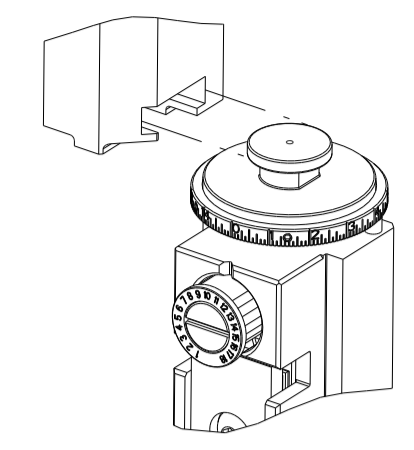


| PART NUMBER | REVISION | DESCRIPTION                            | FEED TYPE  |
|-------------|----------|--|------------|
| 2151786-1   | D        | FINE CRIMP HEIGHT ADJUST               | MECHANICAL |
| 2151786-2   | D        | FINE CRIMP HEIGHT ADJUST               | PNEUMATIC  |
| 5-2151786-1 | D        | SEAL STRIPPER CRIMPER TERMINATING UNIT | MECHANICAL |
| 5-2151786-2 | D        | SEAL STRIPPER CRIMPER TERMINATING UNIT | PNEUMATIC  |
| 7-2151786-1 | D        | MECHANICAL AND CRIMP TOOLING KIT       | MECHANICAL |
| 7-2151786-2 | D        | PNEUMATIC AND CRIMP TOOLING KIT        | PNEUMATIC  |
| 7-2151786-7 | A        | CRIMP TOOLING KIT                      | -          |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 3.25 mm [.128] | F    |
| INSUL           | 4.88 mm [.192] | O    |

APPLICATOR INSTRUCTIONS  
408-35042

| TERMINAL DATA: DELPHI TERMINAL TE CRIMP SPECIFICATION |  |
|---|--|
| TERMINAL NAME: FEMALE METRI-PACK 280                  |  |
| WIRE STRIP LENGTH<br>1.89-.220 IN [4.80-5.59 mm]      | TERMINAL INSULATION DIAMETER RANGE<br>Ø 2.45-3.8mm [1.096-.150 IN] |
| TERMINAL APPLICATION SPECIFICATION<br>NONE            |  |

| TERMINALS APPLIED |                 |           |             |                |
|-------------------|-----------------|-----------|-------------|----------------|
| TE TERMINAL       | DELPHI TERMINAL | TE SEAL   | DELPHI SEAL | CABLE DIAMETER |
| 286919-1          | 12129493        | 1572716-3 | 15324980    | Ø 2.81-3.49mm  |
| 286919-2          | 12176388        | 1949896-1 | 15324981    | Ø 3.45-4.30mm  |
|                   |                 | 1949807-1 | 15324982    | Ø 2.03-2.85mm  |
|                   |                 | 1572716-1 | 12010293    | Ø 2.81-3.49mm  |
|                   |                 | 286553-1  | 12015323    | Ø 2.03-2.85mm  |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 3.00mm2   | 1.95 +/- 0.05 [.077 +/- .002] | 6.1                            |
| 2.00mm2   | 1.70 +/- 0.05 [.067 +/- .002] | 8.6                            |

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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.
- 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.
- 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)

| LOC | DIST | REVISIONS |     |               |           |     |      |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A   | 66   | P         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|     |      | A1        |     | ECR-13-015665 | 09OCT2013 | XZ  | TE   |
|     |      | B         |     | ECR-18-011001 | 12JUL2018 | JAH | CT   |
|     |      | C         |     | ECR-19-010758 | 10JUL2019 | TB  | TE   |
|     |      | D         |     | ECR-21-006351 | 18JUN2021 | FZ  | RK   |

|   |     |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | -   | 1   | 1   | -   | -   | 1803515-3   | RAM ASSEMBLY, SF ATLANTIC           | 293 |
| - | -   | -   | 1   | 1   | -   | -   | 2-1803583-1 | APPLICATOR BASIC ASSEMBLY, SF       | 292 |
| - | 1   | -   | 1   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119082-7   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241 |
| - | -   | 1   | -   | 1   | -   | 1   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239 |
| - | 1   | -   | 1   | -   | 1   | -   | 2844940-1   | AIR FEED MODULE                     | 238 |
| - | -   | -   | 1   | 1   | -   | -   | 4-1722335-3 | STRIPPER, SIDE FEED                 | 182 |
| - | -   | -   | 1   | 1   | -   | -   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 181 |
| - | -   | -   | 1   | 1   | -   | -   | 2-1752354-5 | STANDOFF,HOLD-DOWN                  | 180 |
| - | -   | -   | 1   | 1   | -   | -   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177 |
| - | -   | -   | 1   | 1   | -   | -   | 5-22280-0   | SPRING, COMPRESSION                 | 176 |
| - | -   | -   | 1   | 1   | -   | -   | 1752353-3   | GUIDE PIN,HOLDDOWN                  | 175 |
| - | -   | -   | 1   | 1   | -   | -   | 1901680-2   | GUIDE PIN,HOLDDOWN                  | 174 |
| - | REF | REF | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| - | 2   | 2   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 60  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 985575-3    | SCR, FLT SKT HD CAP M3 X 10.0       | 57  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1338683-8   | FEED PAWL                           | 56  |
| - | 4   | 4   | 4   | 4   | 4   | 4   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 54  |
| - | 2   | 2   | 2   | 2   | 2   | 2   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 53  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1803382-6   | HOLD DOWN, SPRING LOADED            | 50  |
| - | 1   | 2   | 1   | 2   | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | -   | 1   | -   | 1   | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48  |
| - | -   | 1   | -   | 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   | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1752356-1   | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 2   | 2   | 2   | 2   | 2   | 2   | 3-2844962-0 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2844992-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | -   | -   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 2   | 2   | 1   | 1   | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | -   | -   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 318707-1    | FLOATING SHEAR, FRONT               | 9   |
| 1 | 2   | 2   | 1   | 1   | 1   | 1   | 1-1633703-0 | ANVIL, COMBINATION                  | 8   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1-240641-4  | SPACER                              | 7   |
| - | -   | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119781-5   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 3-238011-8  | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 2   | 2   | 1   | 1   | 1   | 1   | 2-1803018-3 | CRIMPER, INSULATION O               | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2   |
| 1 | 2   | 2   | 1   | 1   | 1   | 1   | 3-1673600-2 | CRIMPER, WIRE                       | 1   |

| ITEM NO | PART NO | DESCRIPTION |
|---------|---------|-------------|
| -77     | -72     | -71         |
| -52     | -51     | -2          |
| -1      |         |             |

