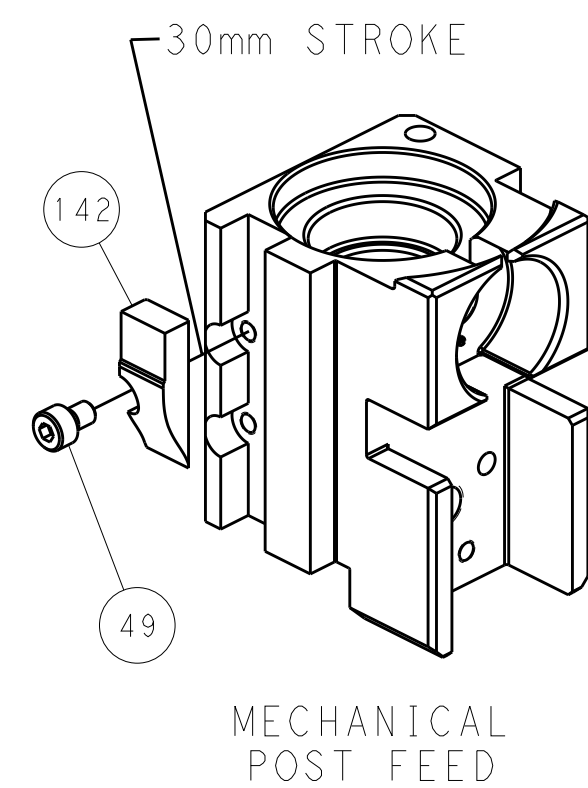
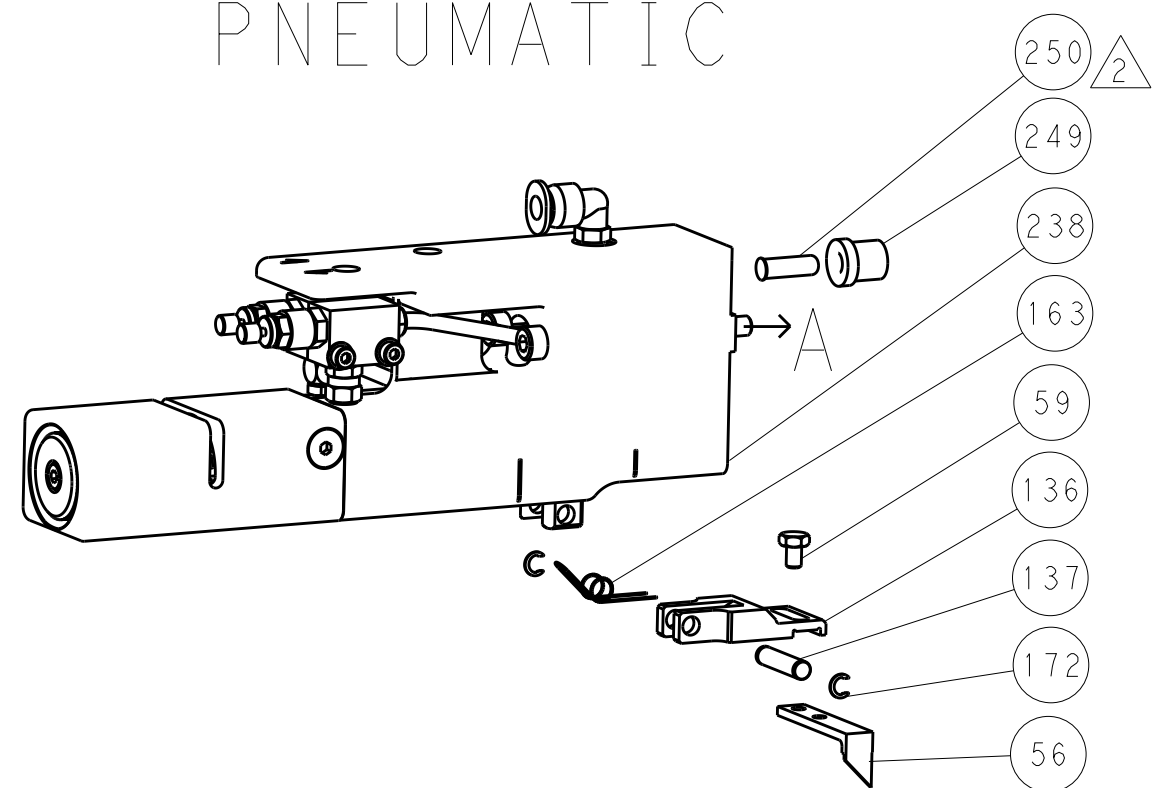
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				CHG. -		Harrisburg, PA 17105-3608			
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		0 PLC ±		PRODUCT SPEC					
		1 PLC ±		APPLICATION SPEC					
		2 PLC ±							
		4 PLC ±							
ANGLES ±°		±°				SIZE CAGE CODE DRAWING NO.		RESTRICTED TO	
MATERIAL -		FINISH -		WEIGHT -		A 00779 C=2151448		-	
Customer Accessible Production Drawing						SCALE 1:2		SHEET 3 OF 4 REV C	

