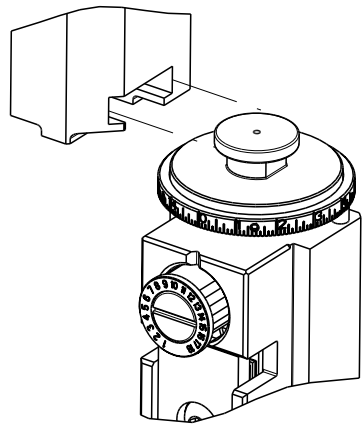


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151954-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151954-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151954-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151954-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.25 mm [.128]	F
INSUL	4.45 mm [.175]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL		DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: MALE METRI-PACK 280			
WIRE STRIP LENGTH 4.90-5.28 mm [.193-.208 IN]		INSULATION DIAMETER RANGE Ø2.45-3.25 mm [.096-.128 IN]	
TERMINAL APPLICATION SPECIFICATION		DELPHI Rev -	
		CODE LEGEND 1005	

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	
286945-1	12129497	1572716-3	15324980	
		1949807-1	15324982	
		1949896-1	15324981	
		286953-3	12015284	Ø2.81-3.49mm Ø2.03-2.85mm Ø3.45-4.30mm Ø2.85-2.03mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	1.90+/-0.05 [0.075+/-0.002]	6.2
2.00mm2	1.65+/-0.05 [0.065+/-0.002]	8.8



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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE 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.

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
		B		ECR-14-004385	24MAR2014	RK	GB
		C		ECR-17-005721	20APR2017	BW	CT
		D		ECR-18-011359	18JUL2018	VLA	CT

3	-	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	1	2119082-9	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	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	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	455888-4	SPACER, CRIMPER	82	
-	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79	
-	1	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	1	1	2119943-1	WASHER, SPACER	69	
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
6	-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1	1338683-8	FEED PAWL	56
	-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33	
-	2	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1320928-4	STRIP GUIDE	24	
-	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	
A	-	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
A	-	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
A	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
	1	2	2	1	2-1633928-5	ANVIL, COMBINATION	8
A	-	-	-	-	-	-	7
	-	-	-	-	-	-	6
A	-	1	1	1	1-2119781-0	DEPRESSOR, SHEAR	5
	-	1	1	1	5-238011-5	BLOCK, CRIMPER SPACER	4
A	1	2	2	1	5-1633965-9	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1-455888-0	SPACER, CRIMPER	2
A	1	2	2	1	3-1673600-2	CRIMPER, WIRE	1
	-77	-72	-71	-2	PART NO	DESCRIPTION	ITEM NO

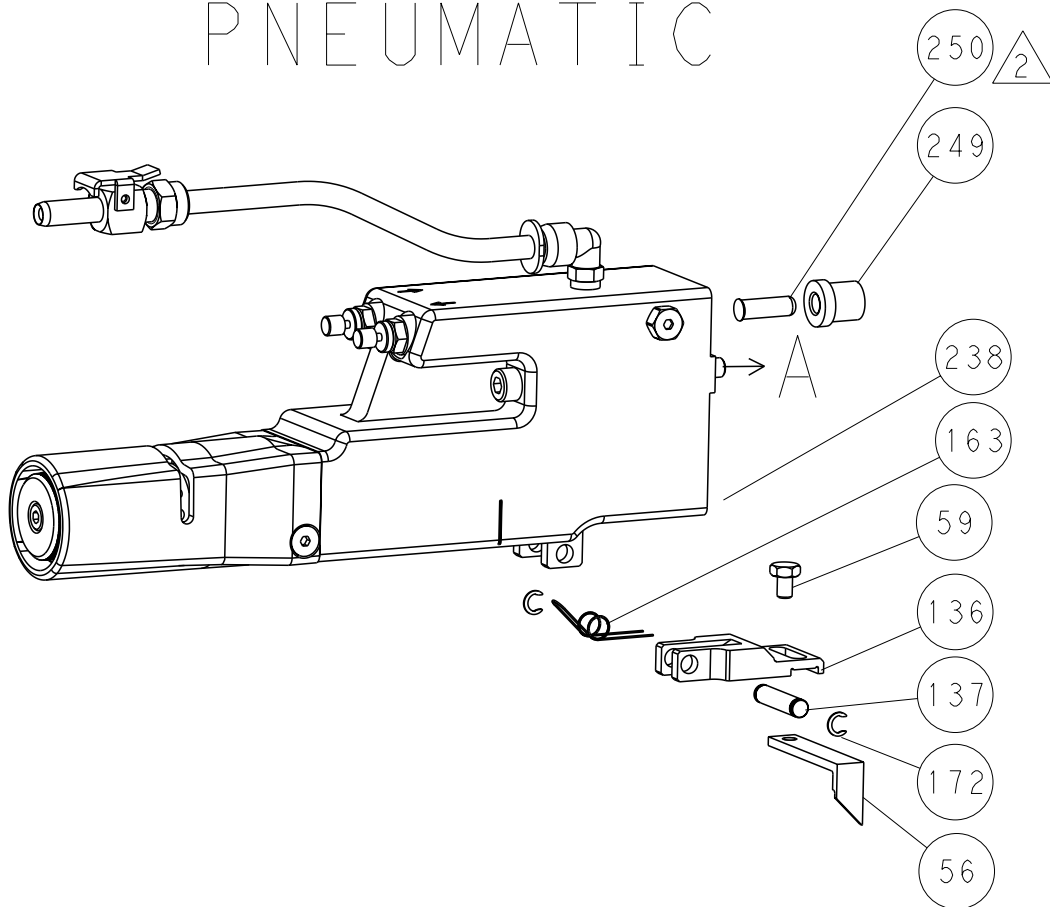
THIS DRAWING IS CONTROLLED AND THE USER SHALL BE RESPONSIBLE FOR CONTROLLING THE DRAWING. THE USER SHALL BE CONTACTED FOR THE LATEST REVISION.		DWN HOFFNER 30MAY2013	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T.ELBIN 31MAY2013		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD T.ELBIN 31MAY2013	NAME Ocean Side Feed Applicator	
MATERIAL -		FINISH -	SIZE A1	CAGE CODE 00779
		WEIGHT -	DRAWING NO C=2151954	RESTRICTED TO -
		Customer Accessible Production Drawing		SCALE 1:2
		SHEET 1		REV D