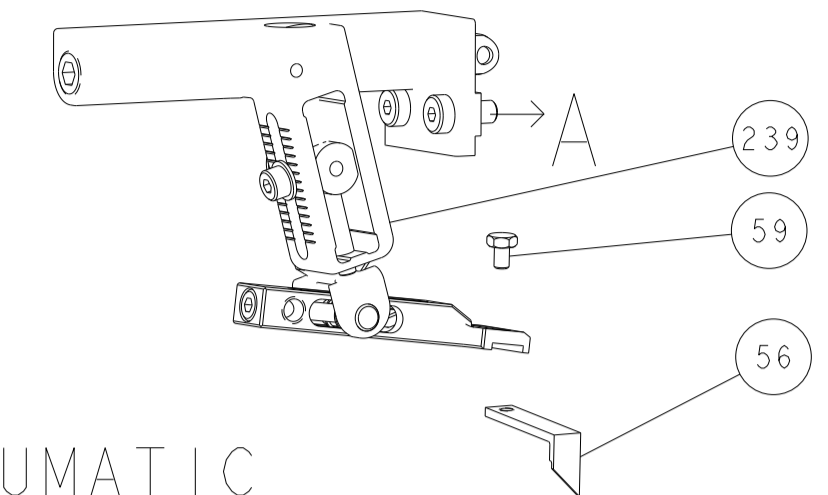
|      |         |           |
|------|---------|-----------|
| OWN  | C. CHEN | 16OCT2012 |
| CHK  | S. XI   | 16OCT2012 |
| APVD | J. CRUZ | 16OCT2012 |

|      |                            |            |               |
|------|----------------------------|------------|---------------|
| NAME | Ocean Side Feed Applicator |            |               |
| SIZE | CAGE CODE                  | DRAWING NO | RESTRICTED TO |
| A1   | 00779                      | 2151786    | -             |

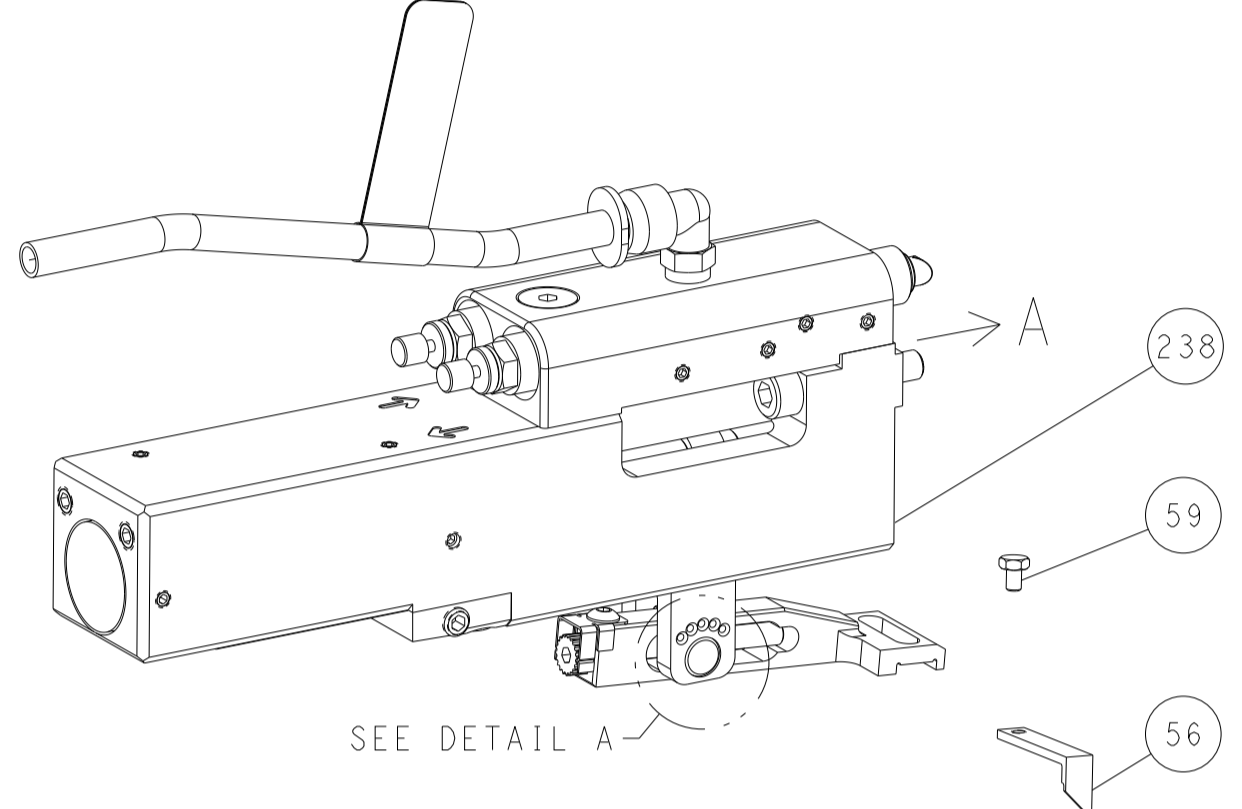
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV D

