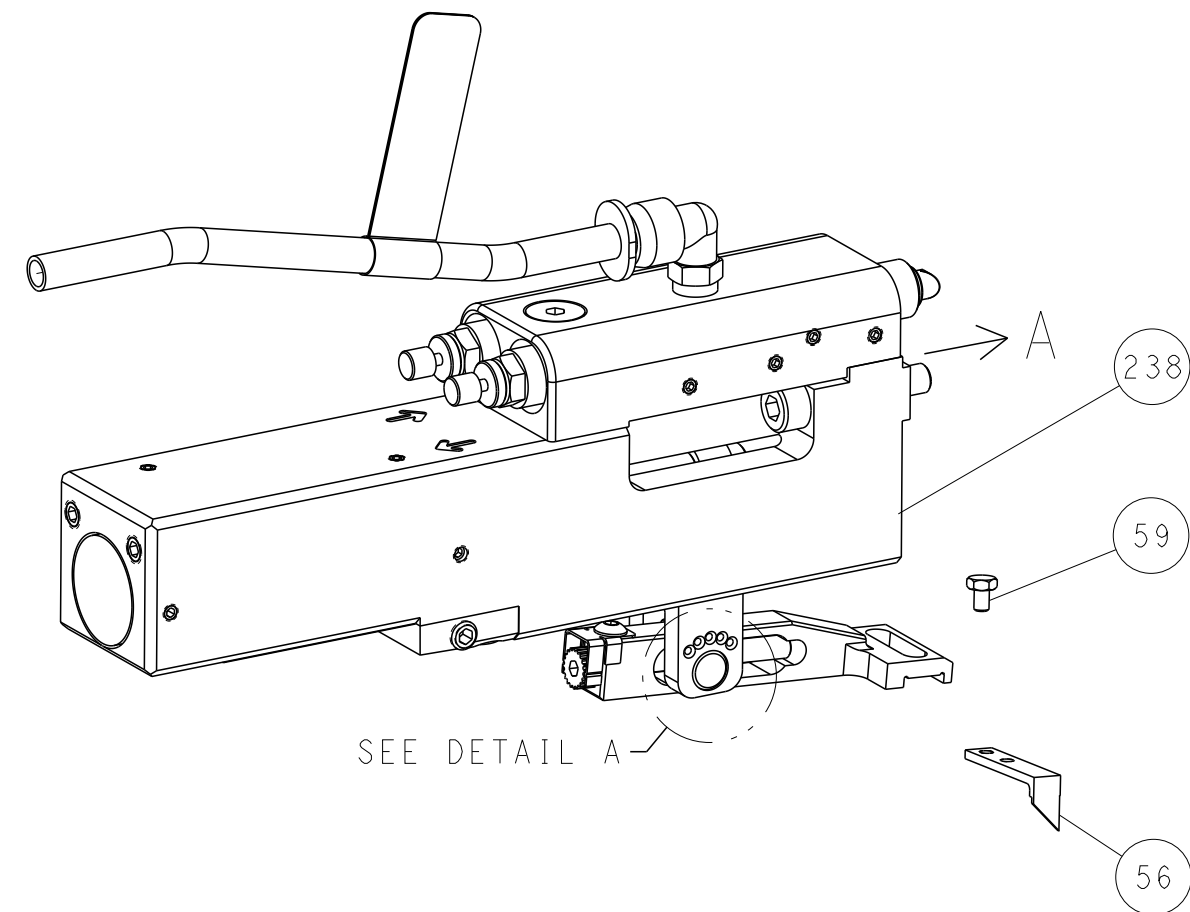
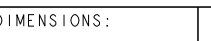


PNEUMATIC

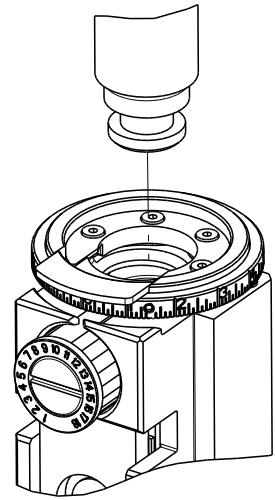
[illegible]

