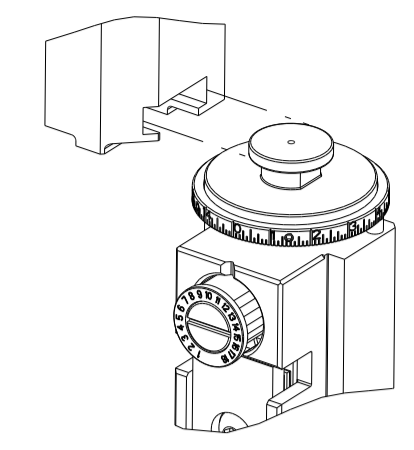


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151332-2	AA	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151332-2	AA	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151332-2	AA	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151332-7	Y	CRIMP TOOLING KIT	-

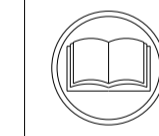
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.89 mm [.035]	F
INSUL	1.07 mm [.042]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO MQS TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.25-3.55 mm [.128-.140 IN]		Ø0.85-1.10 mm [.033-.043 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18858	-	-
	(B)114-137526	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A)1-1703930-1	(A)1-1703930-2	(B)2834464-5	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.17mm ²	0.63+/-0.02 [.0248+/- .0008]	6.5
0.13mm ²	0.59+/-0.02 [.0232+/- .0008]	7.0



- 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. THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- 6. TERMINAL LUBRICANT IS RECOMMENDED.
- 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)

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		Y	ECR-19-016655	25OCT2019	FJ GB
		Z	ECR-21-001302	01FEB2021	JWC GB
		Z1	ECR-21-003710	26MAR2021	FJ YY
		AA	ECR-21-120047	08NOV2021	FZ RK

-	-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119791-9	DEPRESSOR, WIRE	286
-	1	1	1	1-22281-8	SPRING, COMPRESSION	262
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	261
5	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	-	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
6	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	64
-	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	61
-	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
-	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
5	-	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	2-1803095-3	FLOATING SHEAR, FRONT	9
1	2	1	1	1633689-5	ANVIL, COMBINATION	8
-	1	1	1	240641-1	SPACER	7
-	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	6-238011-0	BLOCK, CRIMPER SPACER	4
1	1	2	1	4-1803019-7	CRIMPER, INSULATION O	3
-	-	-	-	-	-	2
1	1	2	1	1803697-2	CRIMPER, WIRE PREMIUM, STEPPED	1
-	77	-	72	-	-	-
-	72	-	32	-	-	-
-	-	-	-	2	PART NO	ITEM NO
-	-	-	-	-	DESCRIPTION	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:				
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE	1:2	SHEET	1	OF	4	REV	AA

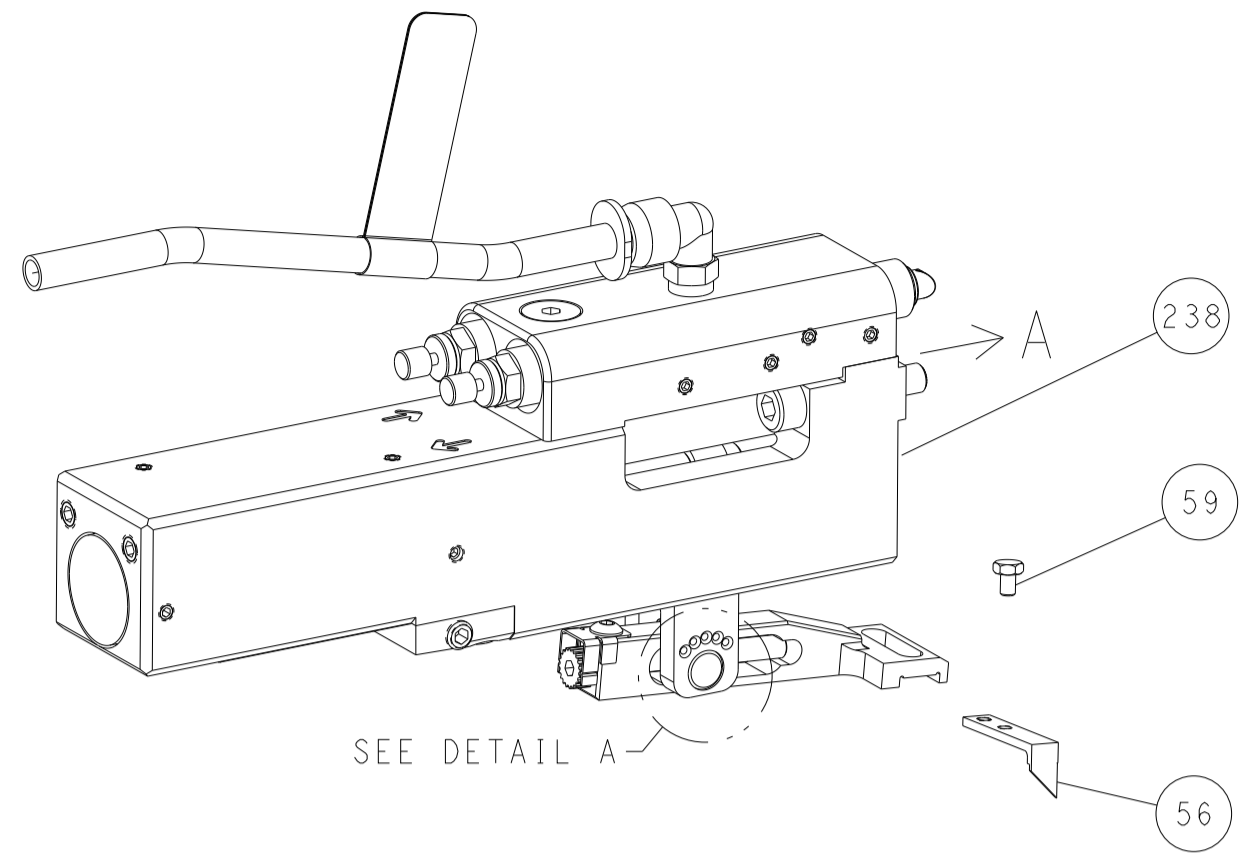
STE TE Connectivity
Harrisburg, PA 17105-3608