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

# FEED TYPE MECHANICAL



## PNEUMATIC

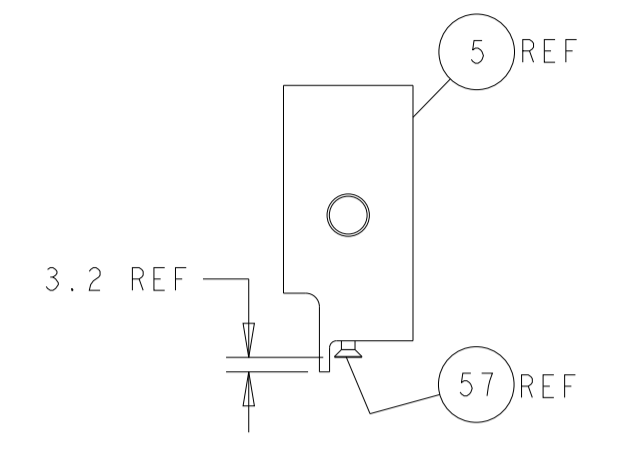
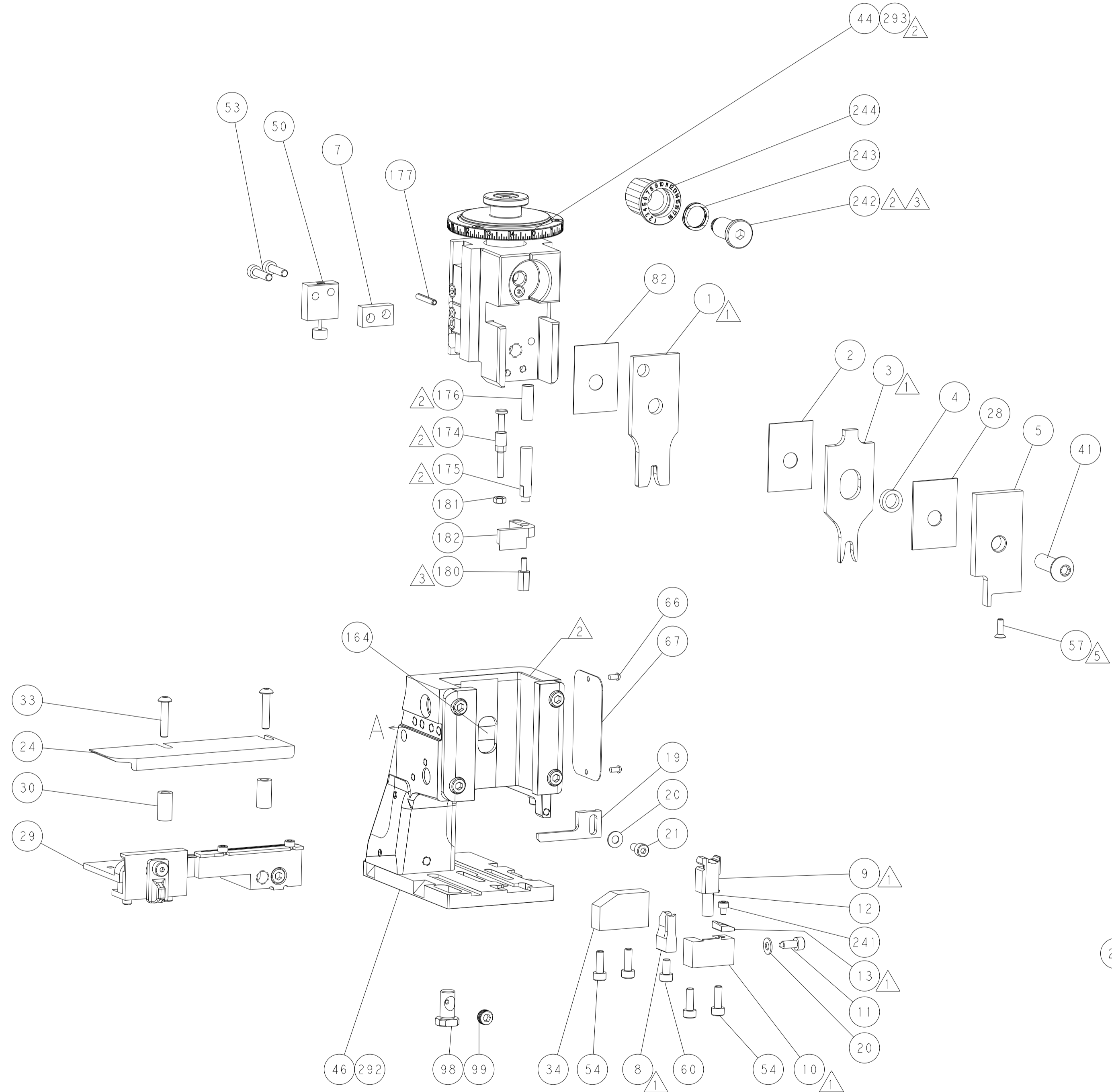
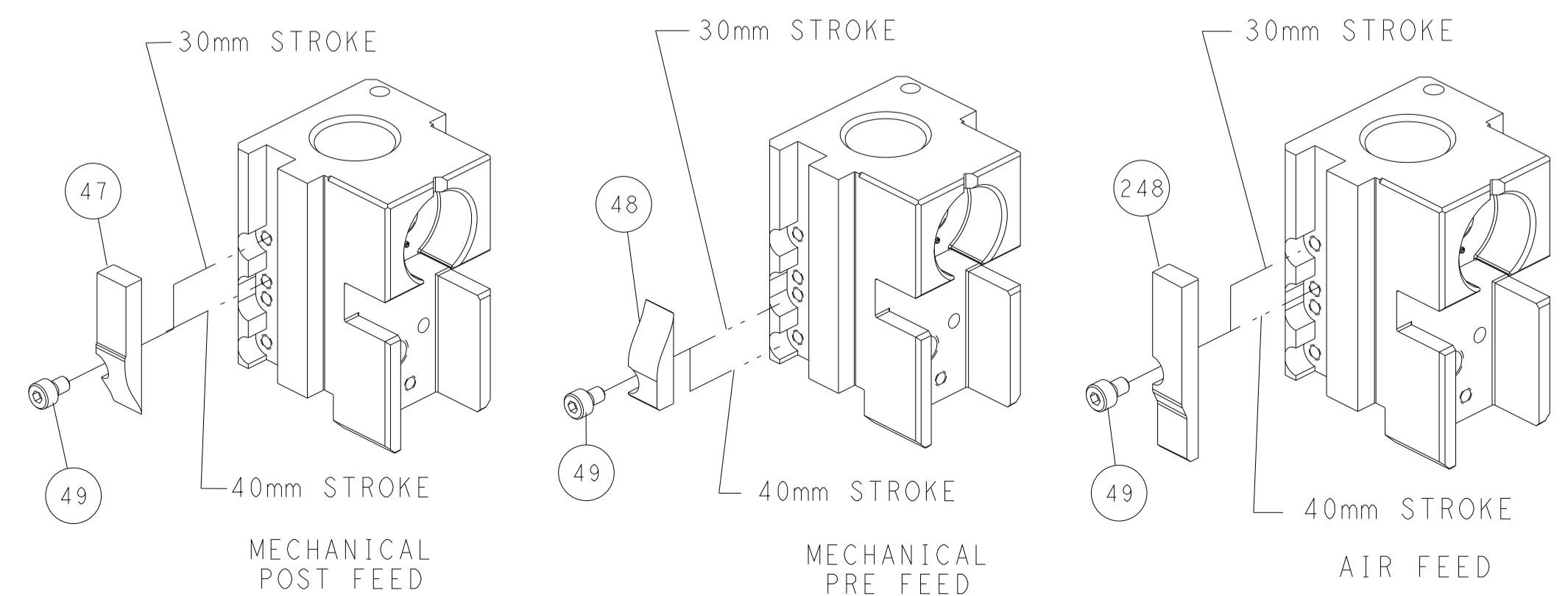