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

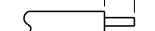
THIS DRAWING IS A CONTROLLED DOCUMENT FROM TFCO ELECTRONICS CORPORATION IT IS BORROWED FROM THE PROPERTY OF TFCO ELECTRONICS CORPORATION IT SHOULD BE RETURNED TO THE LATEST REVISION		DWN 28JUN2011 CHR 28JUN2011 APVD 28JUN2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS 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 - -		WEIGHT -		CAGE CODE 00779	
				DRAWING NO C-2151136	
				RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 of 4 REV F	

8	7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION
20		20
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PART NUMBER	REVISION	DESCRIPTION
2-2151136-1	F	FINE CRIMP HEIGHT ADJUST
2-2151136-2	F	FINE CRIMP HEIGHT ADJUST
7-2151136-7	A	CRIMP TOOLING KIT
		FEED TYPE
		MECHANICAL
		PNEUMATIC
		-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.0mm DIA SOCKET CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.00-3.50 mm [.118-.138 IN]			Ø1.10-1.70 mm [.043-.067 IN]
TERMINAL APPLICATION 		114-5315	
SPECIFICATION		-	
		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1612124-3	1612124-8		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.5mm2(AVSS/CAVS)	1.06+/-0.05 [.042+/- .002]	7.2
0.5mm2(CHFUS)	1.02+/-0.05 [.040+/- .002]	7.7
0.3mm2(AVSS/CAVS)	0.96+/-0.05 [.038+/- .002]	8.3
0.35mm2(CHFUS)	0.93+/-0.05 [.037+/- .002]	8.5



- 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 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 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)

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

	-	1	1	2-1803945-1	TONKER	300
	-	1	1	22278-9	SPRING, COMPRESSION	299
	-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
	-	1	1	1803944-1	SPACER, TONKER	297
	-	1	1	2119791-5	DEPRESSOR, WIRE	286
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1	1633782-2	FENCE	267
	-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	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
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	455888-6	SPACER, CRIMPER	82
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	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	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	2-1752356-0	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	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	2119533-5	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	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	1	3-1633917-4	ANVIL, COMBINATION	8
	-	1	1	4-240641-1	SPACER	7
	-	-	-	-	-	6
	-	1	1	2119757-1	DEPRESSOR, SHEAR	5
	-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1	5-2119784-1	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	2-456402-3	CRIMPER, WIRE PREMIUM	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			DWN	TE Connectivity Harrisburg, PA 17105-3608	
			CHK		
			S.XI		
			APVD		
			PRODUCT SPEC		
			APPLICATION SPEC		
			SIZE	CAGE CODE	DRAWING NO
			00779	2151136	
			Customer Accessible Production Drawing	SCALE	1:2
			SHEET	3	OF 4
			REV	F	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

