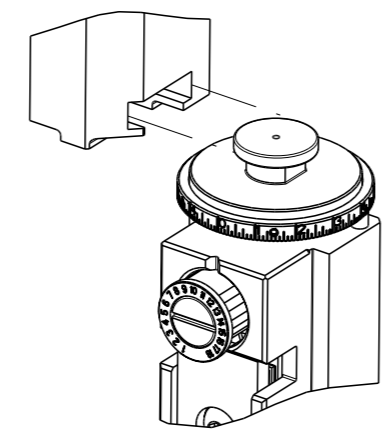


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151753-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151753-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151753-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151753-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151753-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

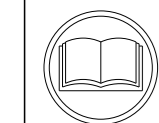


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.58 mm [.062]	F
INSUL	2.03 mm [.080]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN RECEPTACLE, .030 DIA.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.17-3.43 mm [.125-.135 IN]		Ø1.22-1.80 mm [.048-.071 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2083		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742980-1	60348-4	60373-4	42428-5
42428-6	42428-8		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.17+/-0.05 [1.046+/-0.002]	9.2
22 AWG	1.09+/-0.05 [1.043+/-0.002]	10.0
24 AWG	1.02+/-0.05 [1.040+/-0.002]	10.7



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

***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	LYR	DESCRIPTION	DATE	OWN	APVD
		B		ECR-14-011594	31JUL2014	RK	GB
		C		ECR-17-000578	13JAN2017	TB	GB
		D		ECR-19-017839	18NOV2019	FJ	TE

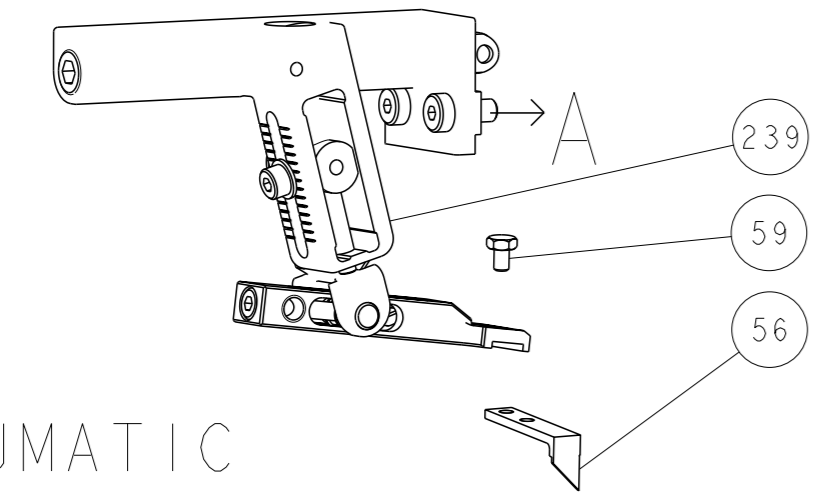
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	3-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	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
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1-1633927-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2
-	1	2	2	1	1-456403-6	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APPROVED	NAME
	ANGLES	FINISH					
MATERIAL				WEIGHT		SCALE	RESTRICTED TO