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

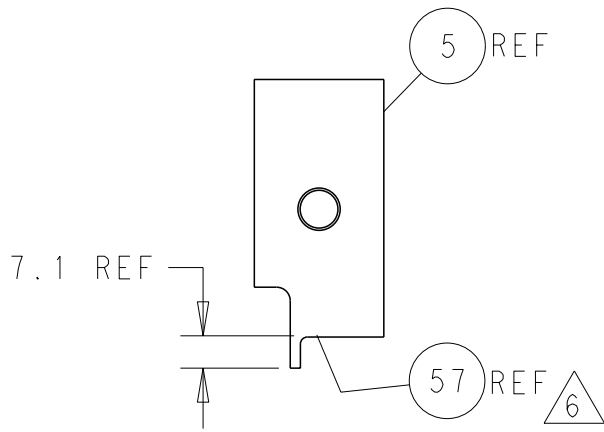
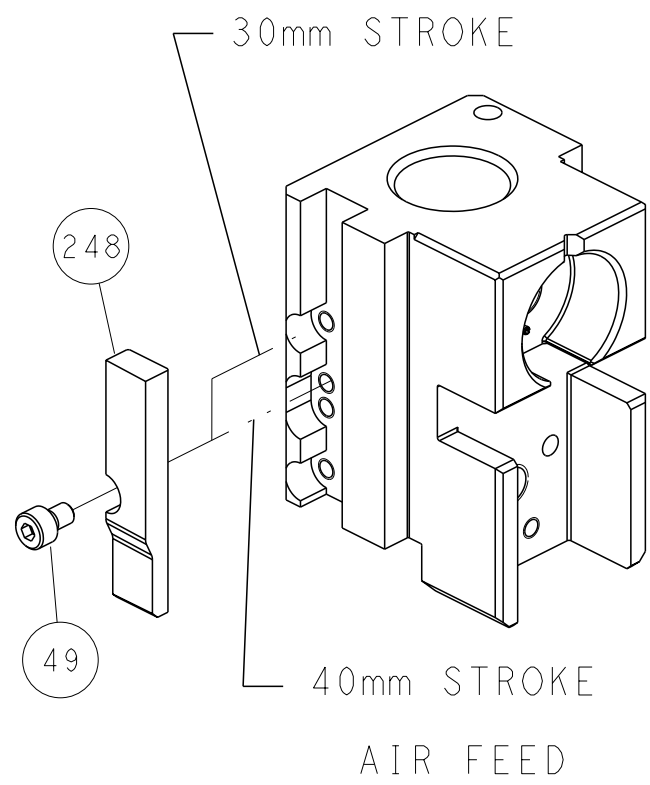
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