FEED TYPE

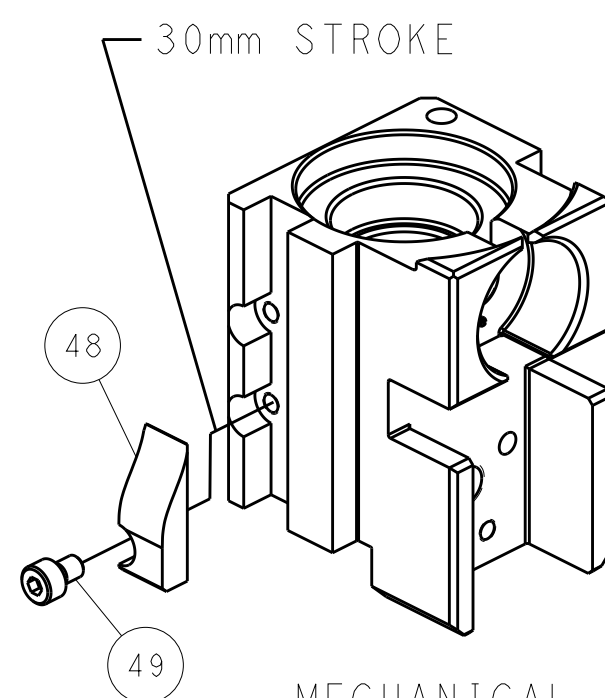
MECHANICAL



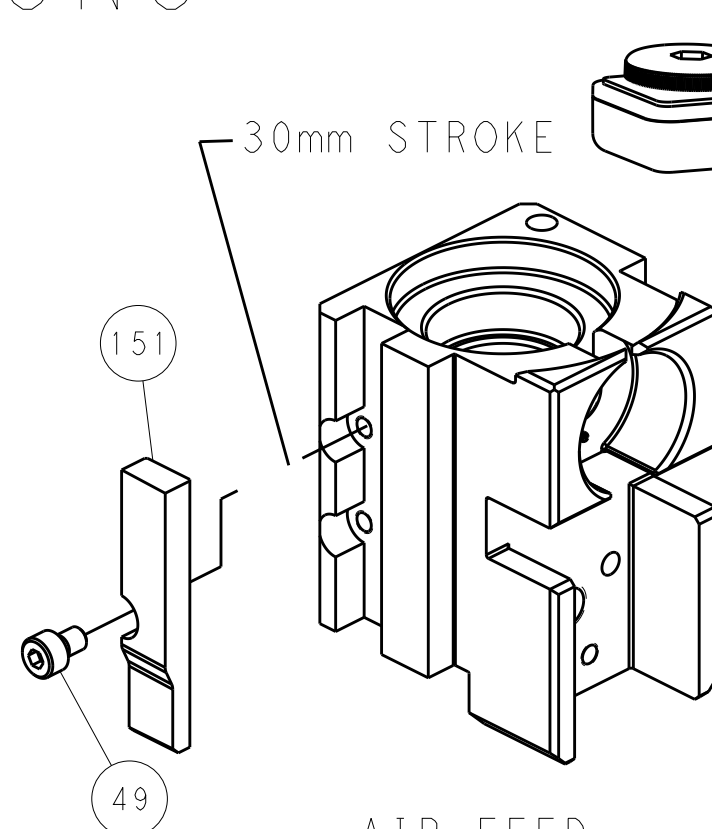
PNEUMATIC



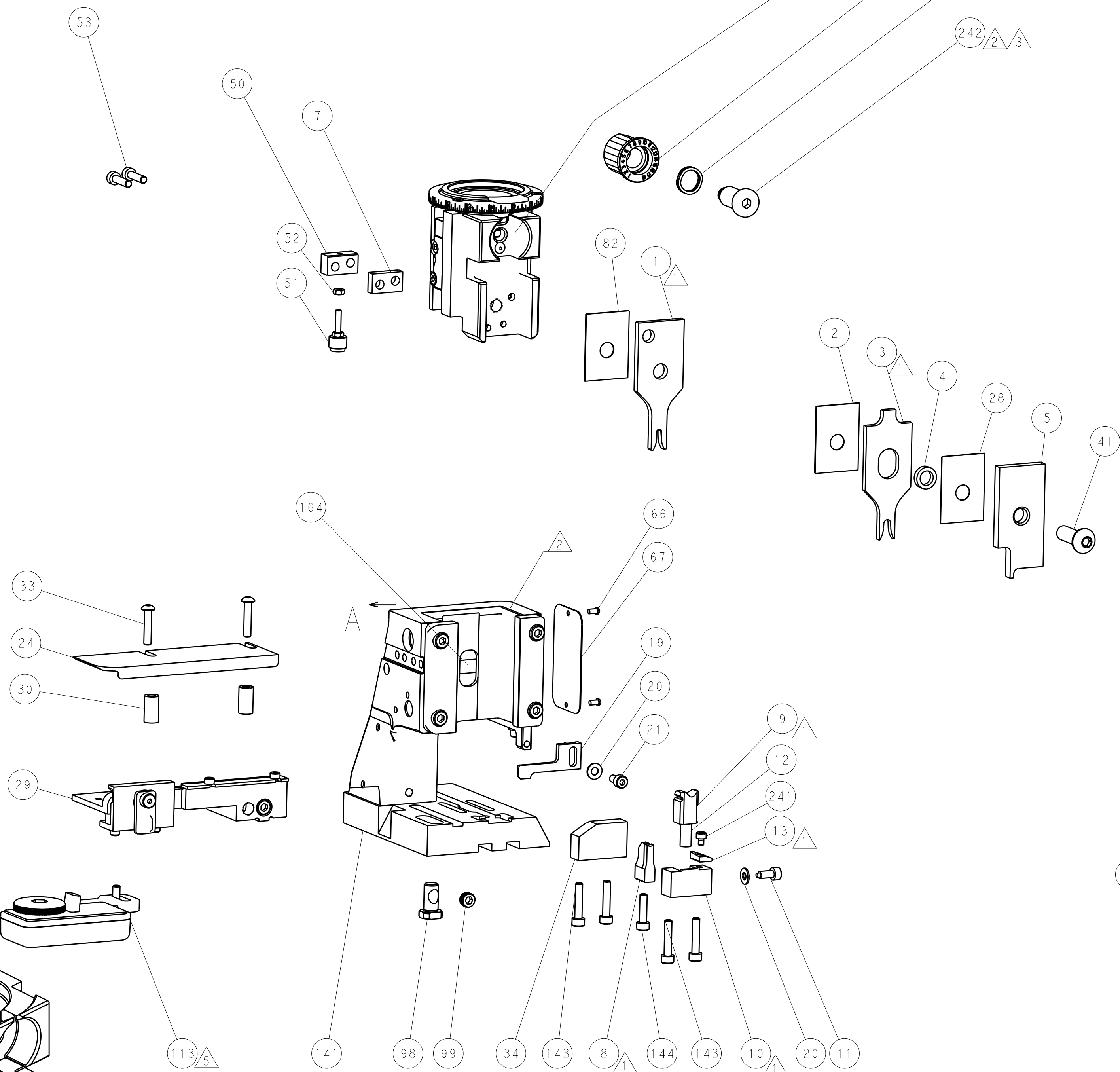
MECHANICAL
POST FEED



MECHANICAL
PRE FEED

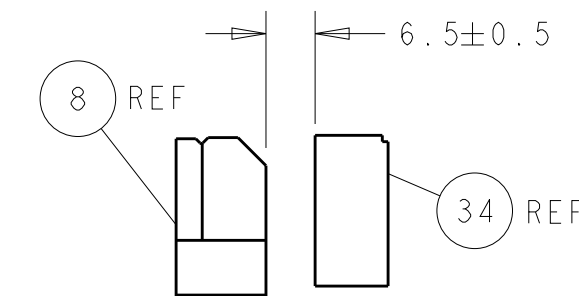


AIR FEED

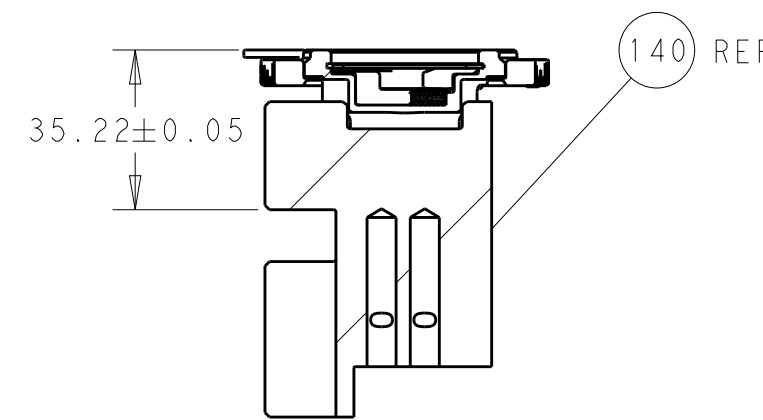


PACIFIC VERSION

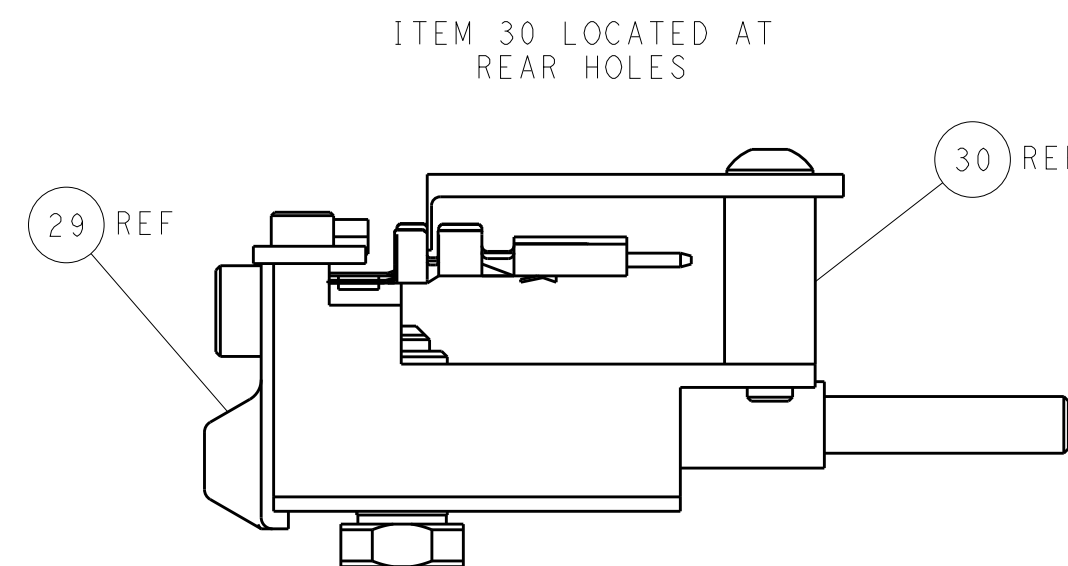
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST VERSION OF THE DRAWING. ANY CHANGES TO THE DRAWING SHALL BE CONTACTED FOR THE LATEST VERSION.		DWN K. HUANG	31MAY2012	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK S. XI	31MAY2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI	31MAY2012	SIZE A	
0 PLC ±		PRODUCT SPEC		CAGE CODE 00779	
1 PLC ±		APPLICATION SPEC		DRAWING NO 2151448	
2 PLC ±				RESTRICTED TO	
3 PLC ±				Customer Accessible Production Drawing	
4 PLC ±				SCALE 1:2	
ANGLES FINISH		WEIGHT		SHEET 4	
MATERIAL				OF 4	
				REV C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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