Ocean Side Feed Applicator

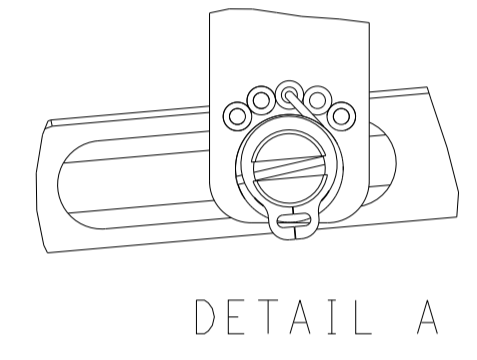
SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151332

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

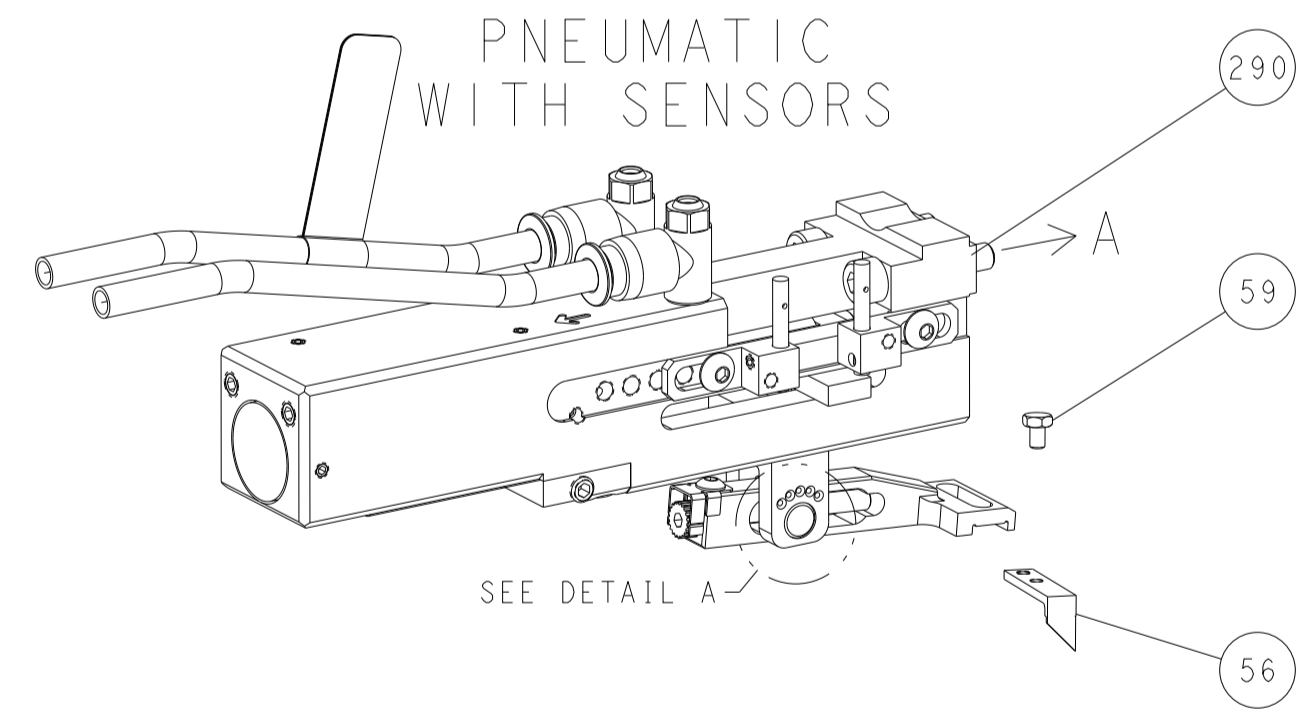