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

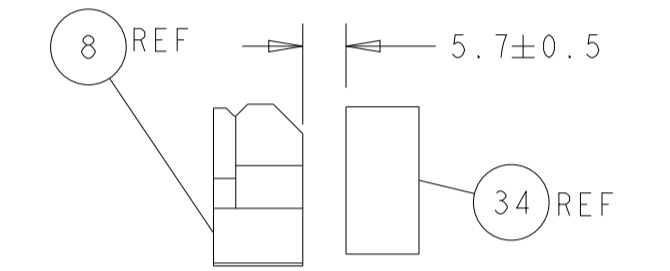


DETAIL A

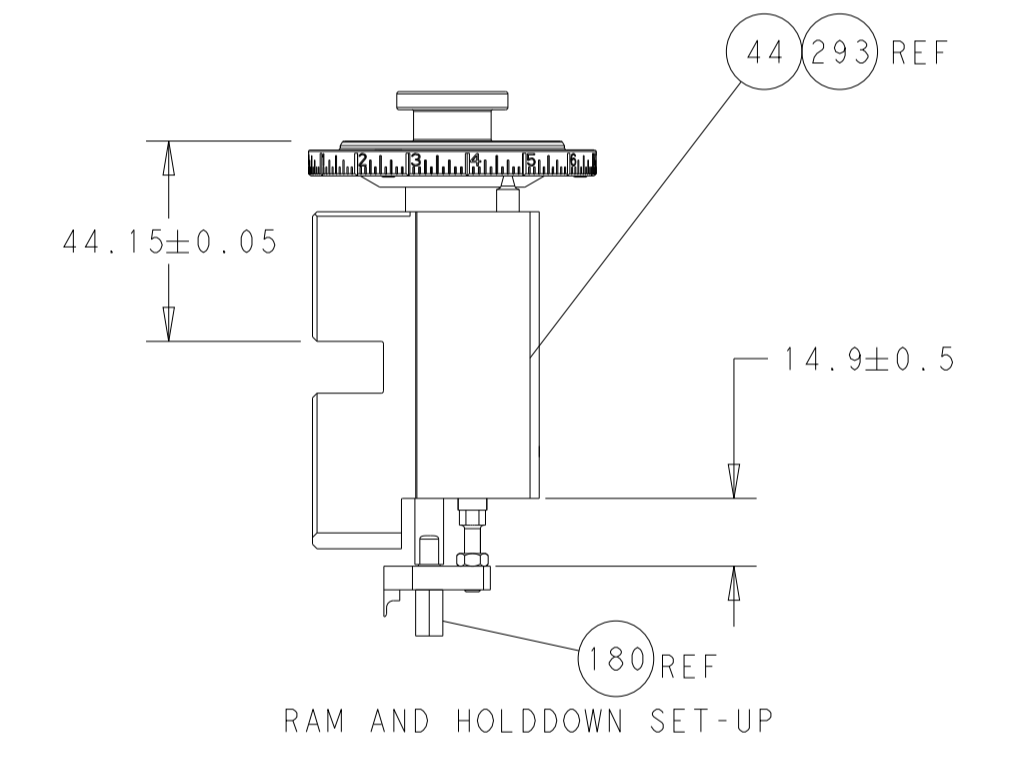
# CAM POSITIONS



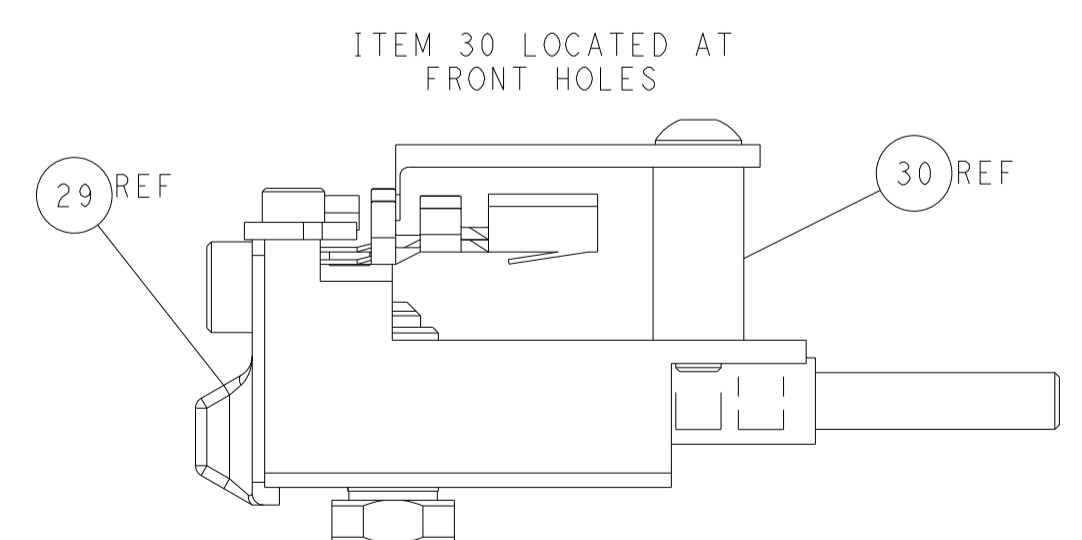
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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)

