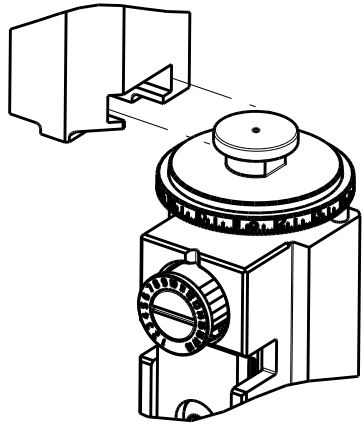


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151817-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151817-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151817-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPT LITEALUM CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.40-4.00 mm [.134-.157 IN]			Ø 3.56-3.74mm [.140-.147 IN]
TERMINAL APPLICATION	114-94204	-	-
SPECIFICATION	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-1862001-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	1.90±0.04 [.0748±.0016]	8.2



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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
6. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
7. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

*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					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		D		ECR-15-015082	14OCT2015	DJG	DS
		E		ECR-16-003273	03MAR2016	JH	CT
		F		ECR-16-013591	23SEP2016	JH	CT
		G		ECR-19-019590	17DEC2019	FZ	TE

3	-	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	268
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-4	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	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2844940-1	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	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	
-	2	2	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	455888-3	SPACER, CRIMPER	82	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119740-1	TAG,IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	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	1338685-1	PAWL, FEED	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	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	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	2-1803583-3	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	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844938-1	PLATE, STRIP GUIDE	29	
-	1	1	1-455888-0	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1803142-1	DRAG, TERMINAL	25	
-	1	1	1320928-2	STRIP GUIDE	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	
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	690472-2	STRIPPER	19	
1	-	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
1	-	1	1	1-356885-5	STOP, SHEAR	11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-6	FLOATING SHEAR, FRONT -	9
	1	2	1	2161316-2	ANVIL, COMBINATION	8
1	-	1	1	2-240641-9	SPACER	7
	-	-	-	-	-	6
1	-	1	1	1-1722335-0	SHEAR DEPRESSOR ASSEMBLY	5
	-	1	1	5-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	1	1722335-8	CRIMPER, INSULATION F	3
	-	-	-	-	-	2
1	1	2	1	2217302-2	CRIMPER, WIRE, CONICAL BLEND	1
-77-72 -2 PART NO					DESCRIPTION	ITEM NO

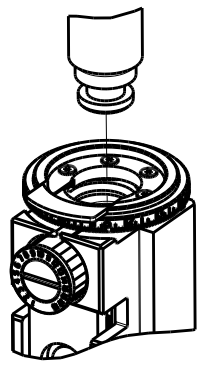
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE USER'S RESPONSIBILITY TO CONTACT THE MANUFACTURING ORGANIZATION FOR THE LATEST EDITION.		DWN A. HUANG CHK S. XI APVD S. XI	07FEB2013 07FEB2013 07FEB2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES		± ± ± ± ± ±		PRODUCT SPEC APPLICATION SPEC	
FINISH		- -		SIZE A1	
MATERIAL		- -		CAGE CODE 00779	
CUSTOMER DRAWING		DRAWING NO 2151817		RESTRICTED TO -	
		SCALE 1:2		SHEET 1 OF 4	
				REV G	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

THIS DRAWING IS A CONTROLLED DOCUMENT FOR ENCLUSTERSHIP CORPORATION 1715 DRAWING 1715-2 CONTROLLED DOCUMENT FOR ENCLUSTERSHIP CORPORATION 1715 IS DESIGN OF THE DRAWING. ANY CHANGES TO THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN 07FEB2013 CHK K. HUANG 07FEB2013 DES S.XI 07FEB2013 APP'D S.XI 07FEB2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
CUSTOMER DRAWING		DRAWING NO C=2151817		RESTRICTED TO -	
		SCALE 1:1		SHEET 2 of 4 REV G	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151817-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151817-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.06 mm [.160]	F