FEED TYPE PNEUMATIC



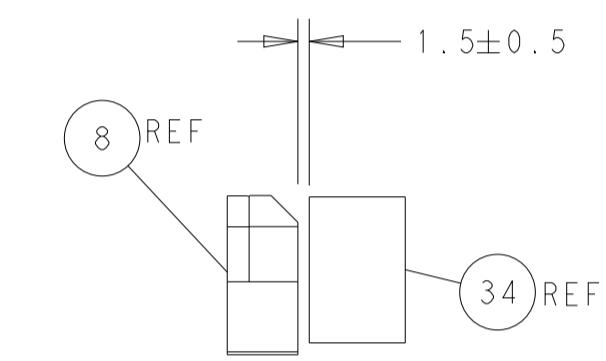
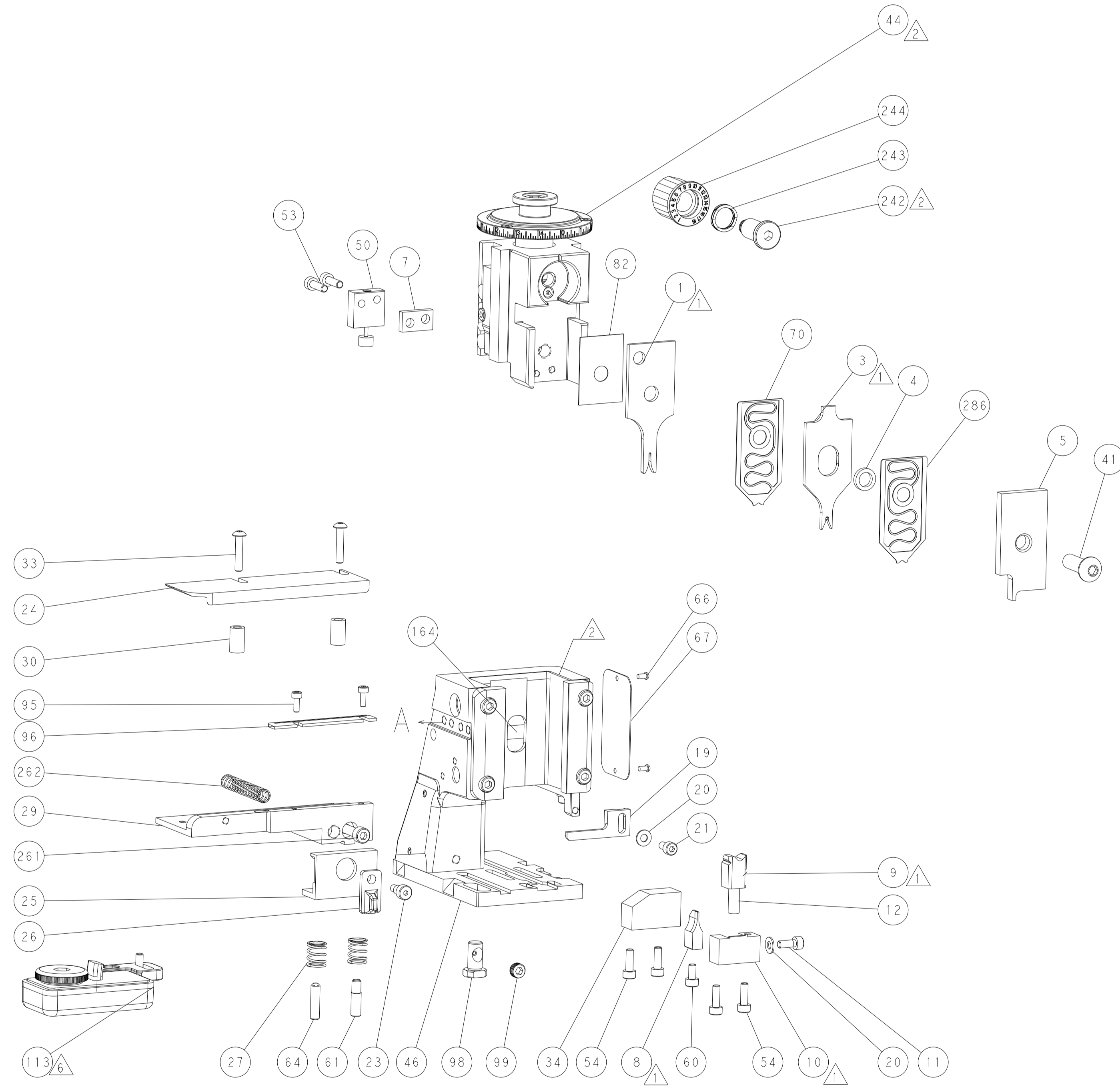
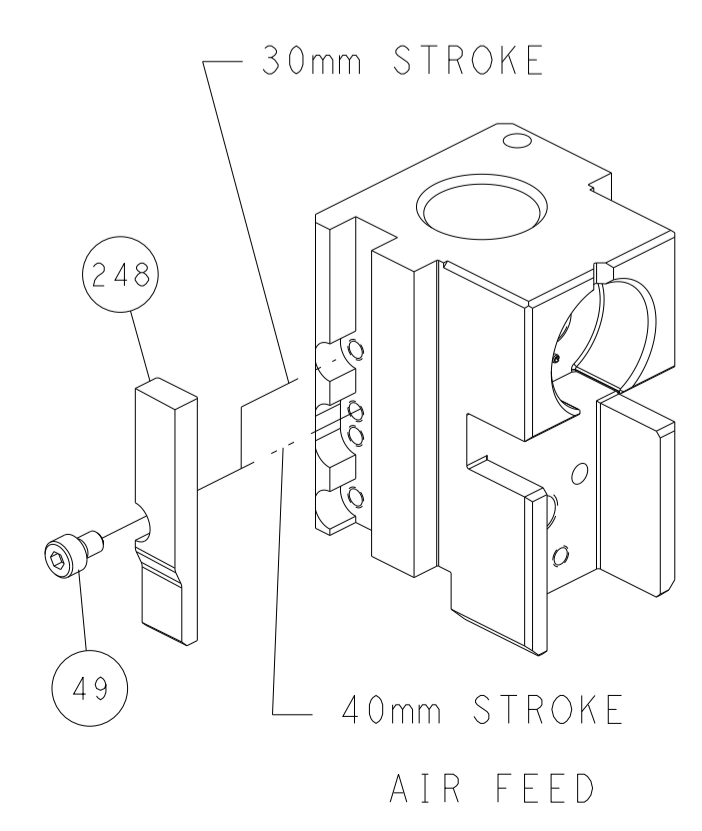
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