|  |  |   |  |
|--|--|---|--|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. THIS DRAWING IS CONTROLLED DOCUMENT. FOR THE ELECTRONICS CORPORATION. IT IS THE POLICY OF THE CORPORATION TO CONTROL THE DISTRIBUTION OF THIS DRAWING TO THE EXTENT NECESSARY TO PROTECT THE INTERESTS OF THE CORPORATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> |  | DWN: C. CHEN 16OCT2012<br>CHK: S. XI 16OCT2012<br>APVD: J. CRUZ 16OCT2012                                 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ±   |  | NAME: Ocean Side Feed Applicator<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151786<br>RESTRICTED TO: | SCALE: 1:2<br>SHEET: 2 of 4<br>REV: D        |
| MATERIAL:  |  | WEIGHT: Customer Accessible Production Drawing  |  |

| PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE  |
|-------------|----------|--------------------------|------------|
| 2-2151786-1 | D        | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151786-2 | D        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC  |
| 7-2151786-7 | A        | CRIMP TOOLING KIT        | -          |

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 3.25 mm [.128] | F    |
| INSUL           | 4.88 mm [.192] | O    |

APPLICATOR INSTRUCTIONS  
 408-35042

| TERMINAL DATA: DELPHI TERMINAL TE CRIMP SPECIFICATION |   |
|---|---|
| TERMINAL NAME: FEMALE METRI-PACK 280                  |   |
| WIRE STRIP LENGTH<br>.189-.220 IN [4.80-5.59 mm]      | TERMINAL INSULATION DIAMETER RANGE<br>∅ 2.45-3.8mm [.096-.150 IN] |
| TERMINAL APPLICATION SPECIFICATION<br>NONE            |   |

| TERMINALS APPLIED |                 |           |             |                |
|-------------------|-----------------|-----------|-------------|----------------|
| TE TERMINAL       | DELPHI TERMINAL | TE SEAL   | DELPHI SEAL | CABLE DIAMETER |
| 286919-1          | 12129493        | 1572716-3 | 15324980    | ∅ 2.81-3.49mm  |
| 286919-2          | 12176388        | 1949896-1 | 15324981    | ∅ 3.45-4.30mm  |
|                   |                 | 1949807-1 | 15324982    | ∅ 2.03-2.85mm  |
|                   |                 | 1572716-1 | 12010293    | ∅ 2.81-3.49mm  |
|                   |                 | 286553-1  | 12015323    | ∅ 2.03-2.85mm  |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 3.00mm2   | 1.95+/-0.05 [.077+/-0.002] | 6.1                            |
| 2.00mm2   | 1.70+/-0.05 [.067+/-0.002] | 8.6                            |

- 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 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.
- 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.

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

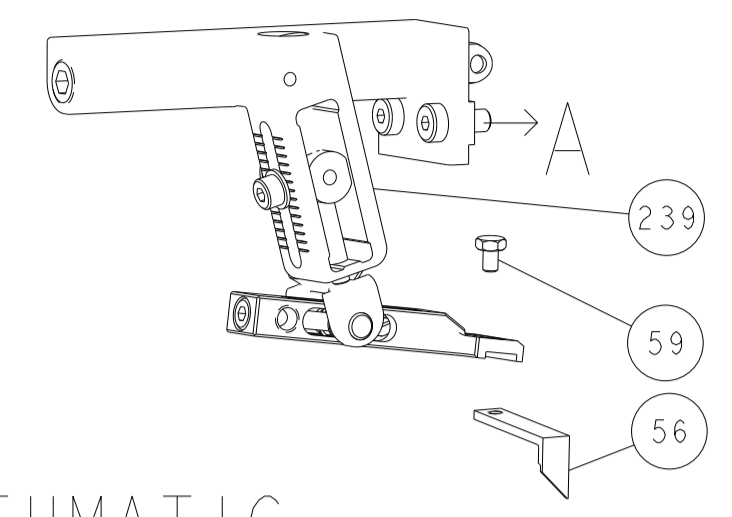
|   |     |     |             |                                     |                               |     |
|---|-----|-----|-------------|-------------------------------------|-------------------------------|-----|
| - | 1   | 1   | 2119082-7   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244                           |     |
| - | 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                           |     |
| - | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99                            |     |
| - | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98                            |     |
| - | 1   | 1   | 455888-4    | 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   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59                            |     |
| 5 | -   | 1   | 1           | 985575-3                            | SCR, FLT SKT HD CAP M3 X 10.0 | 57  |
| - | 1   | 1   | 1338683-8   | FEED PAWL                           | 56                            |     |
| - | 2   | 2   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 53                            |     |
| - | 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   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41                            |     |
| - | 1   | 1   | 1752356-1   | SUPPORT, TERMINAL                   | 34                            |     |
| - | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33                            |     |
| - | 2   | 2   | 3-2844962-0 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30                            |     |
| - | 1   | 1   | 2844992-1   | ASSEMBLY, STRIP GUIDE               | 29                            |     |
| - | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28                            |     |
| - | 1   | 1   | 1320928-2   | 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           | 318707-1                            | FLOATING SHEAR, FRONT         | 9   |
| 1 | 1   | 1   | 1           | 1-1633703-0                         | ANVIL, COMBINATION            | 8   |
| - | 1   | 1   | 1           | 1-240641-4                          | SPACER                        | 7   |
| - | -   | -   | -           | -                                   | 6                             |     |
| - | 1   | 1   | 2119781-5   | DEPRESSOR, SHEAR                    | 5                             |     |
| - | 1   | 1   | 3-238011-8  | BLOCK, CRIMPER SPACER               | 4                             |     |
| 1 | 1   | 1   | 2-1803018-3 | CRIMPER, INSULATION O               | 3                             |     |
| - | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2                             |     |
| 1 | 1   | 1   | 3-1673600-2 | 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)