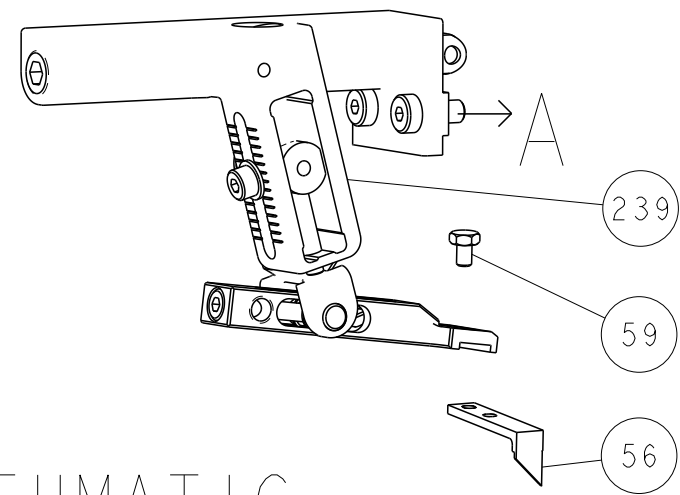
D

C

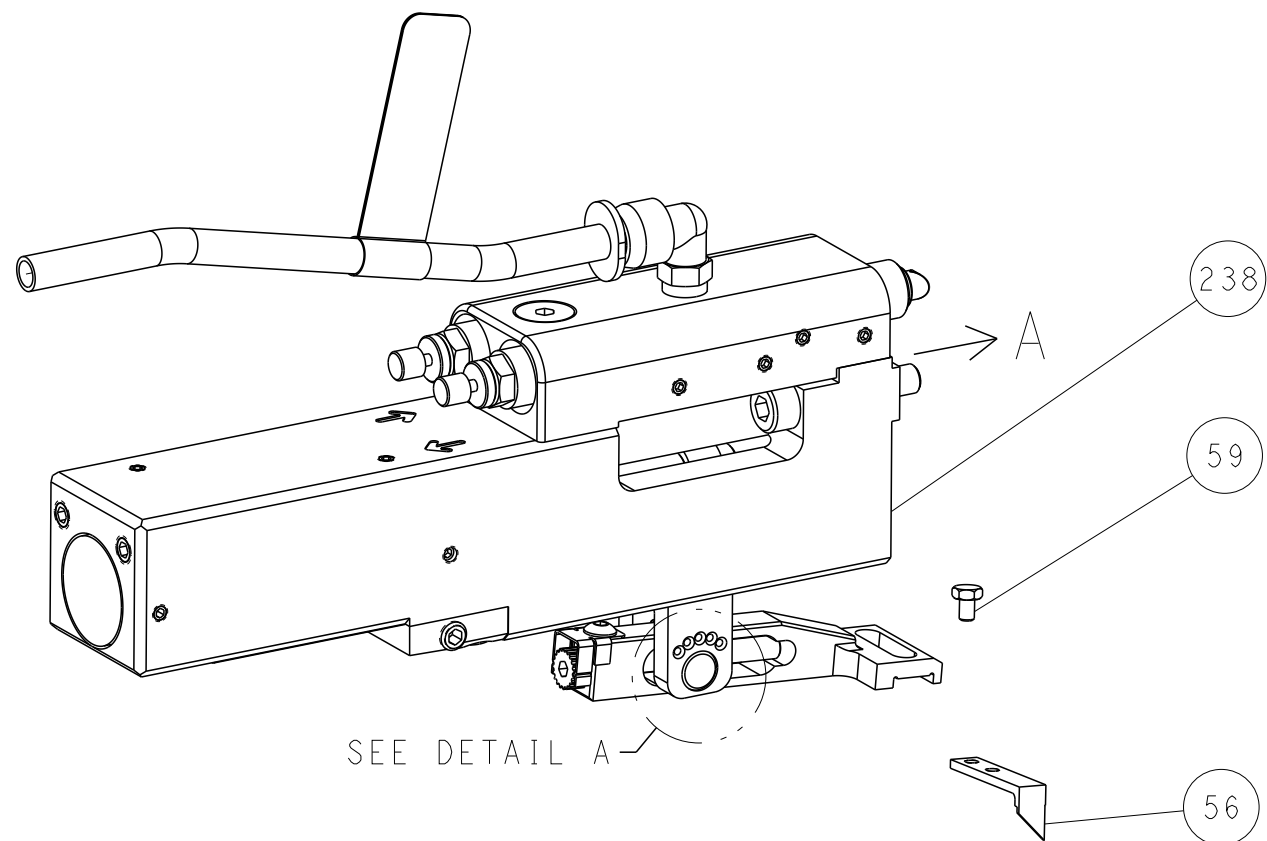
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A