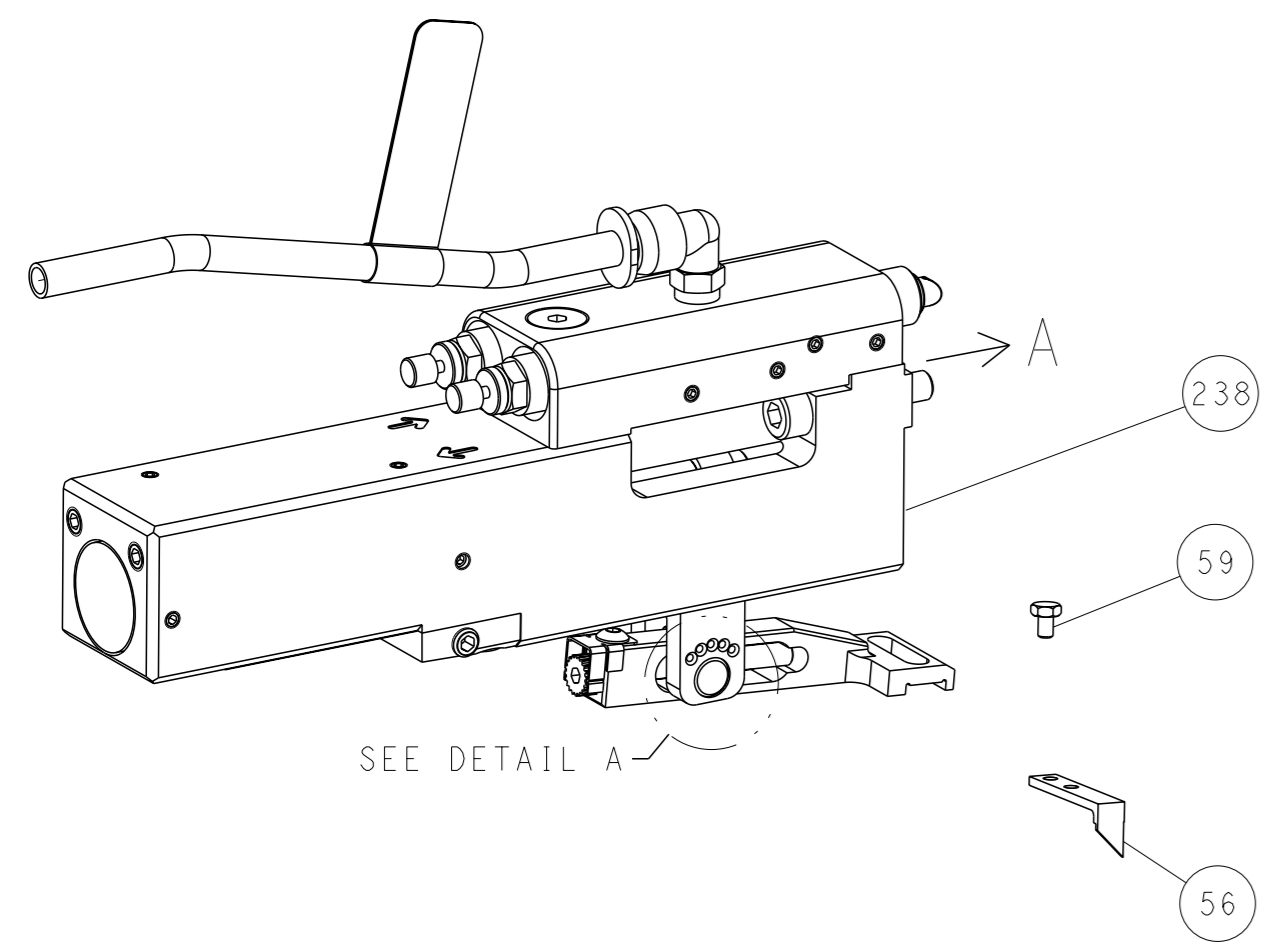
Customer Accessible Production Drawing

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

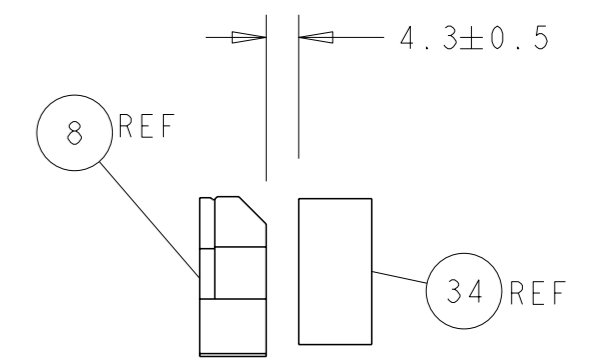