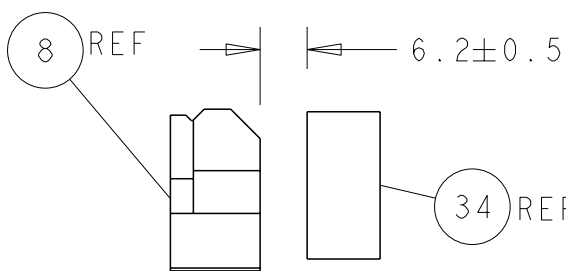
PNEUMATIC



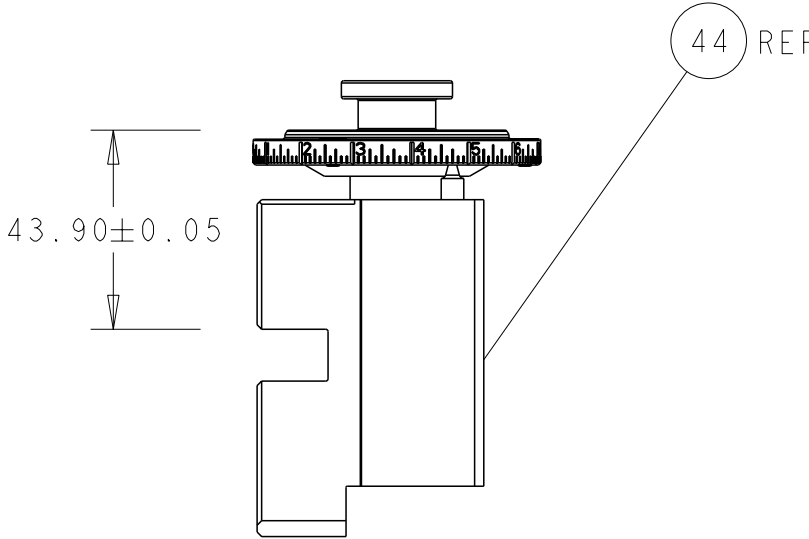
CAM POSITION



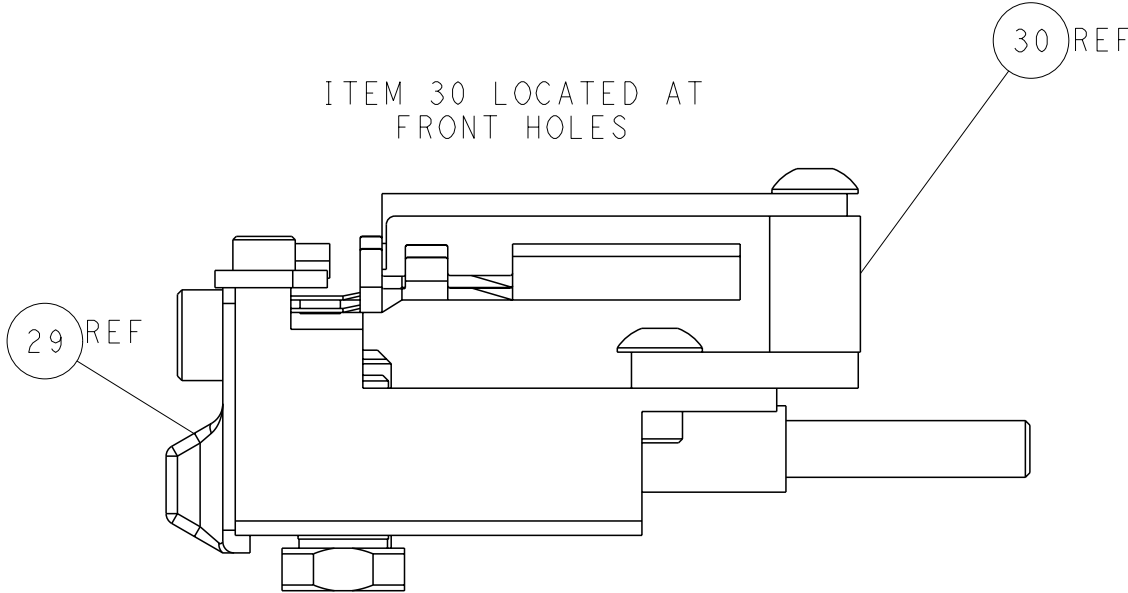
SHEAR DEPRESSOR DETAIL



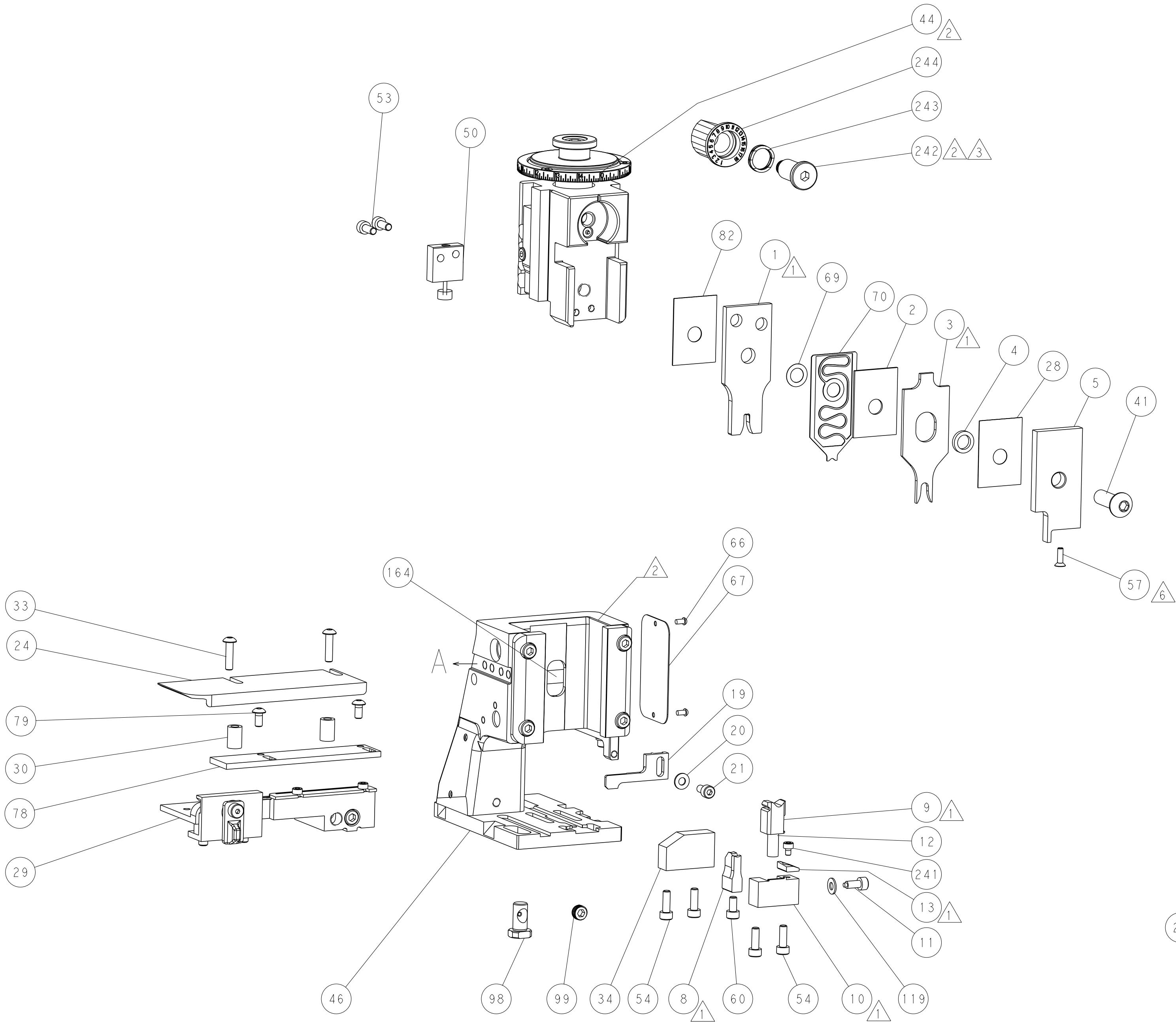
TERMINAL SUPPORT LOCATION



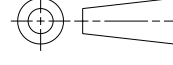
RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

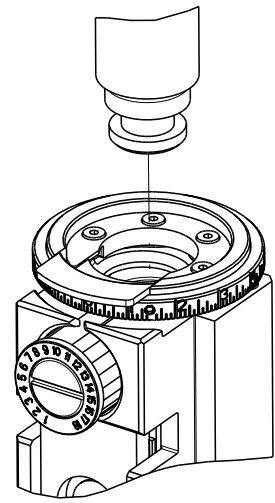


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

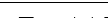
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	30MAY2013	 TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		CMY	31MAY2013		
		FINISH		APVD	31MAY2013	NAME	
MATERIAL		-		PRODUCT SPEC		Ocean Side Feed Applicator	
-		-		APPLICATION SPEC		-	
-		-		WEIGHT		SIZE	
-		-		Customer Accessible Production Drawing		CAGE CODE	
-		-		SCALE		DRAWING NO	
-		-		1:2		00779	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151954-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151954-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.25 mm [.128]	F
INSUL	4.45 mm [.175]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL		DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: MALE METRI-PACK 280			
WIRE STRIP LENGTH 4.90-5.28 mm [.193-.208 IN]			INSULATION DIAMETER RANGE Ø 2.45-3.25 mm [.096-.128 IN]
TERMINAL APPLICATION SPECIFICATION		DELPHI Rev - CODE LEGEND 1005	- -

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	
286945-1	12129497	1572716-3	15324980	
		1949807-1	15324982	
		1949896-1	15324981	
		286953-3	12015284	Ø 2.85-2.03mm

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
3.00mm2		1.90+/-0.05 [.075+/- .002]		6.2
2.00mm2		1.65+/-0.05 [.065+/- .002]		8.8



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE 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.