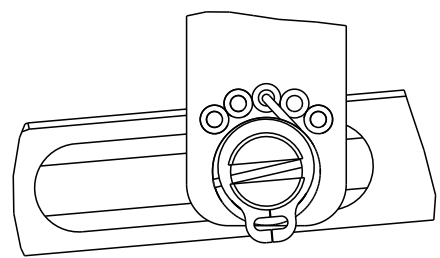
FEED TYPE MECHANICAL



PNEUMATIC

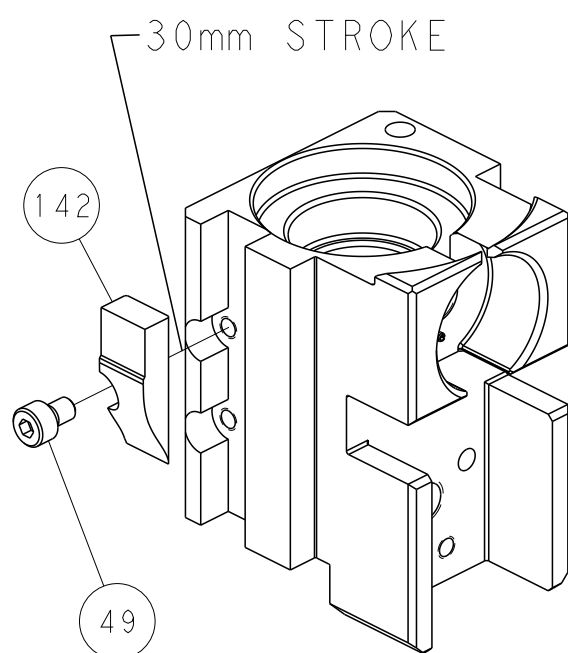


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

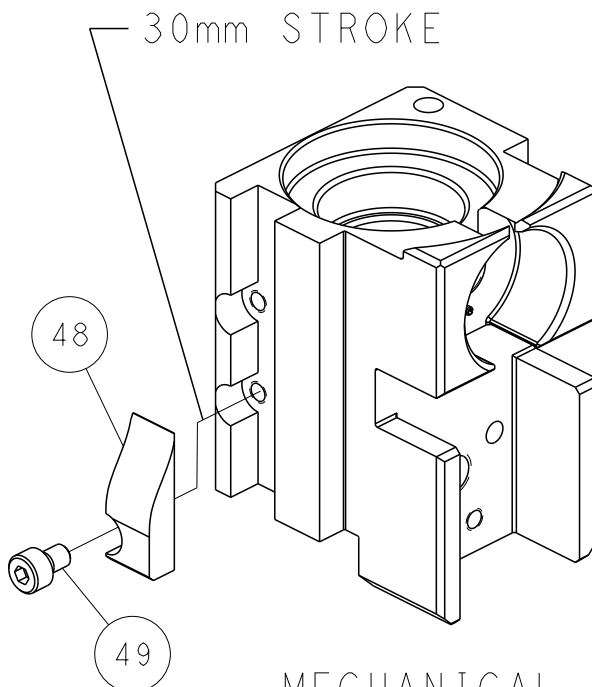


DETAIL A

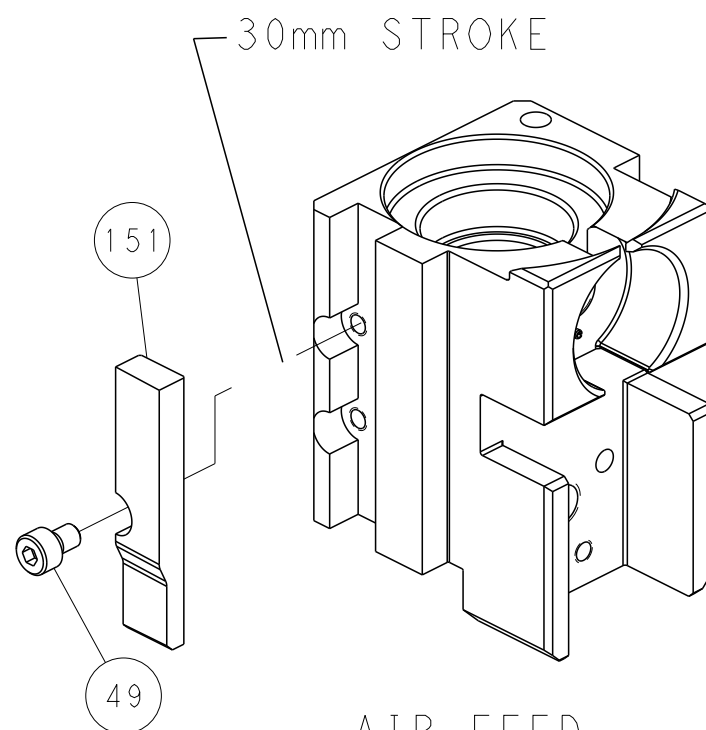