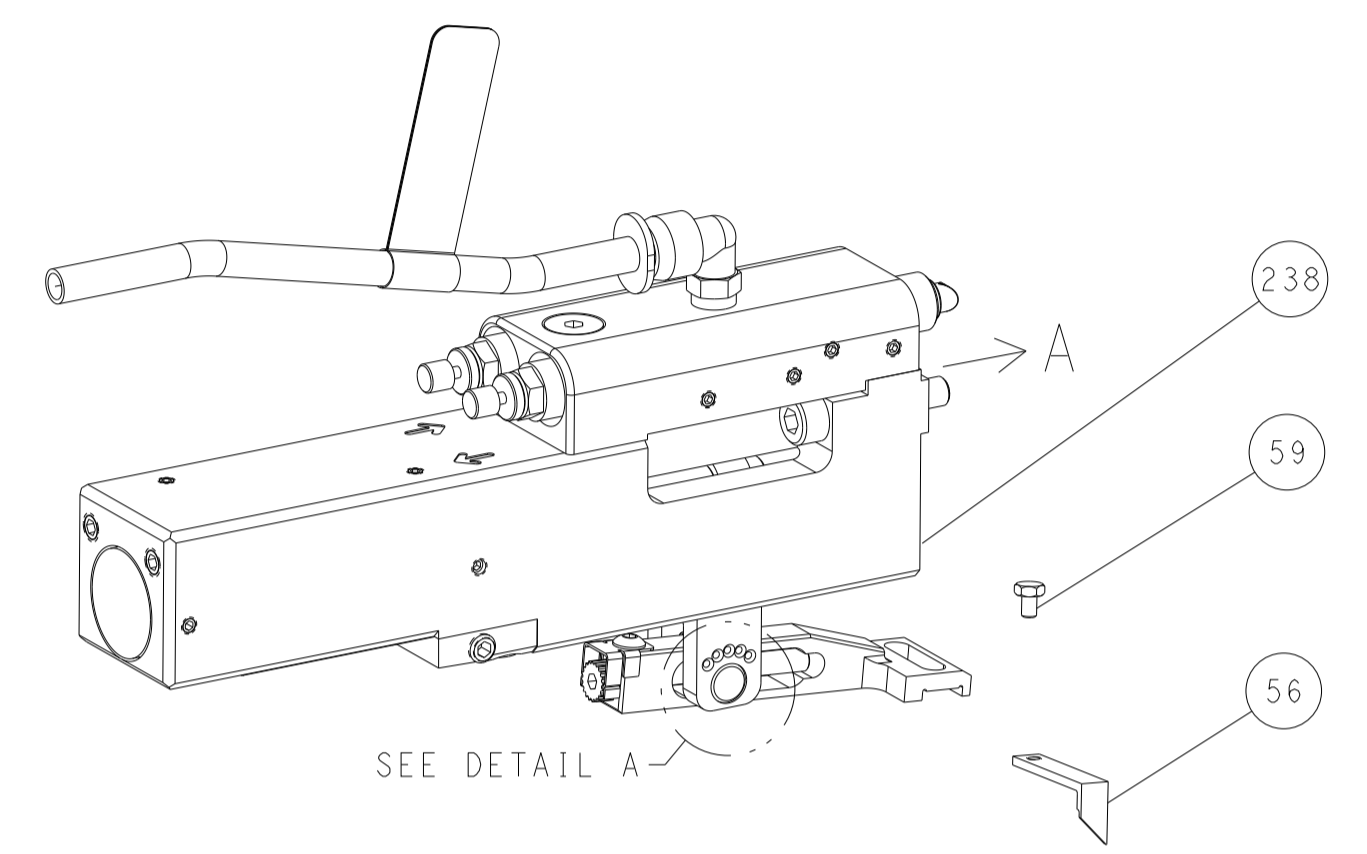
|                |  |  |  |                         |  |  |  |   |  |
|----------------|--|--|--|-------------------------|--|--|--|---|--|
| DIMENSIONS: mm |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DWG: C.CHEN 16OCT2012   |  | CHK: S.XI 16OCT2012                    |  | NAME: TE Connectivity Harrisburg, PA 17105-3608 |  |
| 0 PLC ±        |  | 1 PLC ±                                |  | APVD: J. CRUZ 16OCT2012 |  | PRODUCT SPEC                           |  | SIZE: A1  |  |
| 2 PLC ±        |  | 3 PLC ±                                |  | APPLICATION SPEC        |  | CAGE CODE: 00779                       |  | DRAWING NO: C=2151786                           |  |
| 4 PLC ±        |  | ANGLES FINISH                          |  | WEIGHT                  |  | SCALE: 1:2                             |  | SHEET 3 OF 4                                    |  |
| MATERIAL       |  |  |  | RESTRICTED TO           |  | Customer Accessible Production Drawing |  | REV D   |  |

| LOC | DIST        | REVISIONS |      |    |      |
|-----|-------------|-----------|------|----|------|
| A   | 66          | REV       | DATE | BY | APPV |
| -   | SEE SHEET 1 | -         | -    | -  | -    |