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

2		1	
LOC	DIST	REVISIONS	
A	66	P	LYR
		DESCRIPTION	
		DATE	DWN
		APVD	
		-	SEE SHEET 1
		-	-
		-	-
		-	-

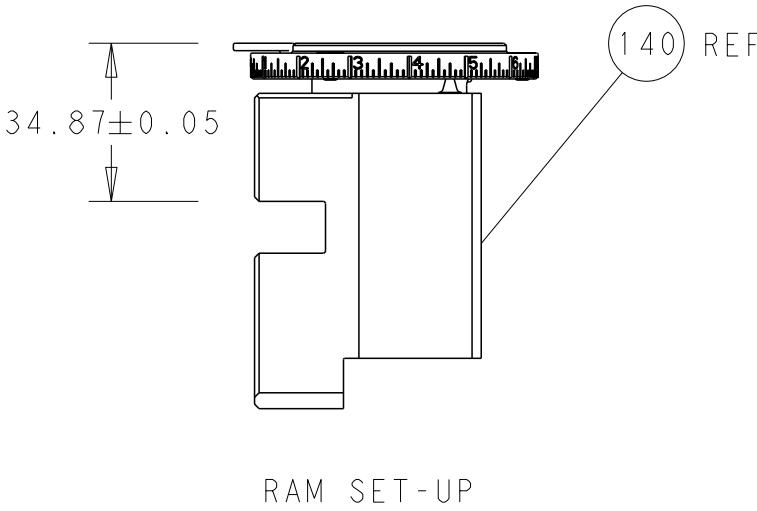
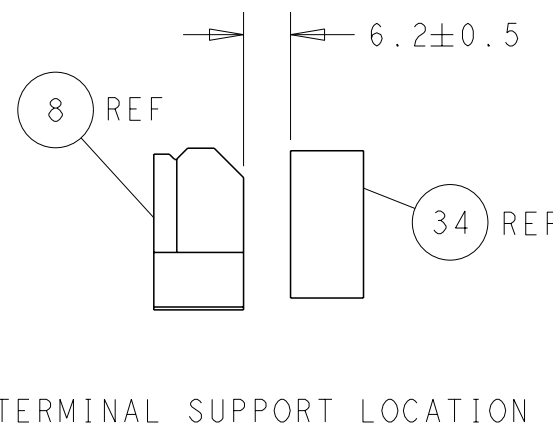
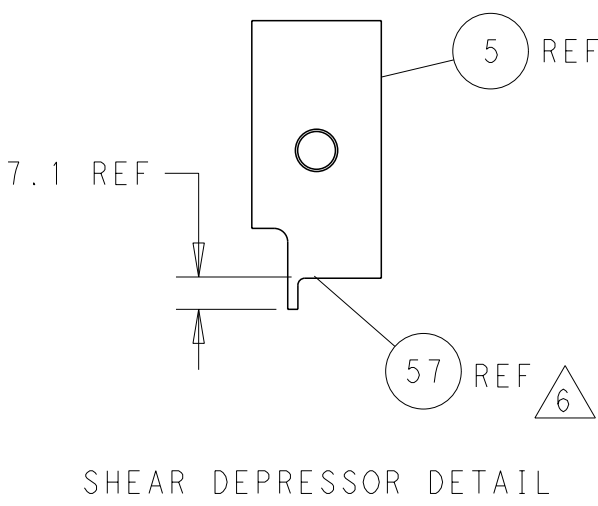
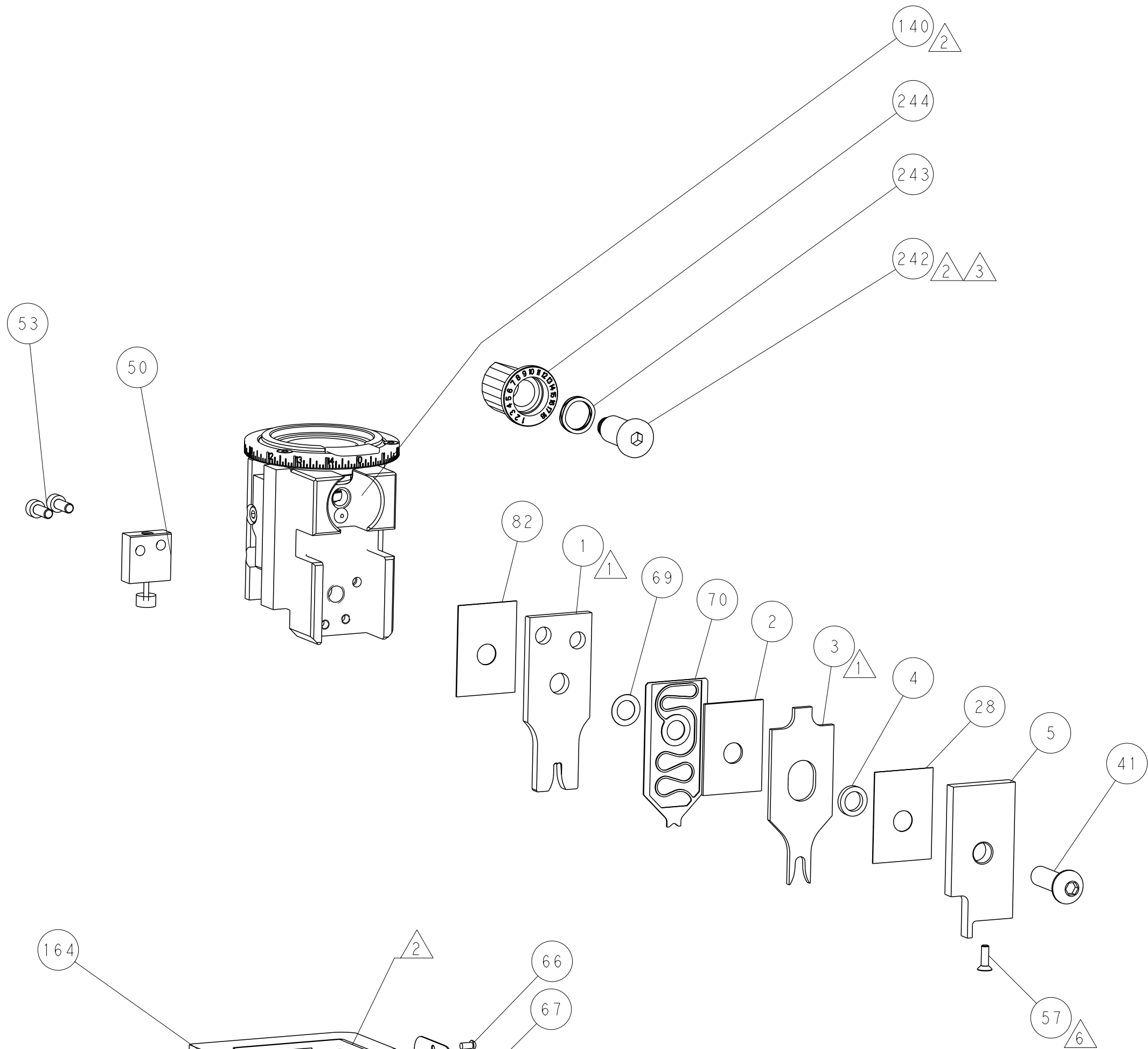
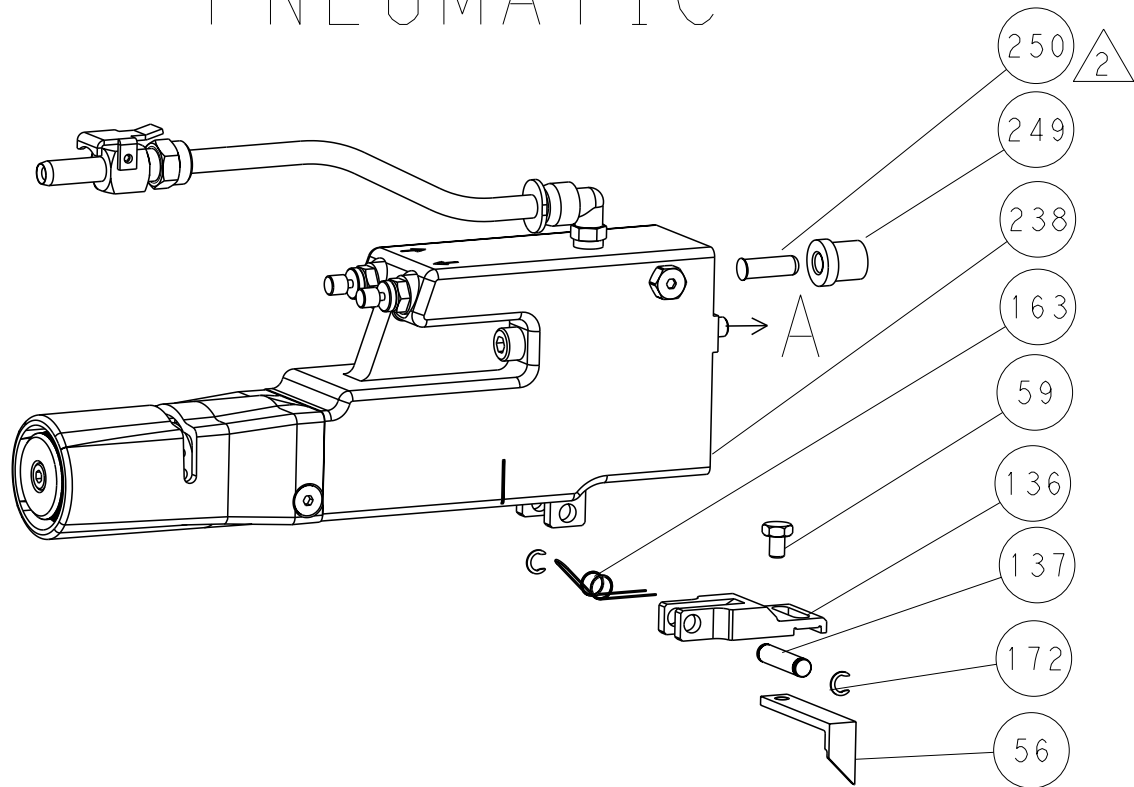
	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1803259-1	BUSHING, FLANGED	249
	-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2063440-1	AIR FEED MODULE	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	1-1803583-0	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	455888-4	SPACER, CRIMPER	82
	-	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
	-	1	1803096-1	EXTENSION PLATE	78
	-	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	2119943-1	WASHER, SPACER	69
	-	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
6	-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1338683-8	FEED PAWL	56
	-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1803382-6	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	1752356-1	SUPPORT, TERMINAL	34
	-	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
	-	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	455888-3	SPACER, CRIMPER	28
	-	1	1320928-4	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	-	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	2119806-1	INSERT, SHEAR	13
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-4	STOP, SHEAR	11
1	-	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1	2-1633928-5	ANVIL, COMBINATION	8
	-	-	-	-	7
	-	-	-	-	6
	-	1	1-2119781-0	DEPRESSOR, SHEAR	5
	-	1	5-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	5-1633965-9	CRIMPER, INSULATION O PREMIUM	3
	-	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	3-1673600-2	CRIMPER, WIRE	1