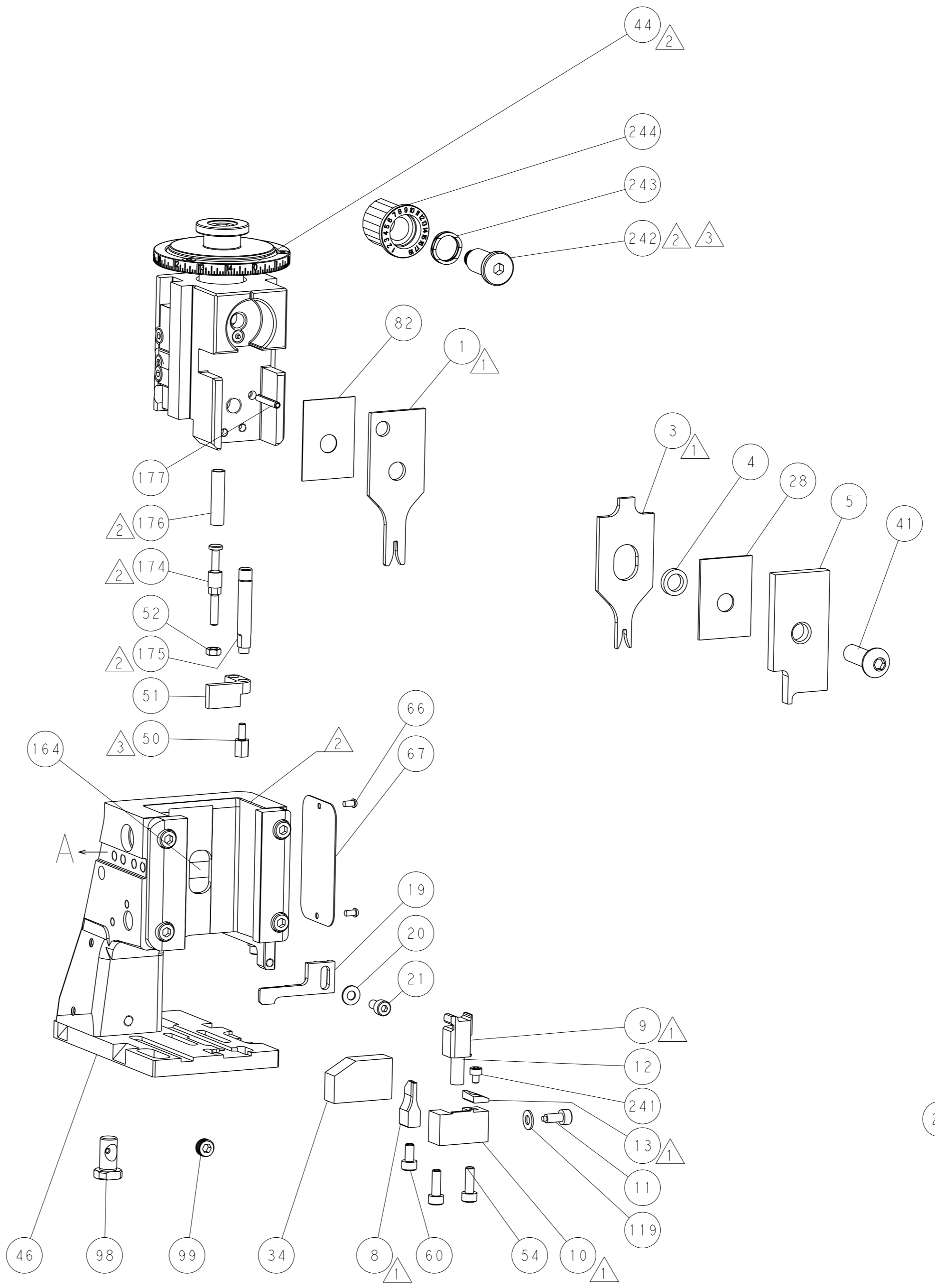
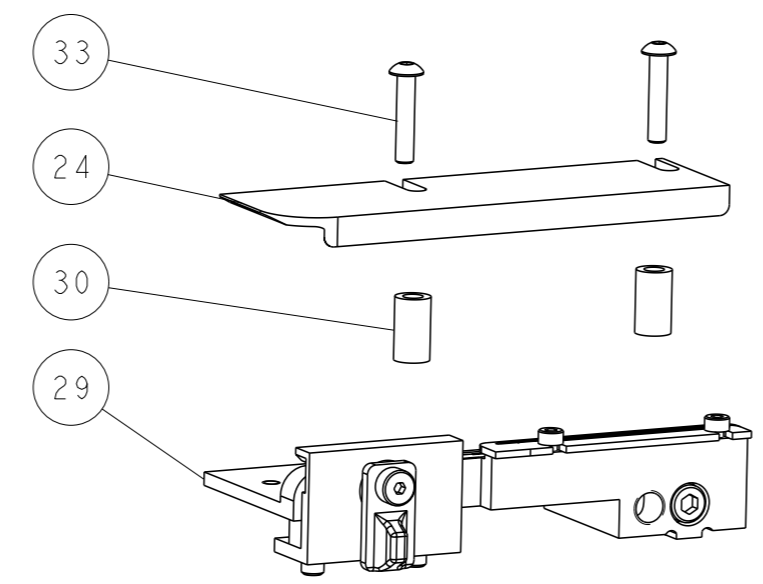
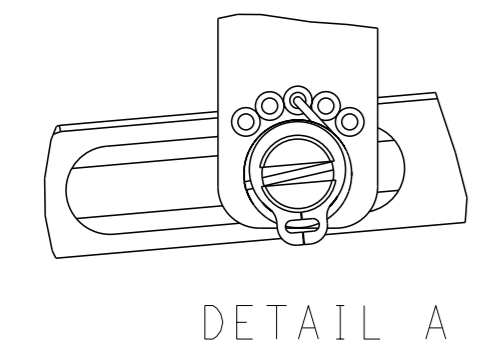
FEED TYPE MECHANICAL