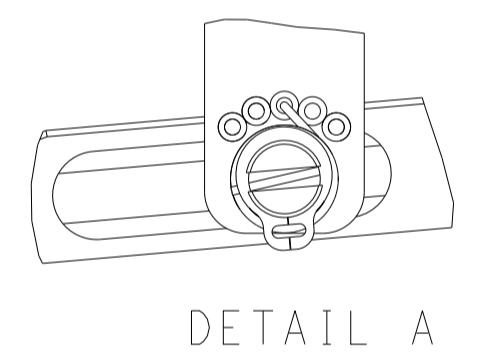
# FEED TYPE MECHANICAL



## PNEUMATIC

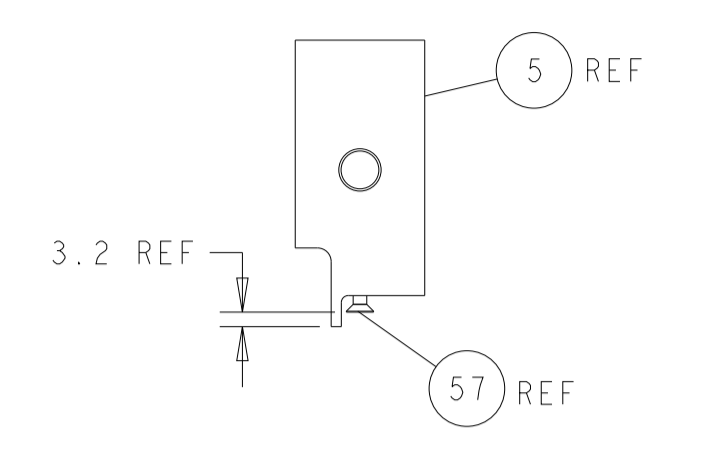
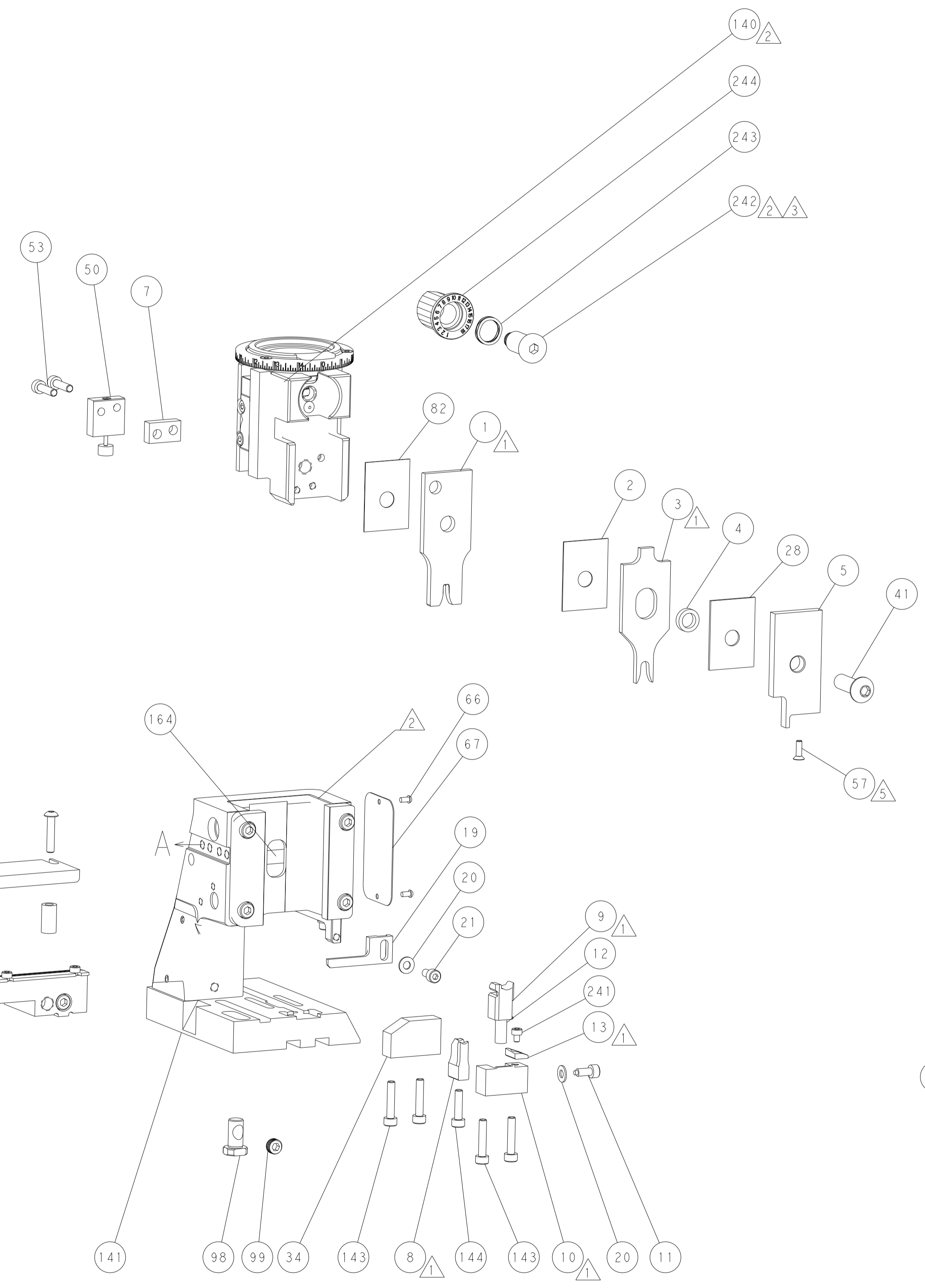
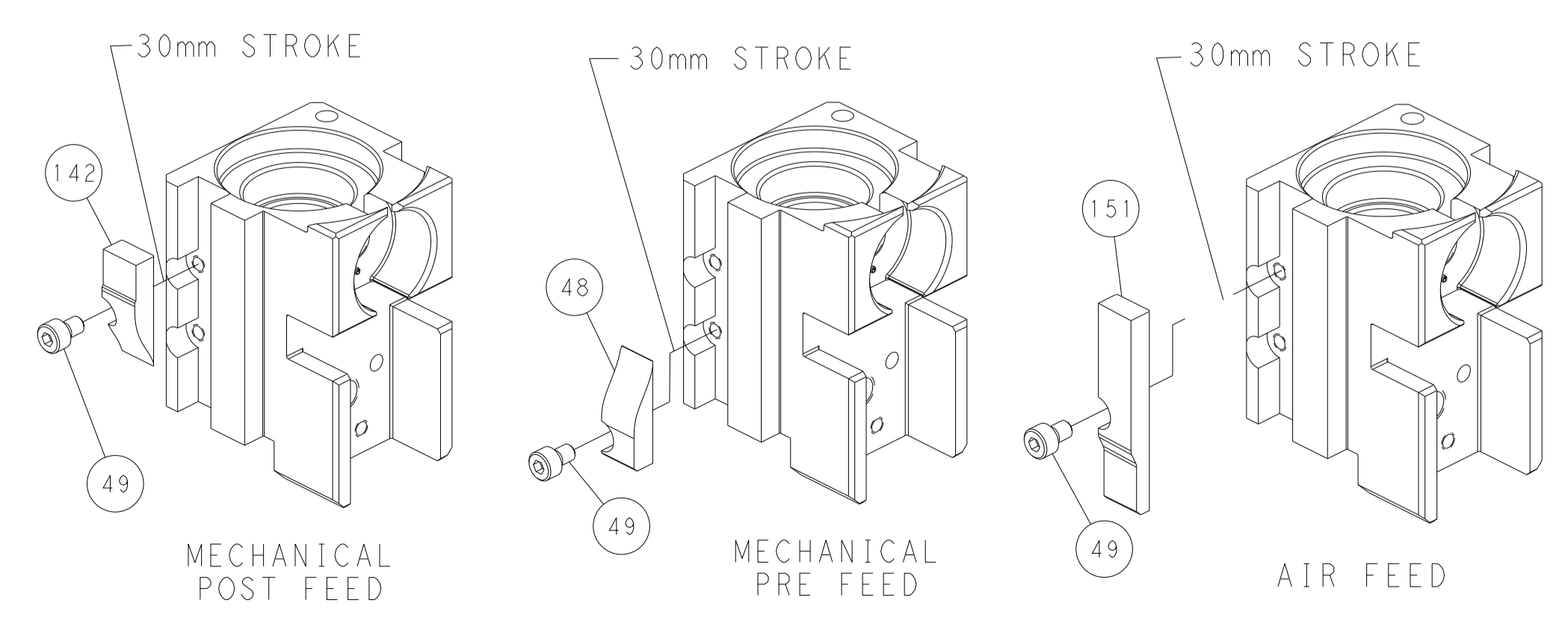