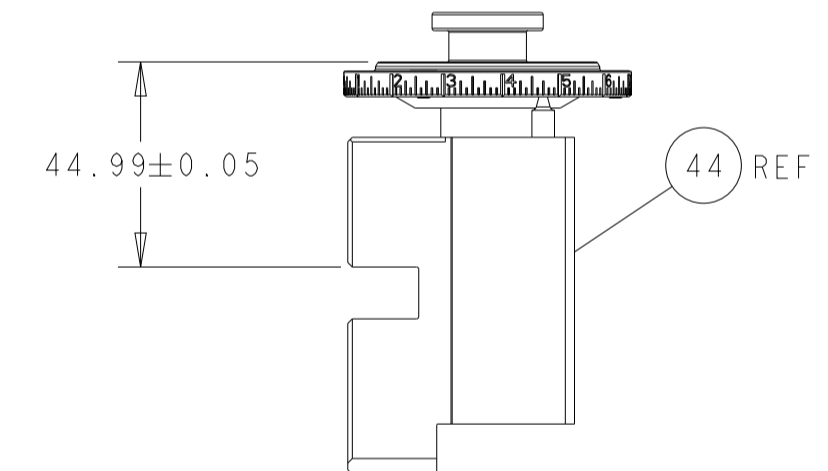
DOUBLE ACTING PNEUMATIC WITH SENSORS



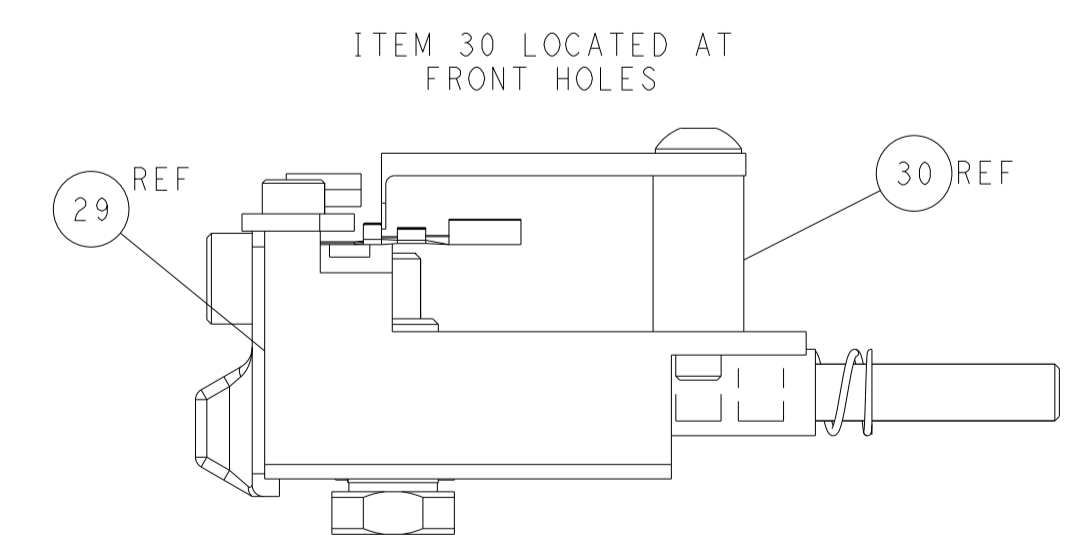
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



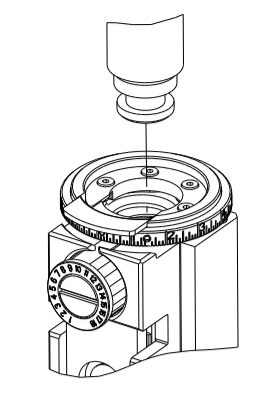
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: C. CHEN 05MAY2011 CHK: S. XI 05MAY2011 APVD: J. CRUZ 05MAY2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151332	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ± ±	PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2	SHEET 2 OF 4 REV AA RESTRICTED TO: -	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151332-2	AA	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151332-2	AA	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151332-7	Y	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.89 mm [.035]	F
INSUL	1.07 mm [.042]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO MQS TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.25-3.55 mm [.128-.140 IN]		Ø0.85-1.10 mm [.033-.043 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18858	-	-
	(B)114-137526	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A)1-1703930-1	(A)1-1703930-2	(B)2834464-5	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.17mm ²	0.63 +/- 0.02 [.0248 +/- .0008]	6.5
0.13mm ²	0.59 +/- 0.02 [.0232 +/- .0008]	7.0