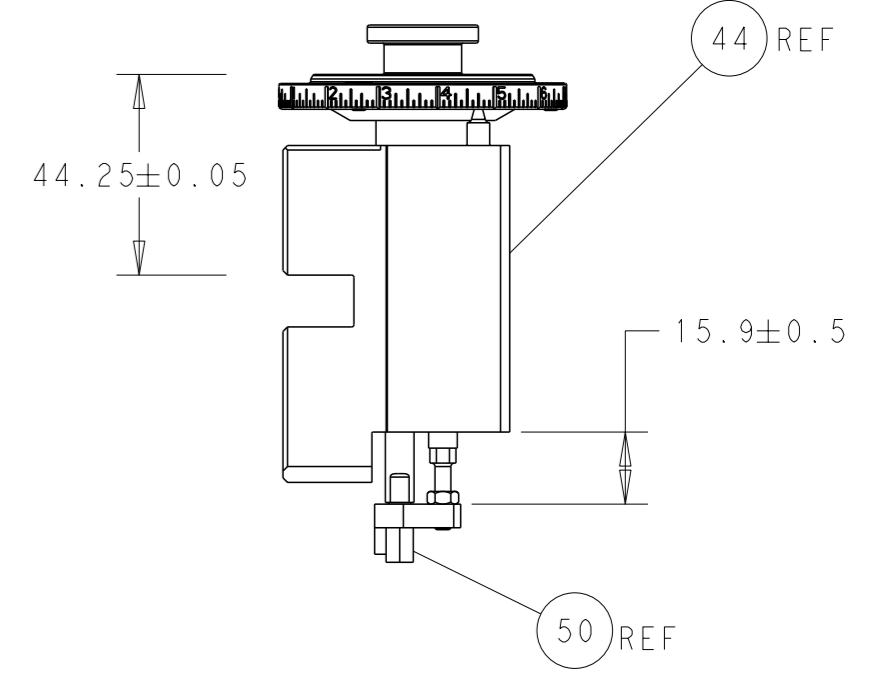
PNEUMATIC



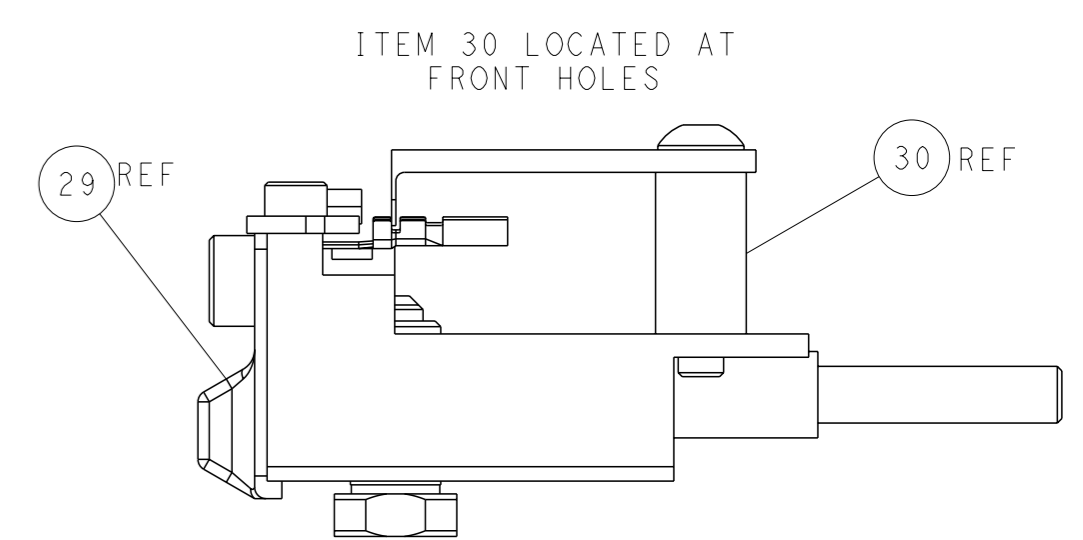
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