APPLICATOR INSTRUCTIONS
408-35042



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPT LITEALUM CONTACT			
WIRE STRIP LENGTH 3.40-4.00 mm [.134-.157 IN]		INSULATION DIAMETER RANGE Ø 3.56-3.74mm [.140-.147 IN]	
TERMINAL APPLICATION 		114-94204	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL 2-1862001-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
4.00mm ²			1.90±0.04 [0.748±.0016]		8.2



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ⑥ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

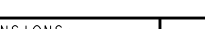
7. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

*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)

[illegible]

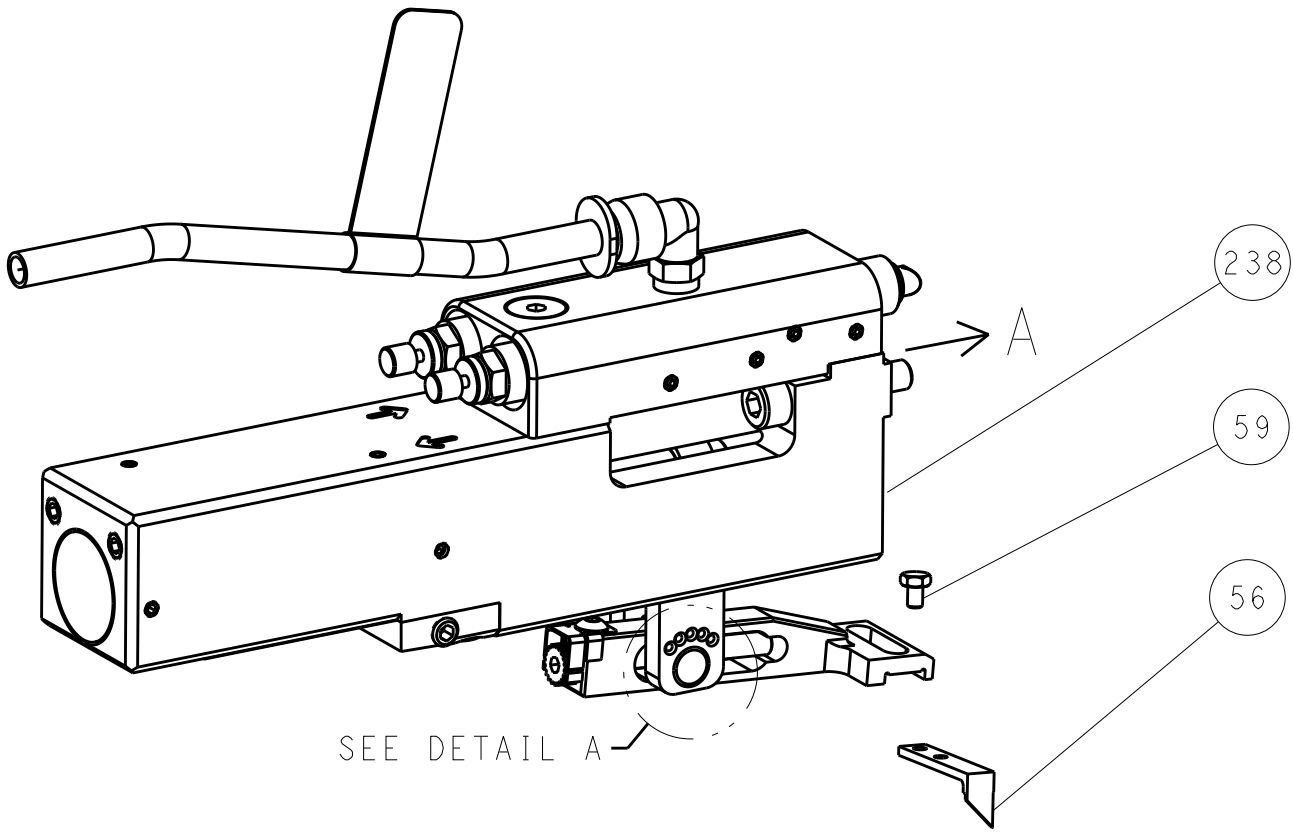
	-	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	268
	-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2844940-1	AIR FEED MODULE	238
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	2119641-2	FEED CAM, AIR FEED	151
	-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	1	2-1803583-4	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1-22281-8	SPRING, COMPRESSION	121
	-	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
	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	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	2119740-1	TAG, IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	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	1338685-1	PAWL, FEED	56
	-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	811242-5	BUMPER, HOLD DOWN	5
	-	1	690753-2	SPACER, TONKER	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	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844938-1	PLATE, STRIP GUIDE	29
	-	1	1-455888-0	SPACER, CRIMPER	28
	-	2	22283-1	SPRING, COMPRESSION	27
	-	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1803142-1	DRAG, TERMINAL	25
	-	1	1320928-2	STRIP GUIDE	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
	-	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	690472-2	STRIPPER	19
1	-	1	2119806-1	INSERT, SHEAR	13
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-5	STOP, SHEAR	11
	-	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1803095-6	FLOATING SHEAR, FRONT -	9
	1	1	2161316-2	ANVIL, COMBINATION	8
	-	1	2-240641-9	SPACER	7
	-	-	-	-	6
	-	1	1-1722335-0	SHEAR DEPRESSOR ASSEMBLY	5
	-	1	5-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1722335-8	CRIMPER, INSULATION F	3
	-	-	-	-	2
1	1	1	2217302-2	CRIMPER, WIRE, CONICAL BLEND	1
-77	-22	PART NO	DESCRIPTION		ITEM NO