- △ 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.
 - △ THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
 - △ TERMINAL LUBRICANT IS RECOMMENDED.
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

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151332-2	2151332-2	1	WIRE CRIMPER	2370388-2
9-2151332-2	2-2151332-2	3	INSULATION CRIMPER	4-1803627-7
		46	BASIC SUB -ASSEMBLY	1803940-9
		141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

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

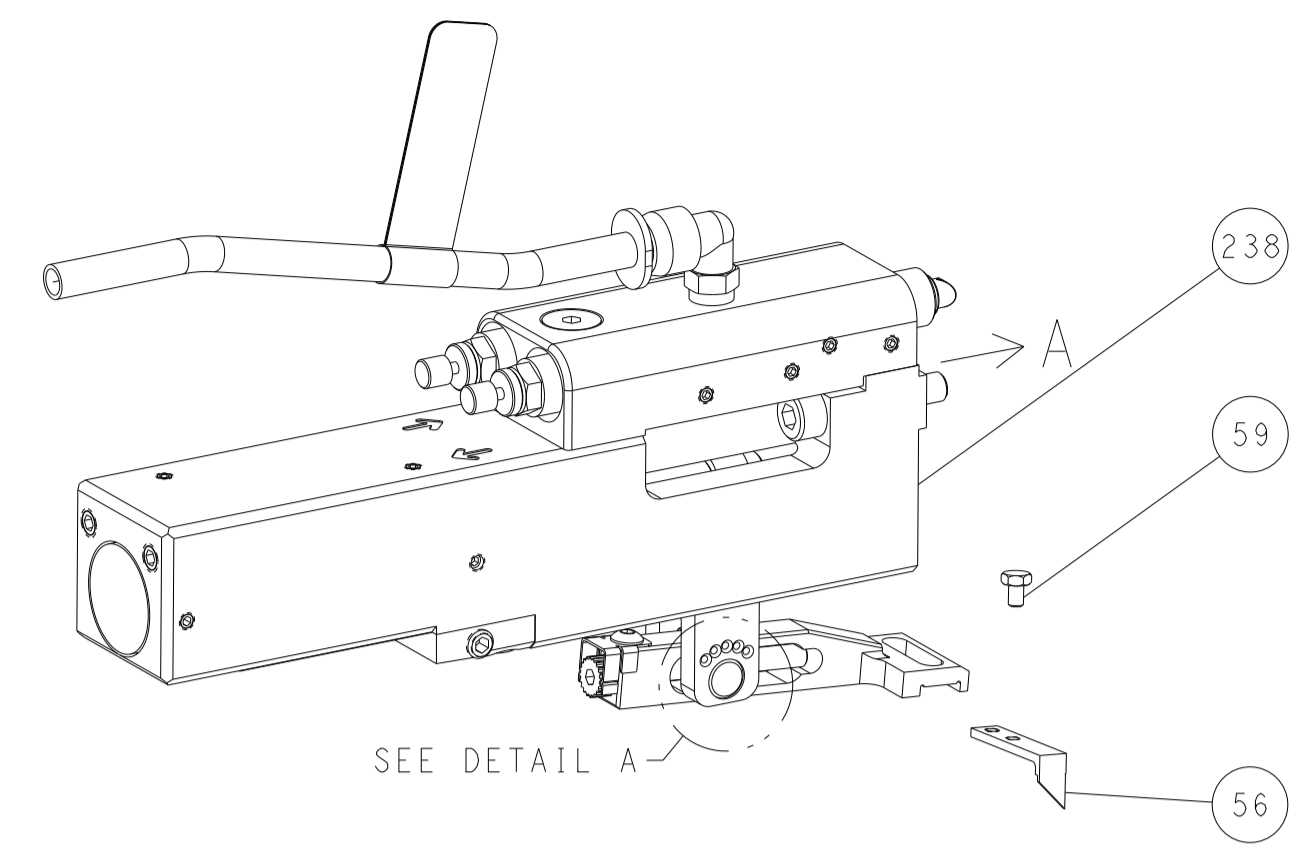
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	2119791-9	DEPRESSOR, WIRE	286
-	1	1	1-22281-8	SPRING, COMPRESSION	262
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	261
-	1	1	2119082-5	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	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	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
△	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	64
-	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
△	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
△	-	1	2119805-1	SHEAR HOLDER, FRONT	10
△	-	1	2-1803095-3	FLOATING SHEAR, FRONT	9
△	1	1	1633689-5	ANVIL, COMBINATION	8
△	-	1	240641-1	SPACER	7
-	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	1	1	6-238011-0	BLOCK, CRIMPER SPACER	4
△	1	1	4-1803019-7	CRIMPER, INSULATION O	3
-	-	-	-	-	2
△	1	1	1803697-2	CRIMPER, WIRE PREMIUM, STEPPED	1