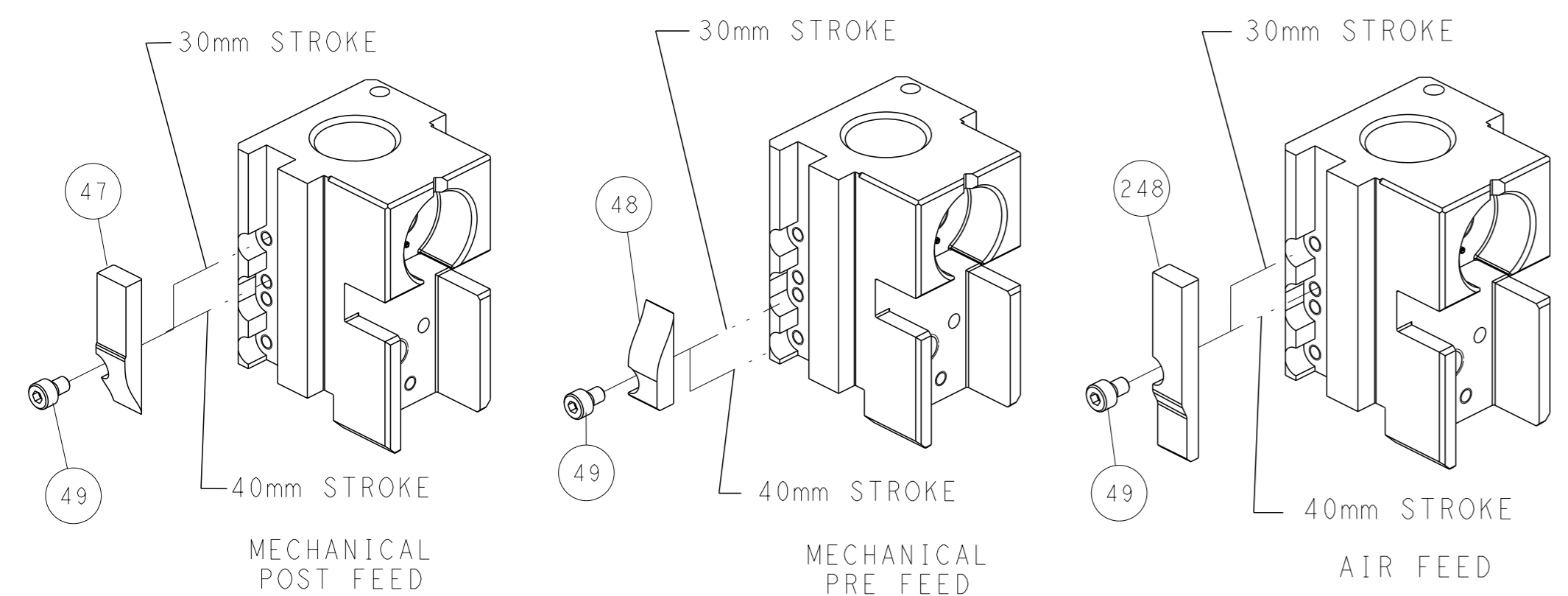


RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

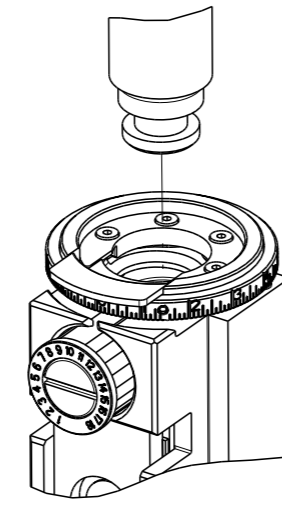


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ±		OWN: HOFFNER 30AUG2012 CHK: T. ELBIN 31AUG2012 APVD: T. ELBIN 31AUG2012 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151753 SCALE: 1:2 SHEET: 2 of 4 REV: D	
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THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	20		
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151753-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151753-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151753-7	A	CRIMP TOOLING KIT	-

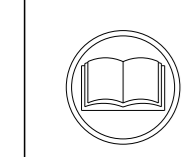
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.58 mm [.062]	F
INSUL	2.03 mm [.080]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN RECEPTACLE, .030 DIA.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.17-3.43 mm [.125-.135 IN]		Ø1.22-1.80 mm [.048-.071 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2083		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742980-1	60348-4	60373-4	42428-5
42428-6	42428-8		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.17+/-0.05 [.046+/-0.002]	9.2
22 AWG	1.09+/-0.05 [.043+/-0.002]	10.0
24 AWG	1.02+/-0.05 [.040+/-0.002]	10.7