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DIMENSIONS: mm		TOLERANCES, UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APPLICATION SPEC		Ocean Side Feed Applicator		A 00779		C=2151817				-	
MATERIAL		FINISH		WEIGHT		CUSTOMER DRAWING		SCALE		SHEET		3 of 4		REV G	
-		-		-				1:2							

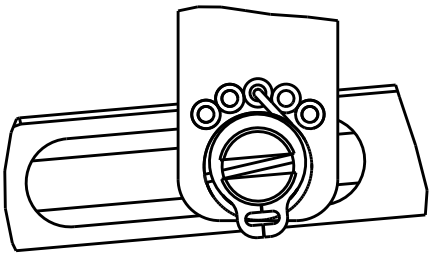
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

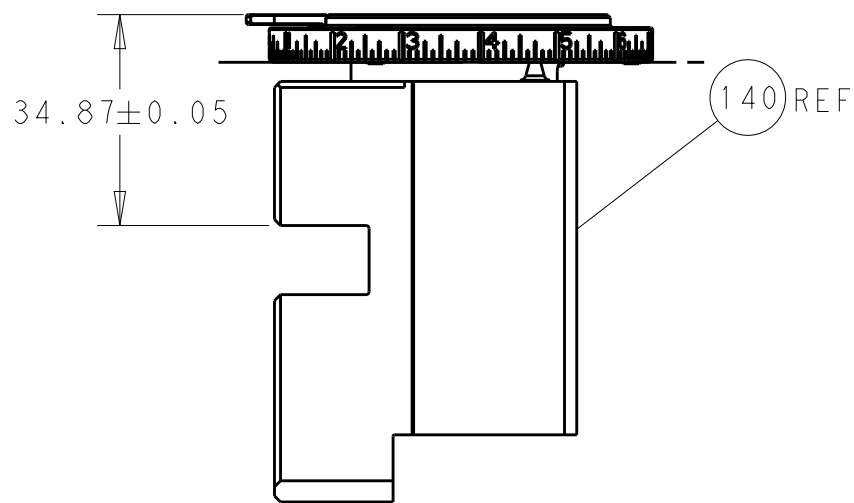
PNEUMATIC



FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

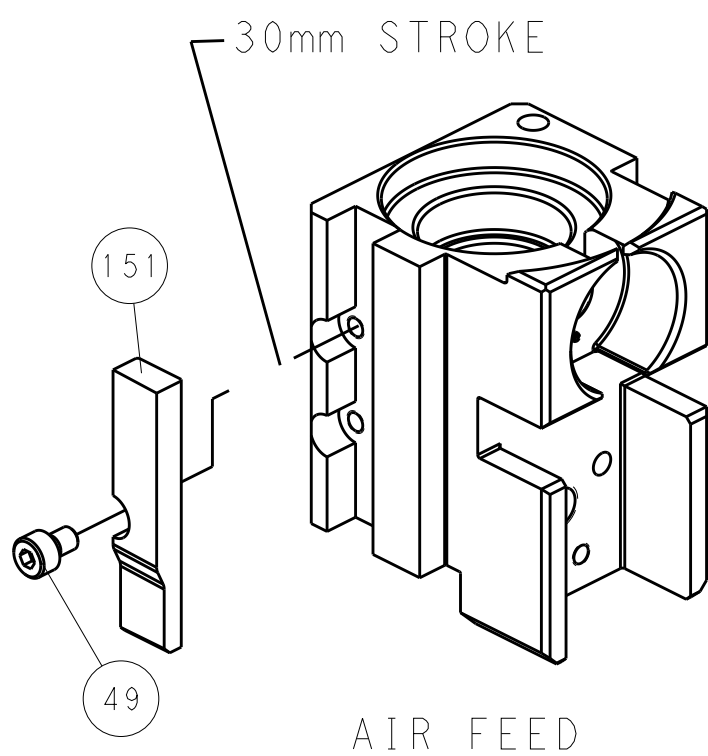


DETAIL A

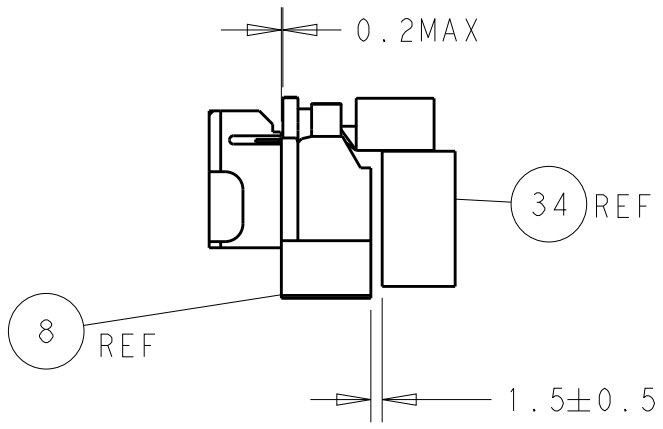
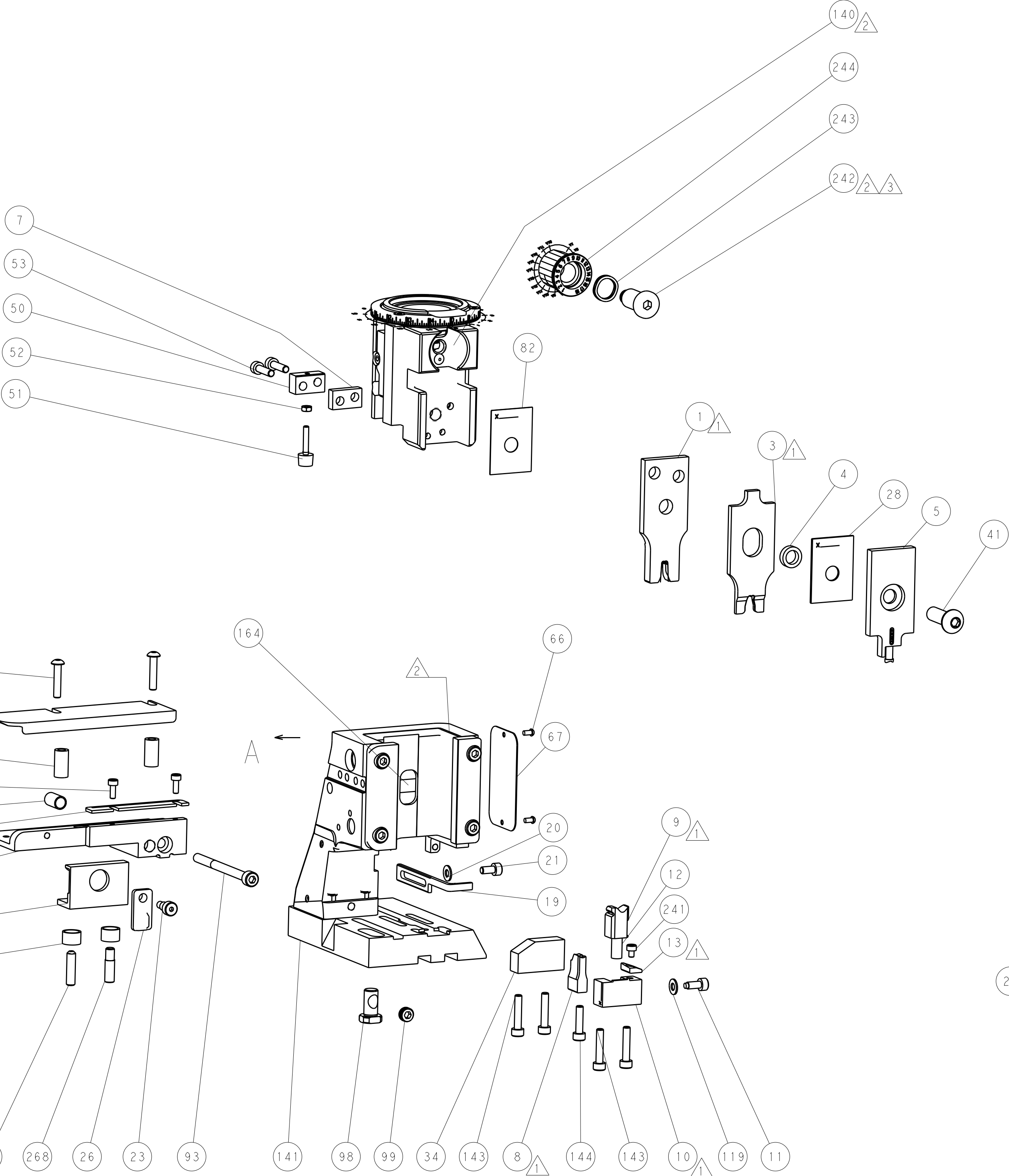