CAM POSITIONS



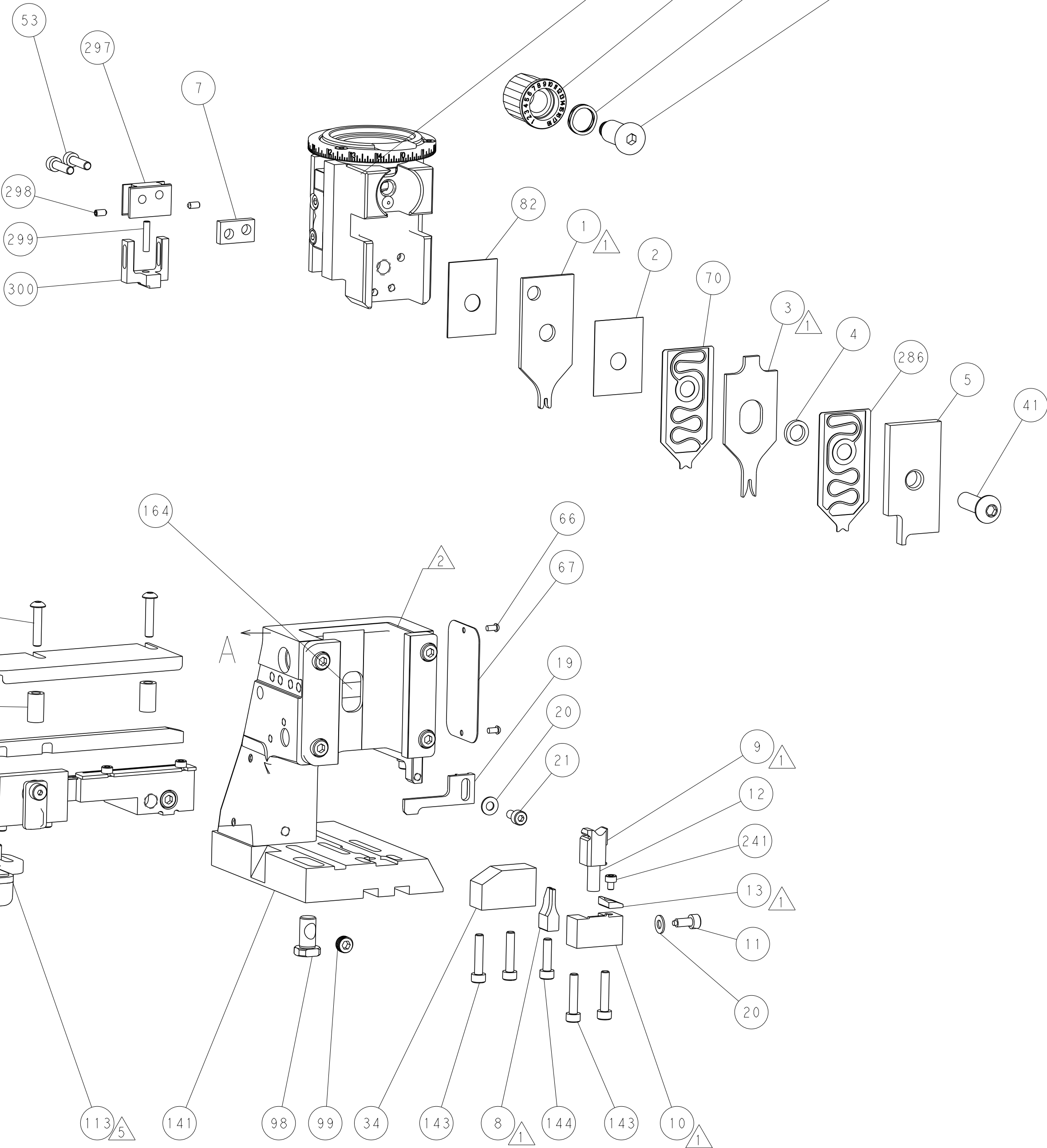
MECHANICAL
POST FEED



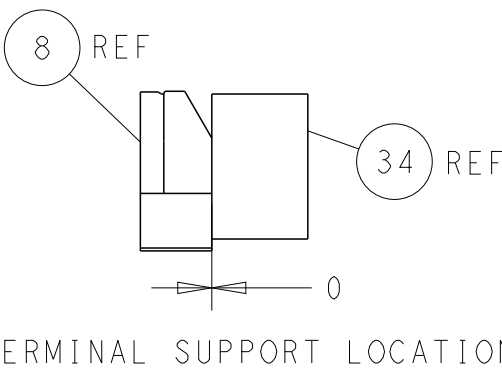
MECHANICAL
PRE FEED



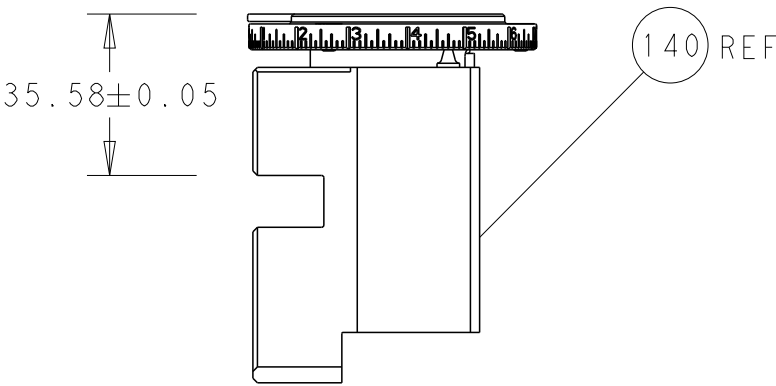
AIR FEED



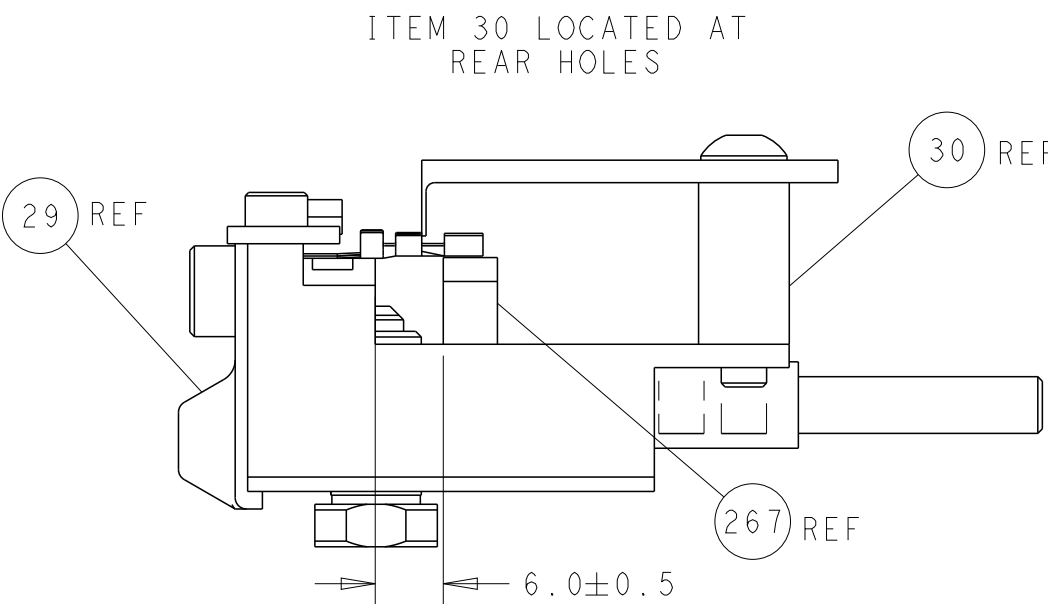
PACIFIC VERSION
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(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME			
mm		0 PLC ±		SIZE			
		1 PLC ±		CAGE CODE			
		2 PLC ±		DRAWING NO			
		3 PLC ±		RESTRICTED TO			
		4 PLC ±					
		ANGLES ±					
		FINISH ±					
MATERIAL							