-77-22		PART NO	DESCRIPTION		ITEM NO
NO. ELECTRONIC COMPONENTS OR ELECTRICAL DEVIATION FROM REVISION		OWN H OFFNER	 TE Connectivity Harrisburg, PA 17105-3608		
		CHK T ELBIN			
		APVD T ELBIN			
		PRODUCT SPEC			
		APPLICATION SPEC			
		SIZE			
		CAGE CODE			
PERANCES UNLESS OTHERWISE SPECIFIED:			Ocean Side Feed Applicator		
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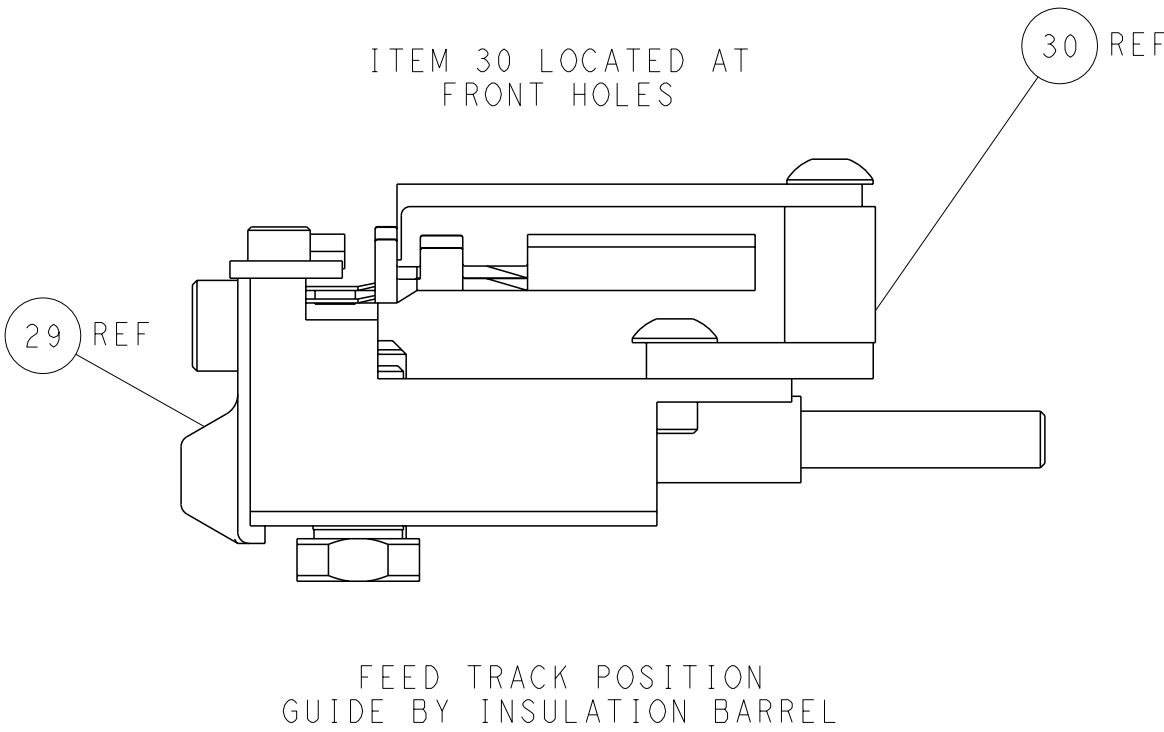
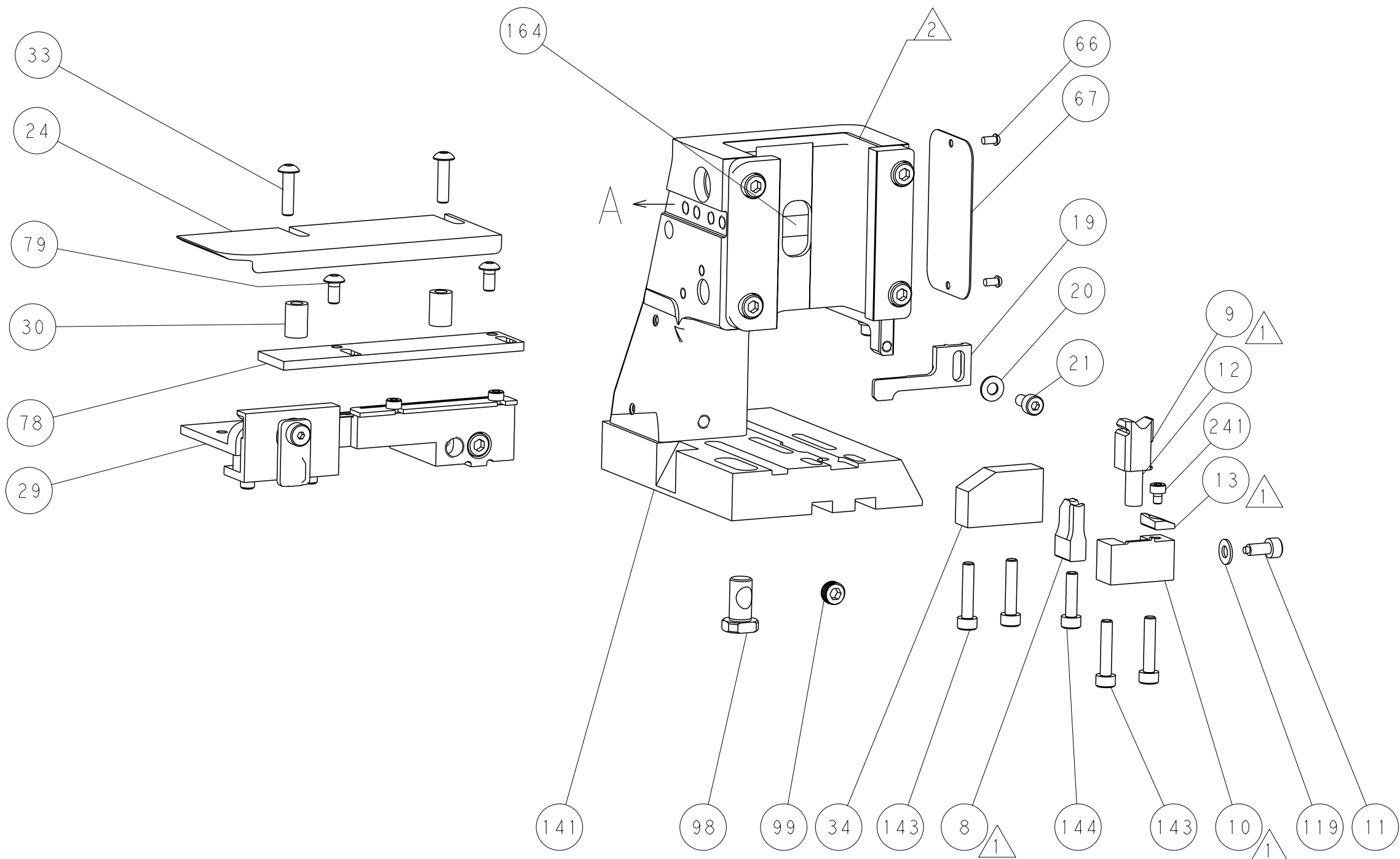
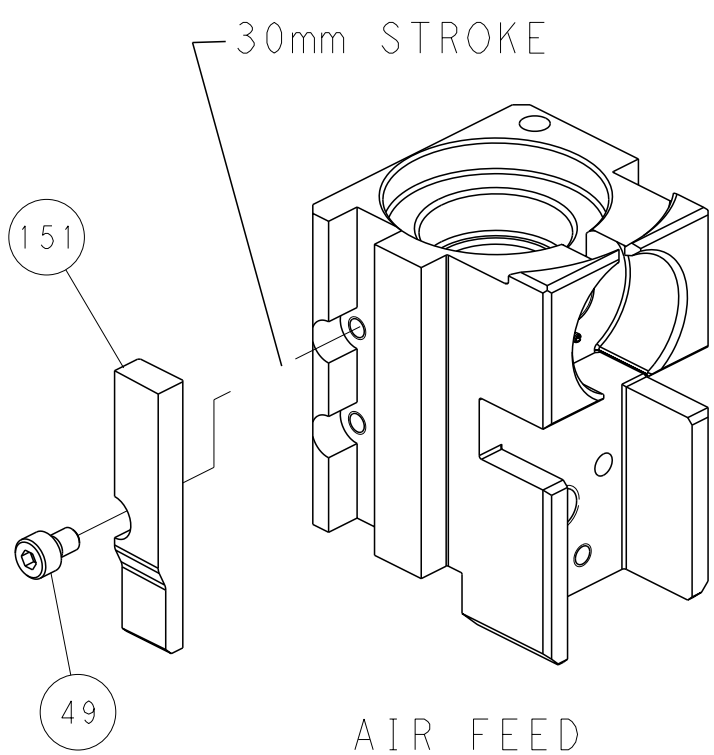
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE
PNEUMATIC



CAM POSITION



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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN HOFFNER 30MAY2013		CNY T.ELBIN 31MAY2013		APVD T.ELBIN 31MAY2013		NAME Ocean Side Feed Applicator	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE	
mm		0 PLC ±						A1		00779	
		1 PLC ±								©=2151954	
		2 PLC ±									
		3 PLC ±									
		4 PLC ±									
		ANGLES									
		FINISH									
MATERIAL				WEIGHT				SCALE		SHEET 4 OF 4	
								Customer Accessible Production Drawing		REV D	