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

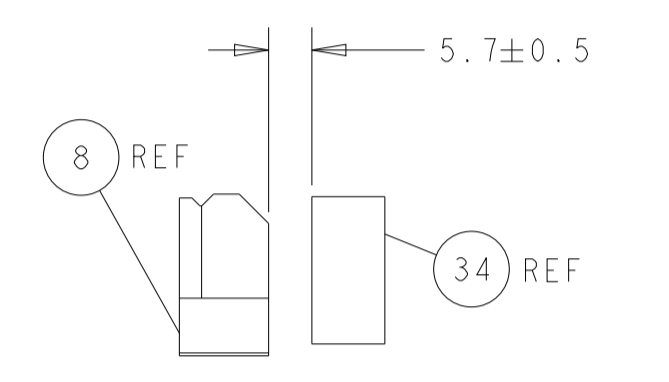


DETAIL A

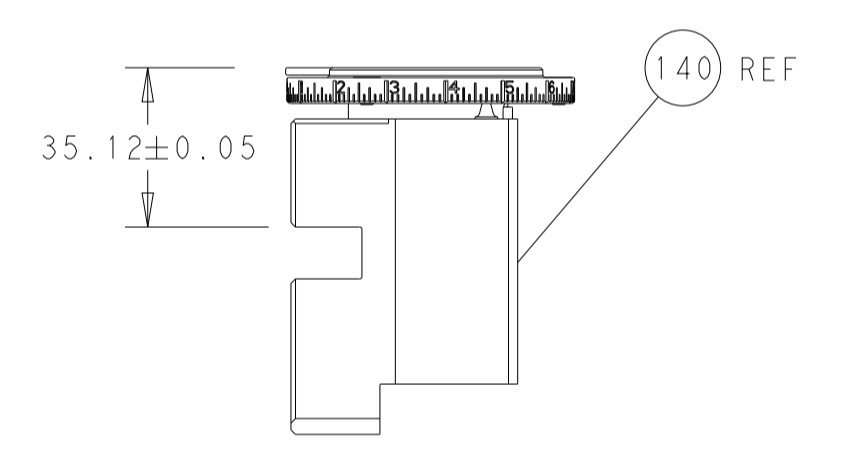
## CAM POSITIONS



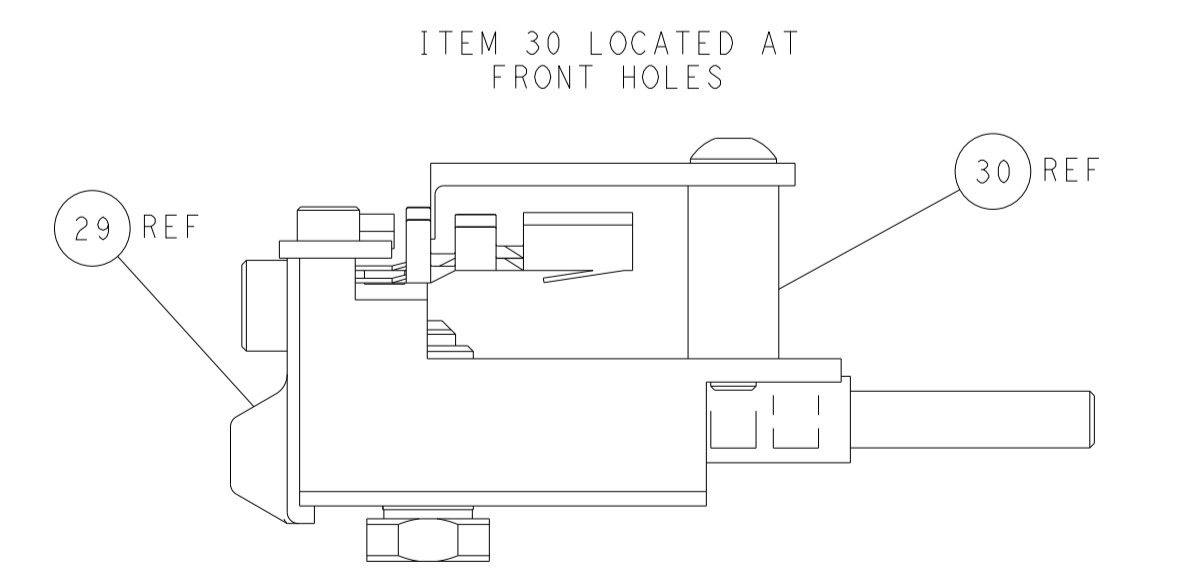
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

|   |   |   |  |
|---|---|---|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF COMPANY AND CONTAINS PROPRIETARY INFORMATION. IT IS TO BE CONTROLLED FOR THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> |   | DWN: C. CHEN 16OCT2012<br>CHK: S. XI 16OCT2012<br>APVD: J. CRUZ 16OCT2012 | NAME: TE Connectivity<br>Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ±  | APPLICATION SPEC<br>PRODUCT SPEC<br>RESTRICTED TO | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151786                       | SCALE: 1:2<br>SHEET: 4 of 4<br>REV: D              |
| MATERIAL:   |   | WEIGHT:   |  |
| Customer Accessible Production Drawing  |   |   |  |