RAM SET-UP

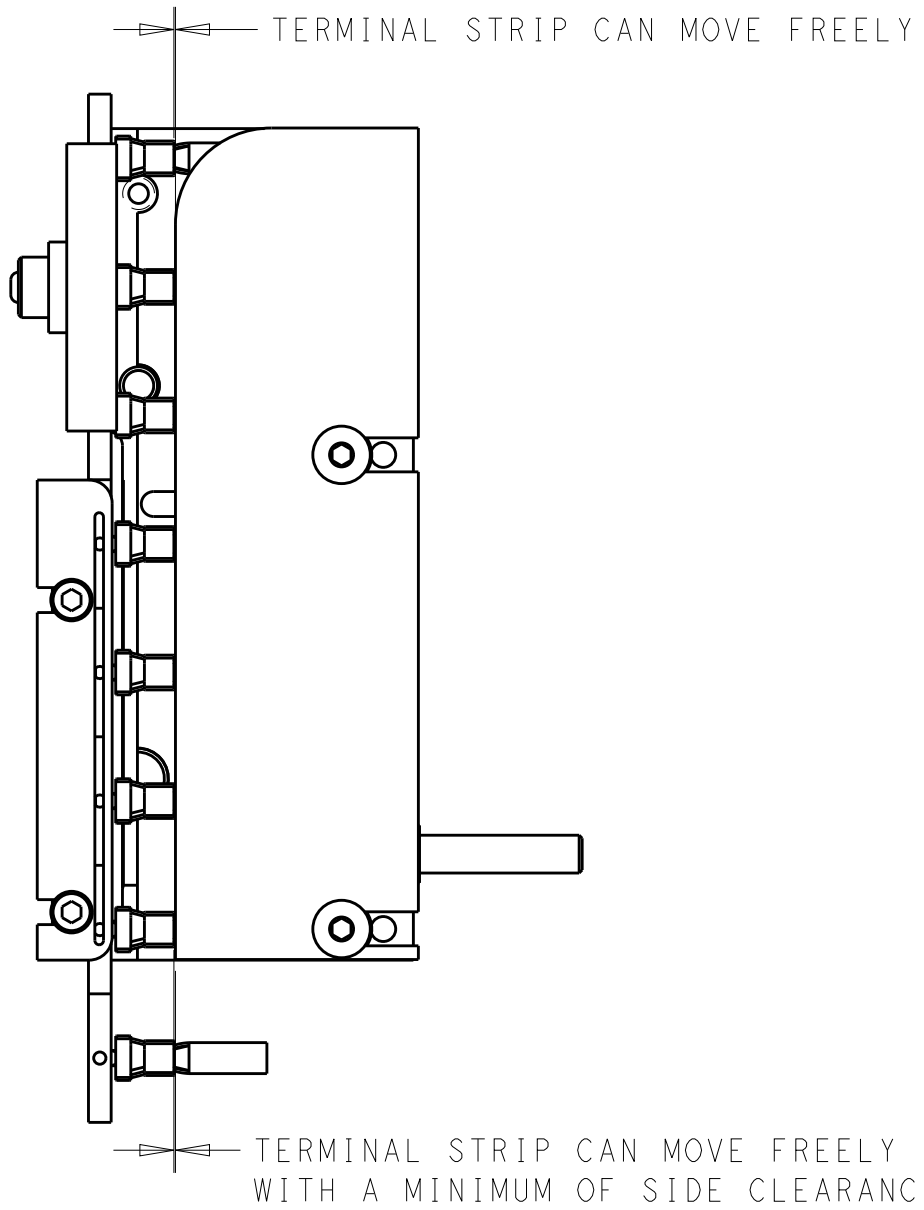
CAM POSITIONS



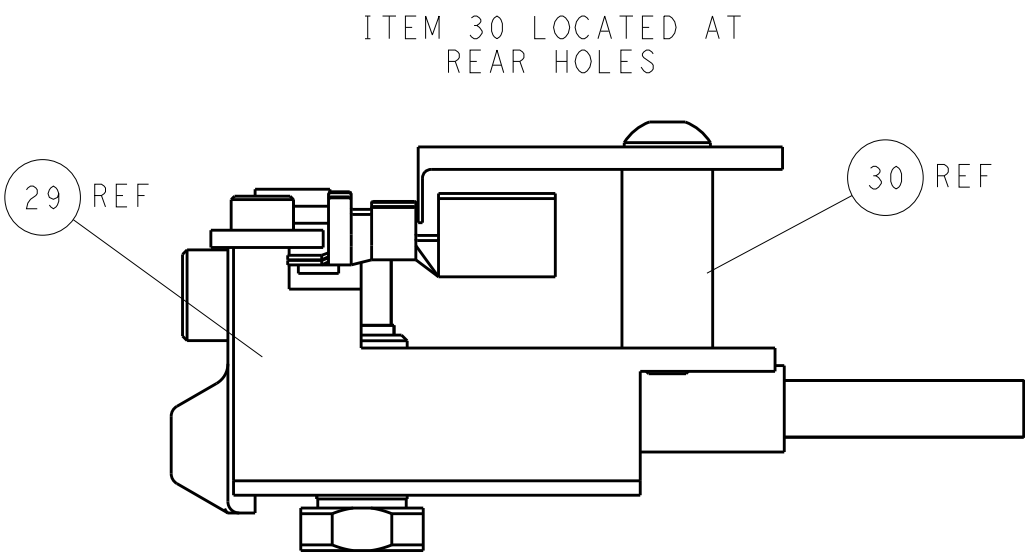
AIR FEED



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION



FEED TRACK POSITION
GUIDE BY WIRE 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:		DWN 07FEB2013		CHK S.XI 07FEB2013		APVD S.XI 07FEB2013		NAME	
mm		0 PLC ±		PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE	
1 PLC ±		2 PLC ±		WEIGHT		CUSTOMER DRAWING		SCALE		SHEET	
3 PLC ±		4 PLC ±		1:2		4		OF		4	
ANGLES		FINISH		REV		G					
MATERIAL											

STE TE Connectivity
Harrisburg, PA 17105-3608

Ocean Side Feed
Applicator

00779 ©=2151817