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

***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)

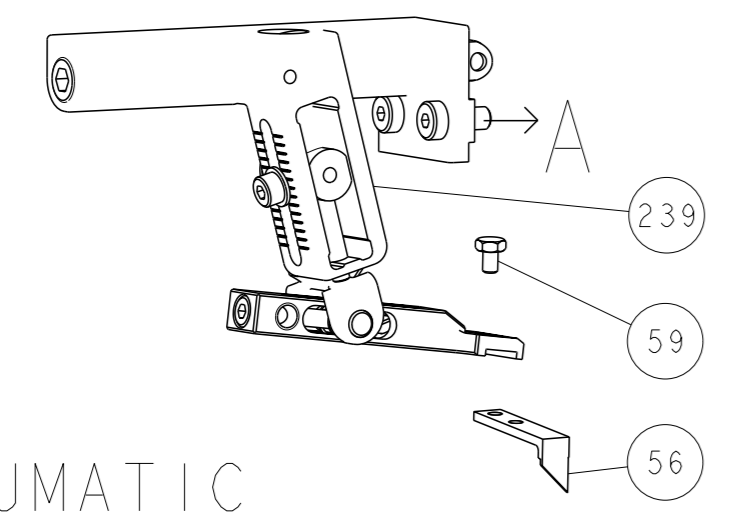
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		-	SEE SHEET 1	-	-

1	1	2119082-9	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
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
1	-	2844940-1	AIR FEED MODULE	238
1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
1	1	8-22280-7	SPRING, COMPRESSION	176
1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
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
2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	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	1-18028-2	WASHER, FLAT, REG M4	119
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
1	1	1338685-1	PAWL, FEED	56
1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
1	1	1901681-1	HOLDDOWN, TERMINAL	51
1	1	1-1752354-5	STANDOFF, HOLD-DOWN	50
1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	2119652-1	FEED CAM, PRE FEED	48
1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
1	1	3-1752356-4	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	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
1	1	1-18028-2	WASHER, FLAT, REG M4	20
1	1	2119533-1	STRIPPER, SIDE FEED	19
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	2119805-1	SHEAR HOLDER, FRONT	10
1	1	454276-5	FLOATING SHEAR, FRONT	9
1	1	2-1633927-1	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
1	1	2119757-4	DEPRESSOR, SHEAR	5
1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
1	1	5-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	2
1	1	1-456403-6	CRIMPER, WIRE PREMIUM	1

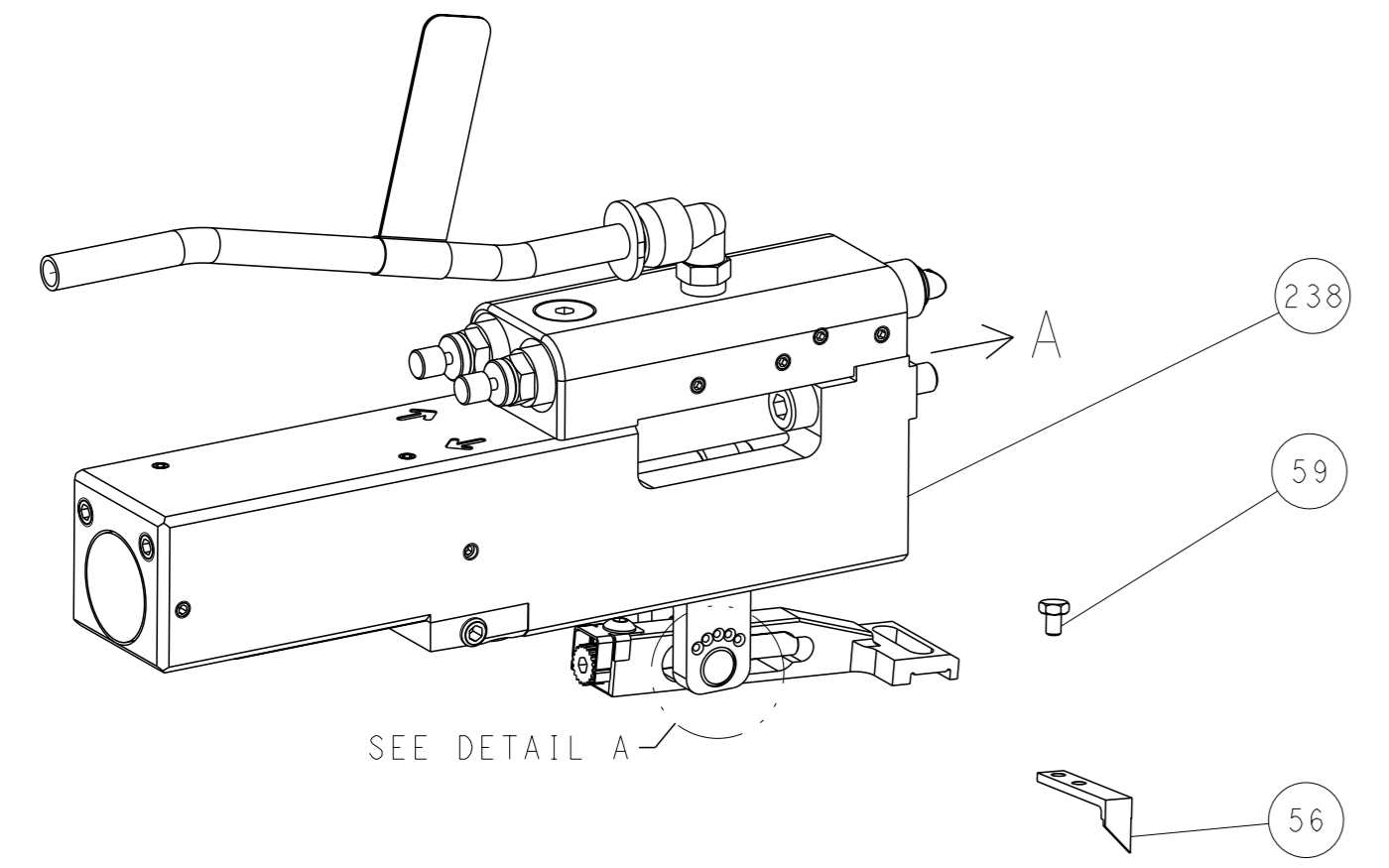
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	30AUG2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	31AUG2012	
	3 PLC ±	4 PLC ±	5 PLC ±	APPV	31AUG2012	
	ANGLES	FINISH		NAME		
MATERIAL				PRODUCT SPEC		Ocean Side Feed Applicator
				APPLICATION SPEC		
				SIZE	CAGE CODE	DRAWING NO
				WEIGHT	A1	00779
						©=2151753
						Customer Accessible Production Drawing
						SCALE 1:2 SHEET 3 OF 4 REV D