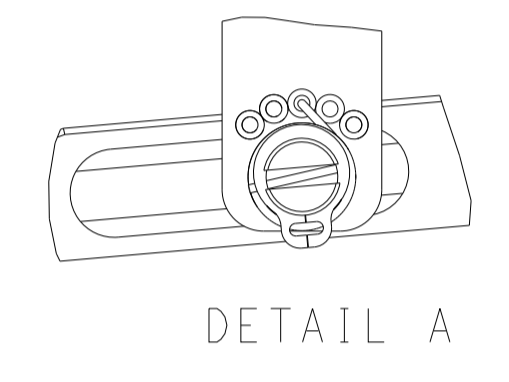
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: C.CHEN 05MAY2011		CHK: S.XI 05MAY2011		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: J. CRUZ 05MAY2011	PRODUCT SPEC	SIZE: A1	CAGE CODE: 00779
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2	DRAWING NO: C=2151332	RESTRICTED TO:	Customer Accessible Production Drawing		SHEET: 3	OF: 4

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

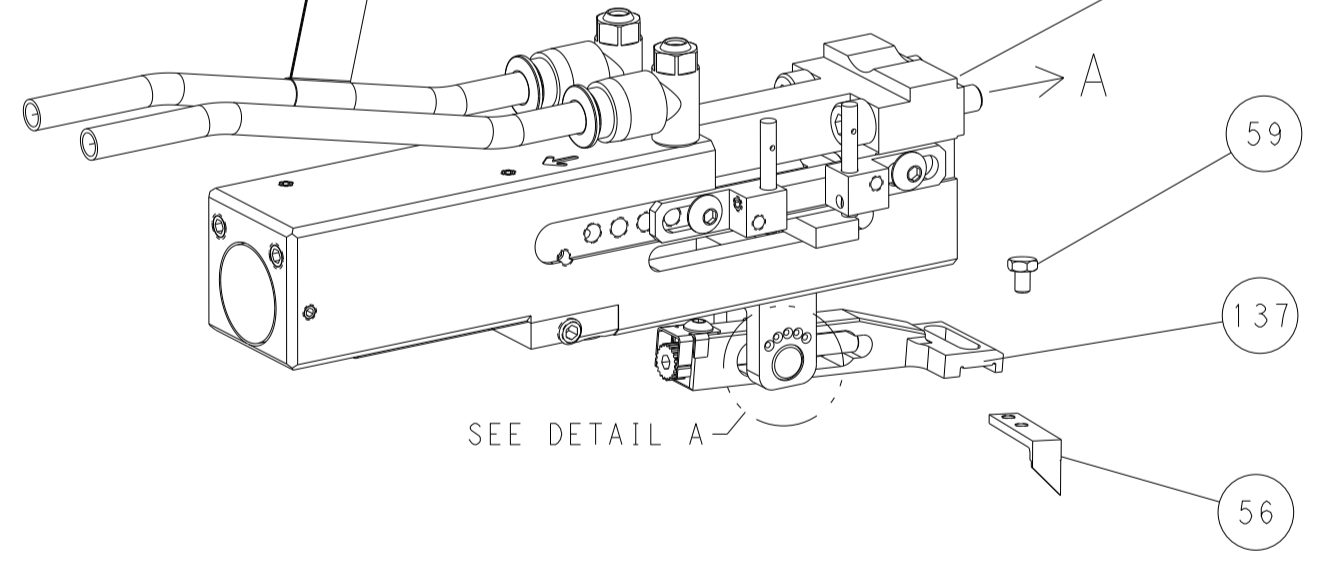
FEED TYPE PNEUMATIC



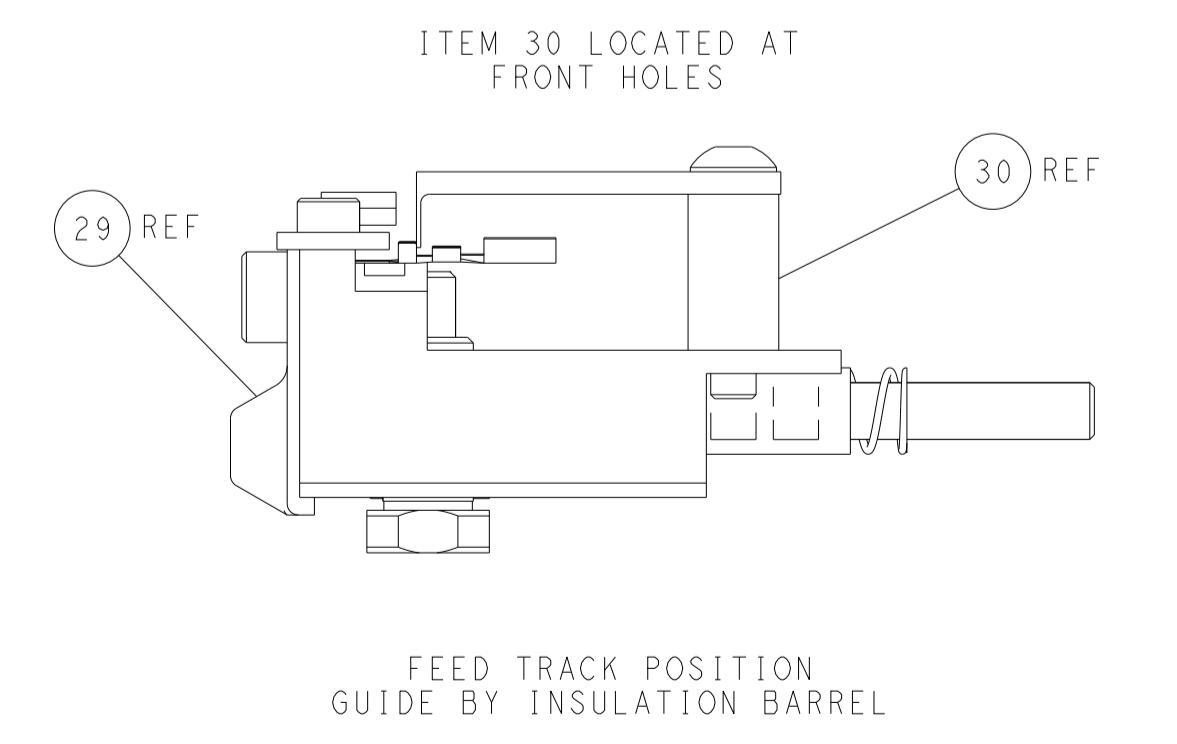
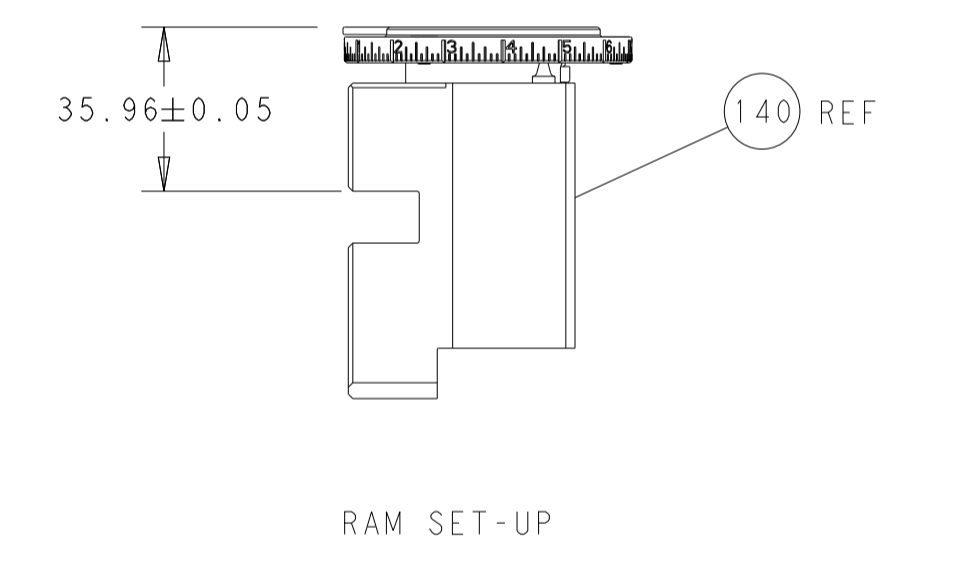
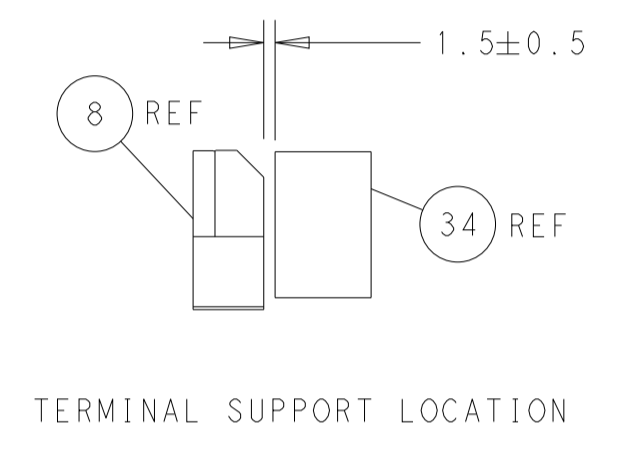
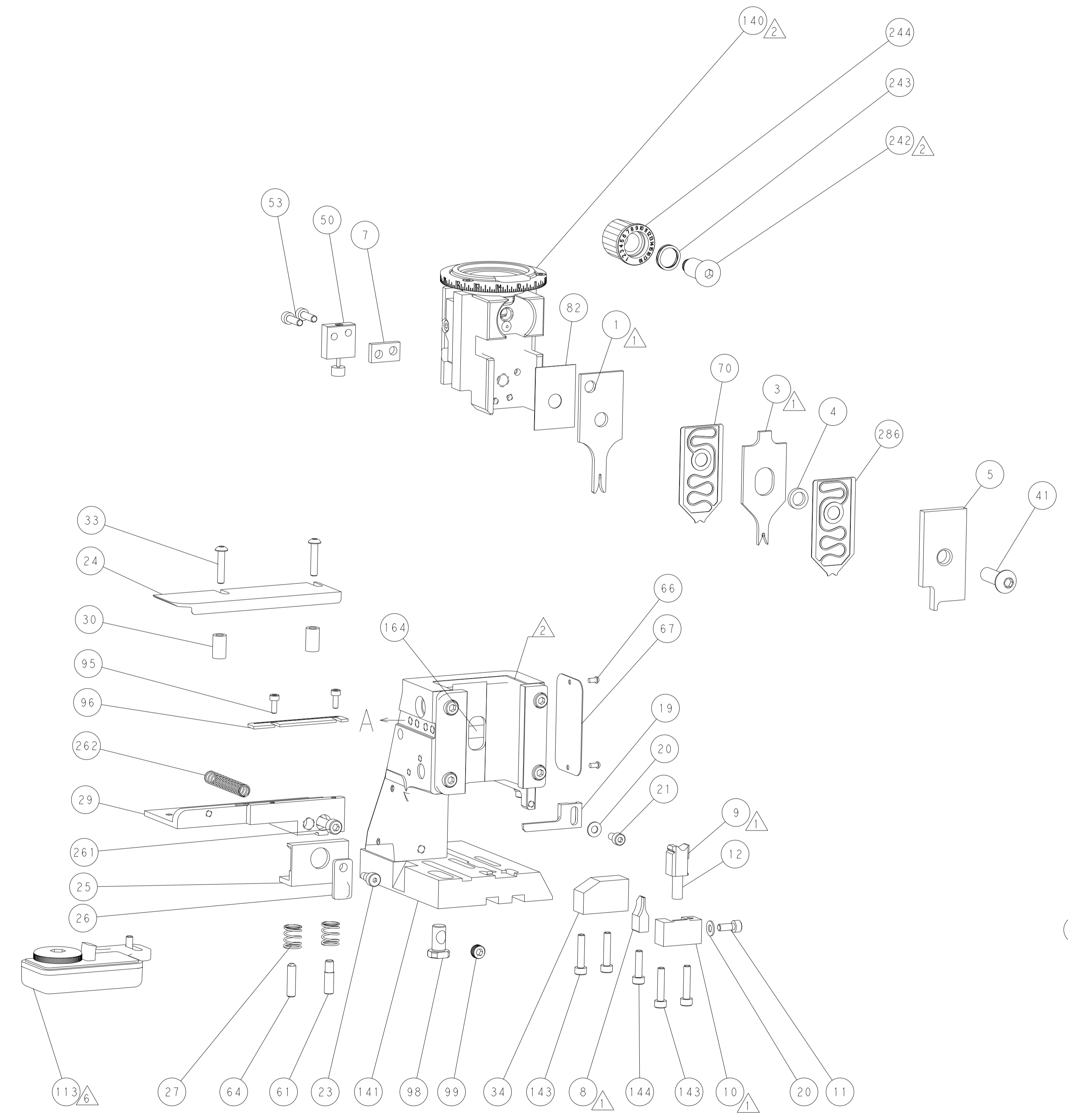
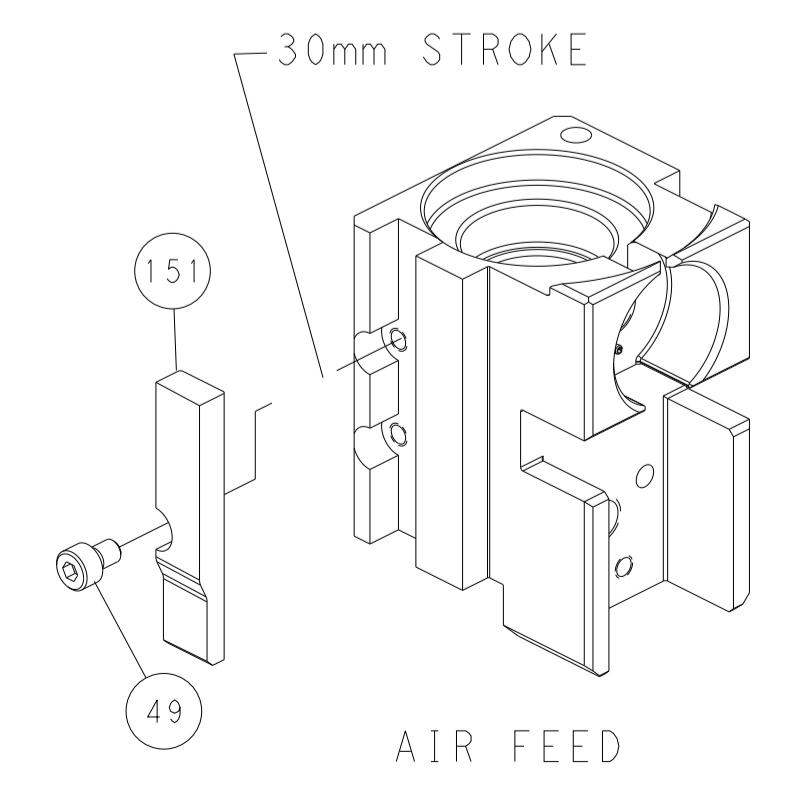
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DOUBLE ACTING PNEUMATIC WITH SENSORS



CAM POSITION



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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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151332 RESTRICTED TO: -	SCALE: 1:2 SHEET: 4 OF 4 REV: AA
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	