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

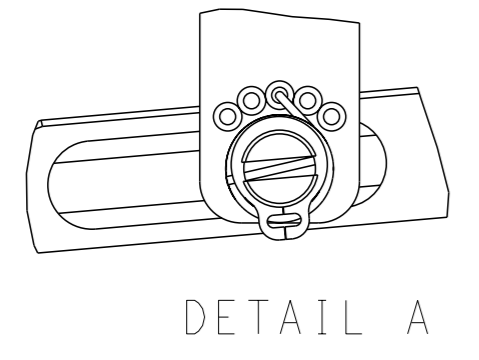
FEED TYPE MECHANICAL



PNEUMATIC

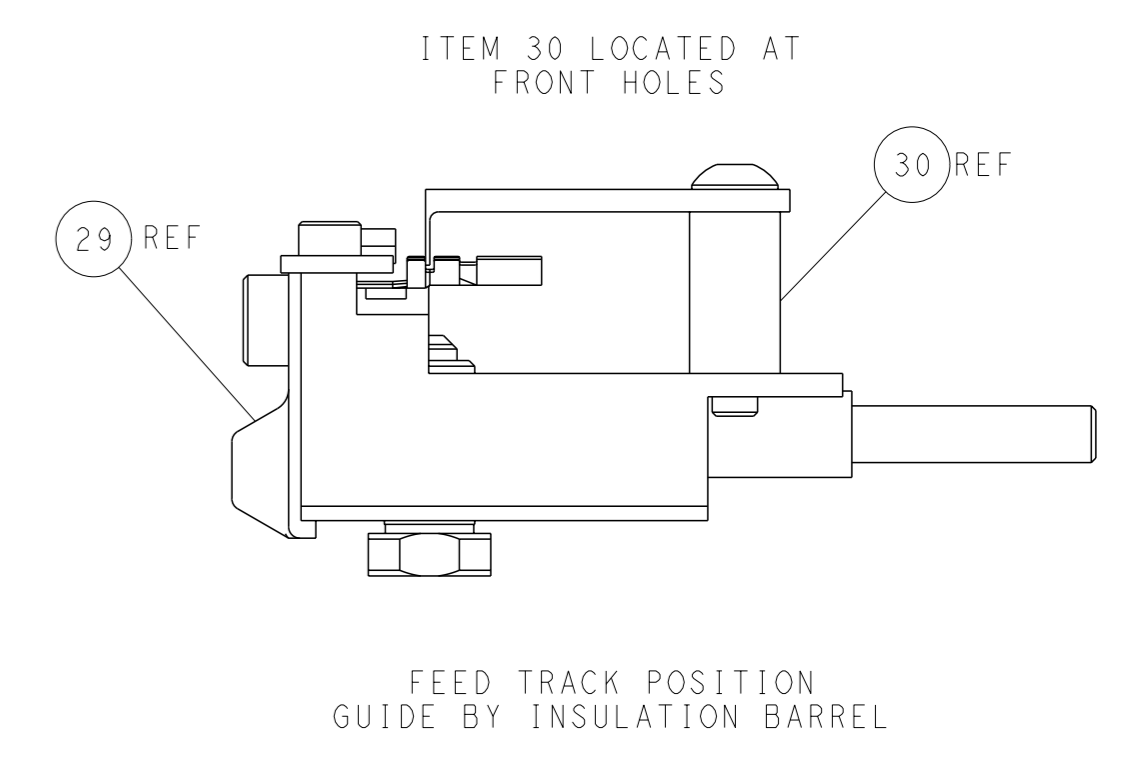
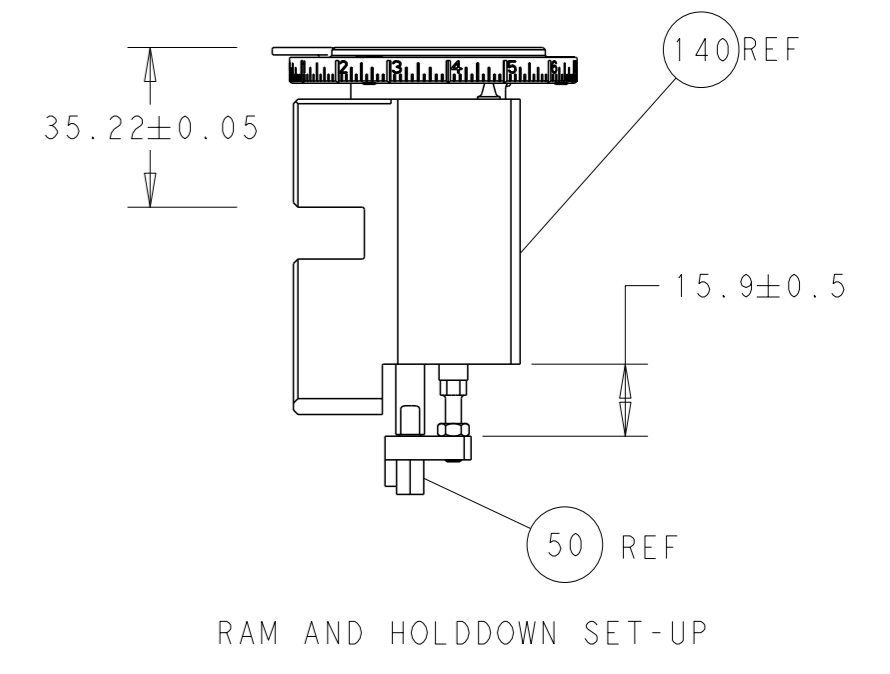
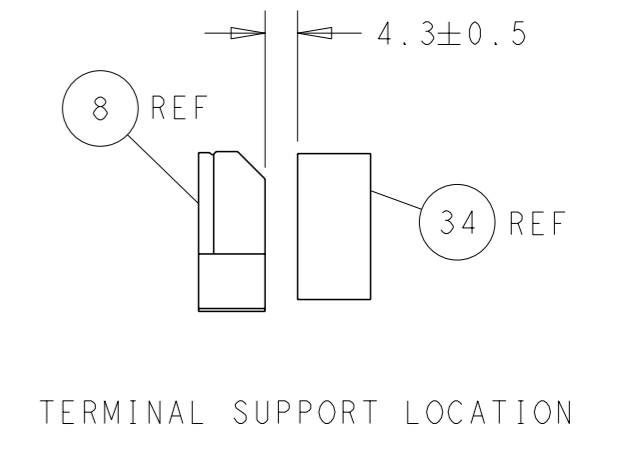
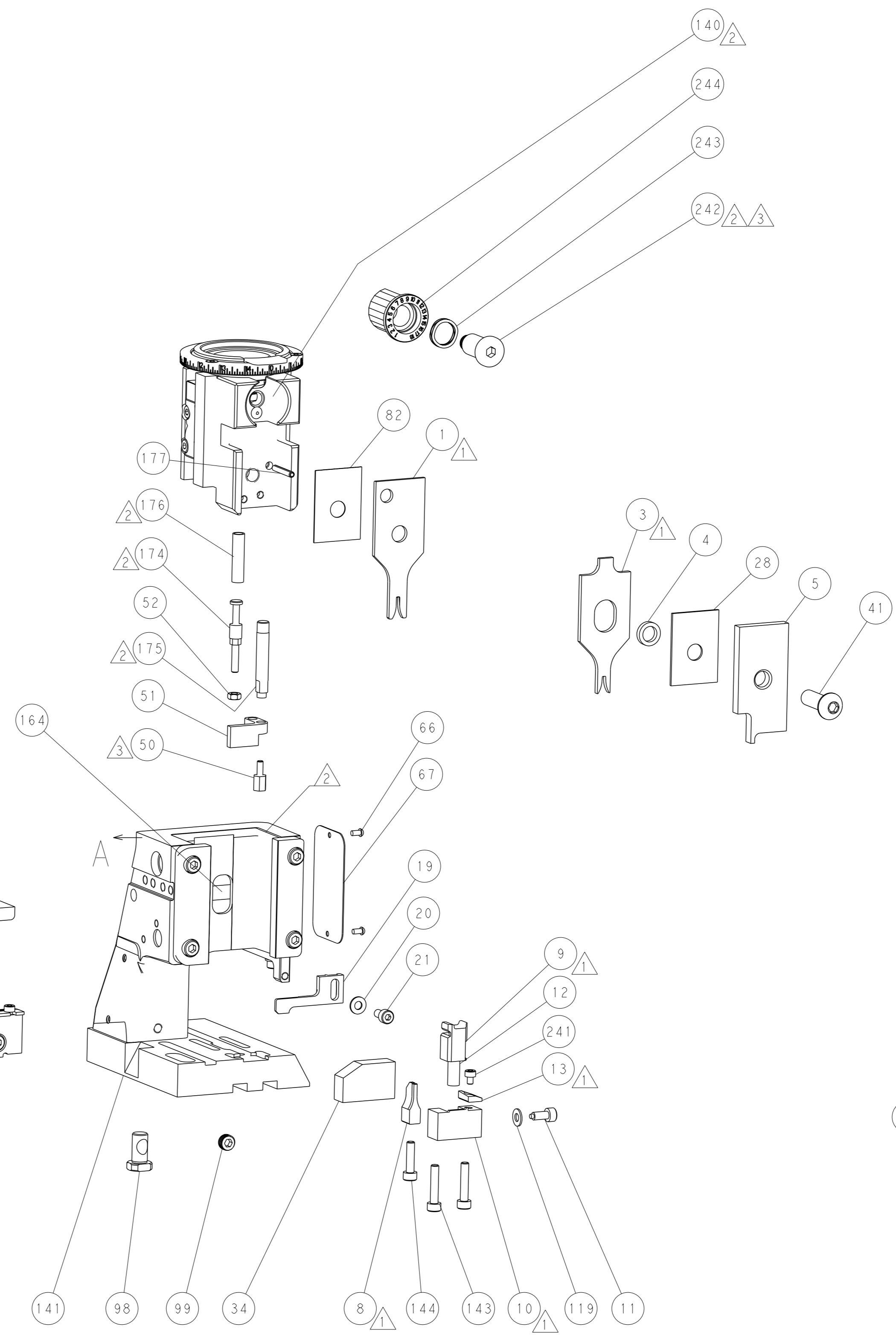
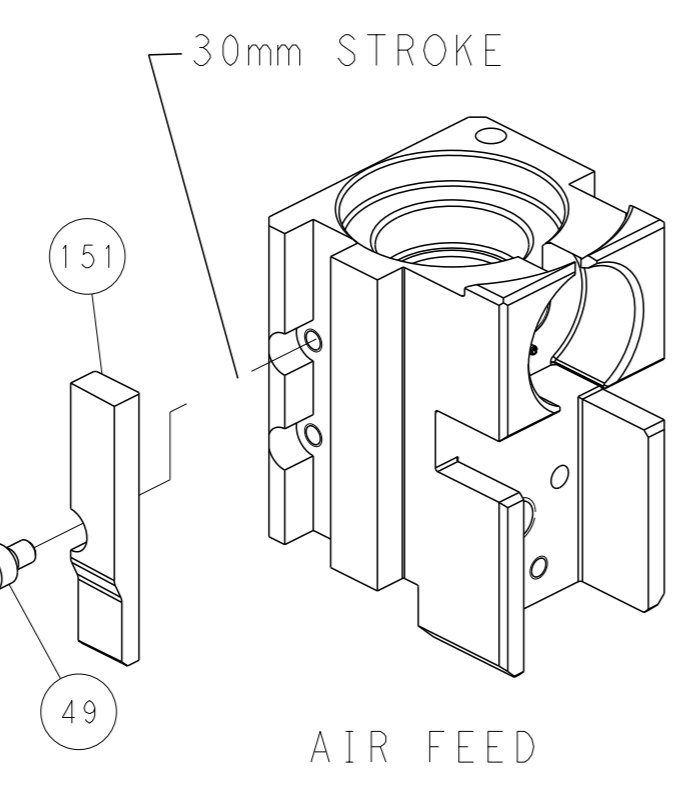
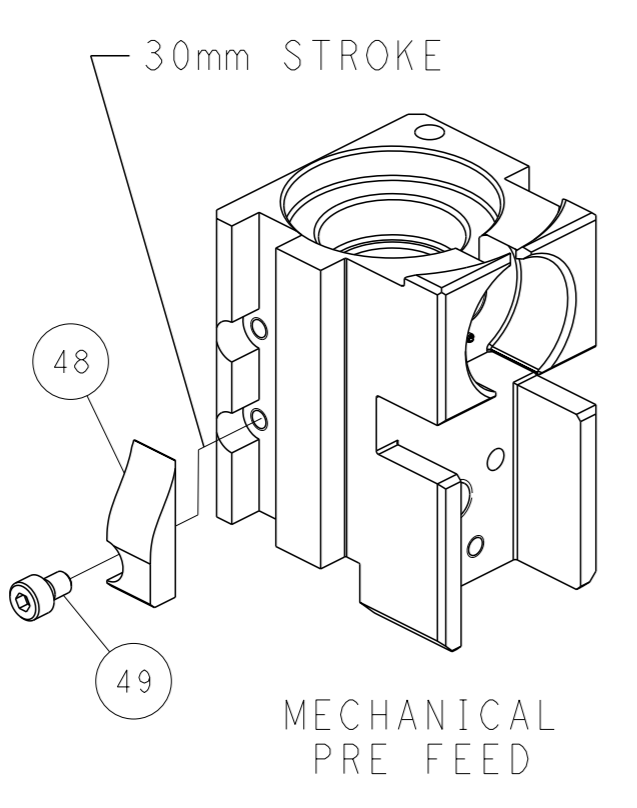
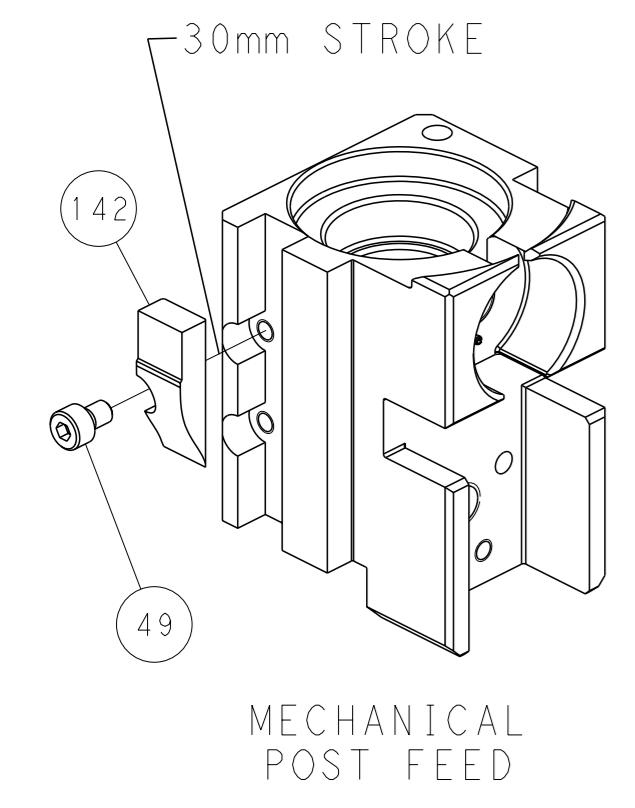


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS



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 SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: HOFFNER CHK: T. ELBIN APVD: T. ELBIN PRODUCT SPEC: - APPLICATION SPEC: - MATERIAL: - FINISH: -	DATE: 30AUG2012 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151753 SCALE: 1:2 SHEET: 4 of 4 REV: D	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	RESTRICTED TO: -	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION