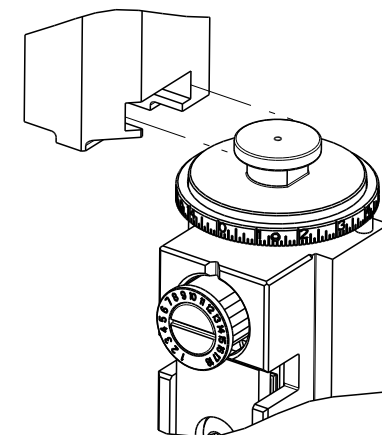


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151553-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151553-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151553-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

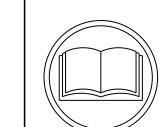


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.80-3.81 mm [.150-.150 IN]		Ø2.00-3.30 mm [.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
880646-1	880646-2	880646-5	880646-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.63+/-0.05 [.064+/- .002]	8.7
0.75mm2	1.52+/-0.05 [.060+/- .002]	9.8
0.50mm2	1.45+/-0.05 [.057+/- .002]	10.7



- 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 ITEM 50. 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.
- 5. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

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
		B		ECR-13-003288	22FEB2013	KH	GB
		C		ECR-19-009437	17JUN2019	FJ	TE
		D		ECR-19-010348	03JUL2019	FZ	LG
		E		ECR-19-011197	16JUL2019	TB	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	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
-	1	1	2844940-2	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	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	455888-5	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	2-1752354-6	STANDOFF,HOLD-DOWN	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	3-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	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	2	1633920-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	2	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
-	1	2	1-456405-6	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

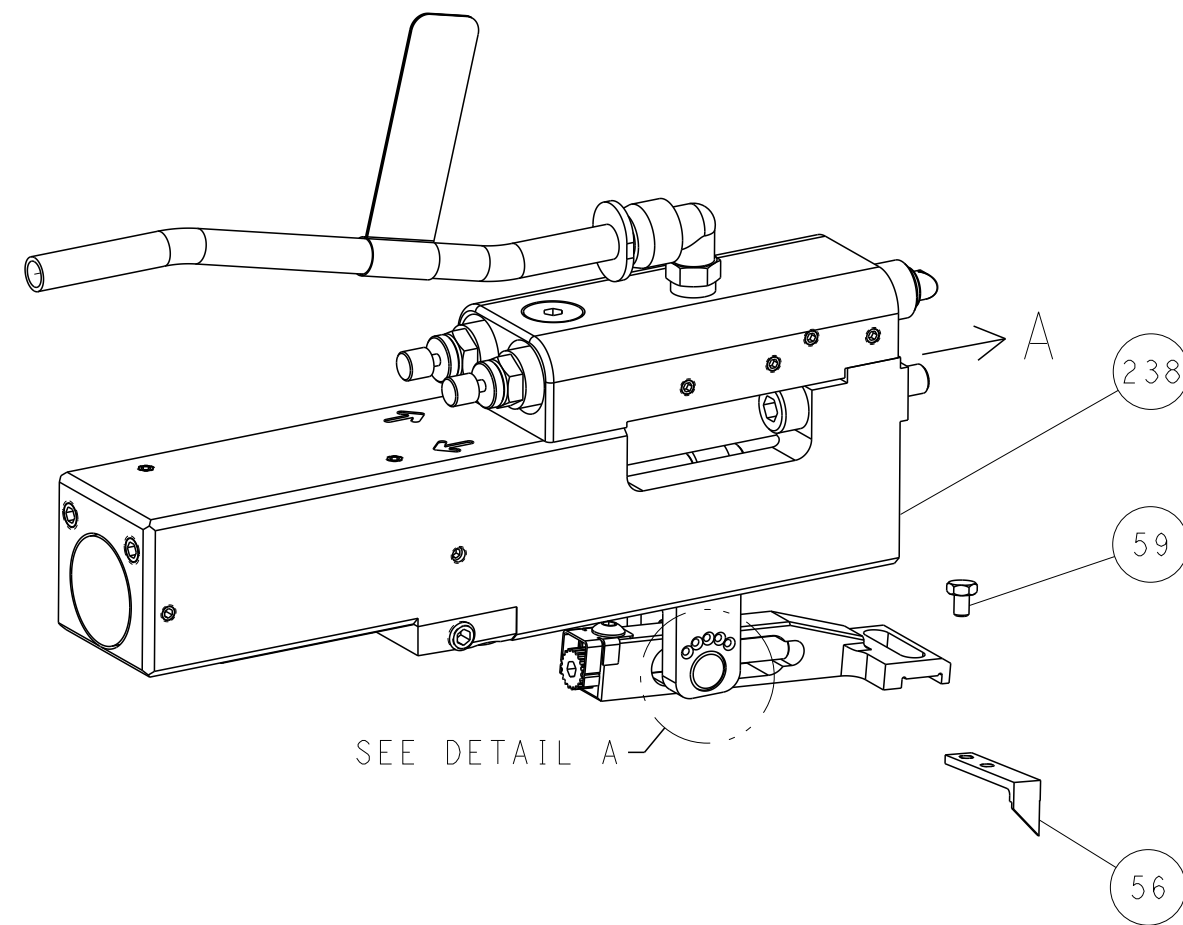
OWN	JH STAKEM	10JAN2012
CHK	G. BAILEY	10JAN2012
APVD	T. ELBIN	10JAN2012

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151553	

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

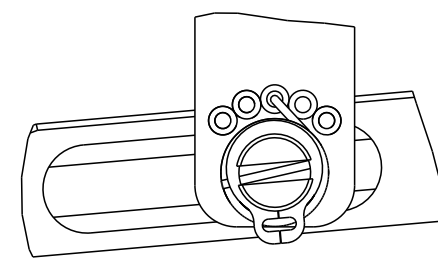
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			

### FEED TYPE PNEUMATIC



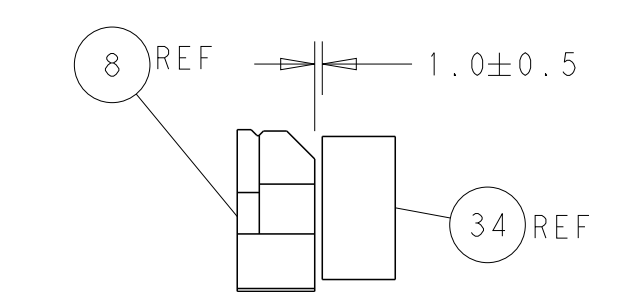
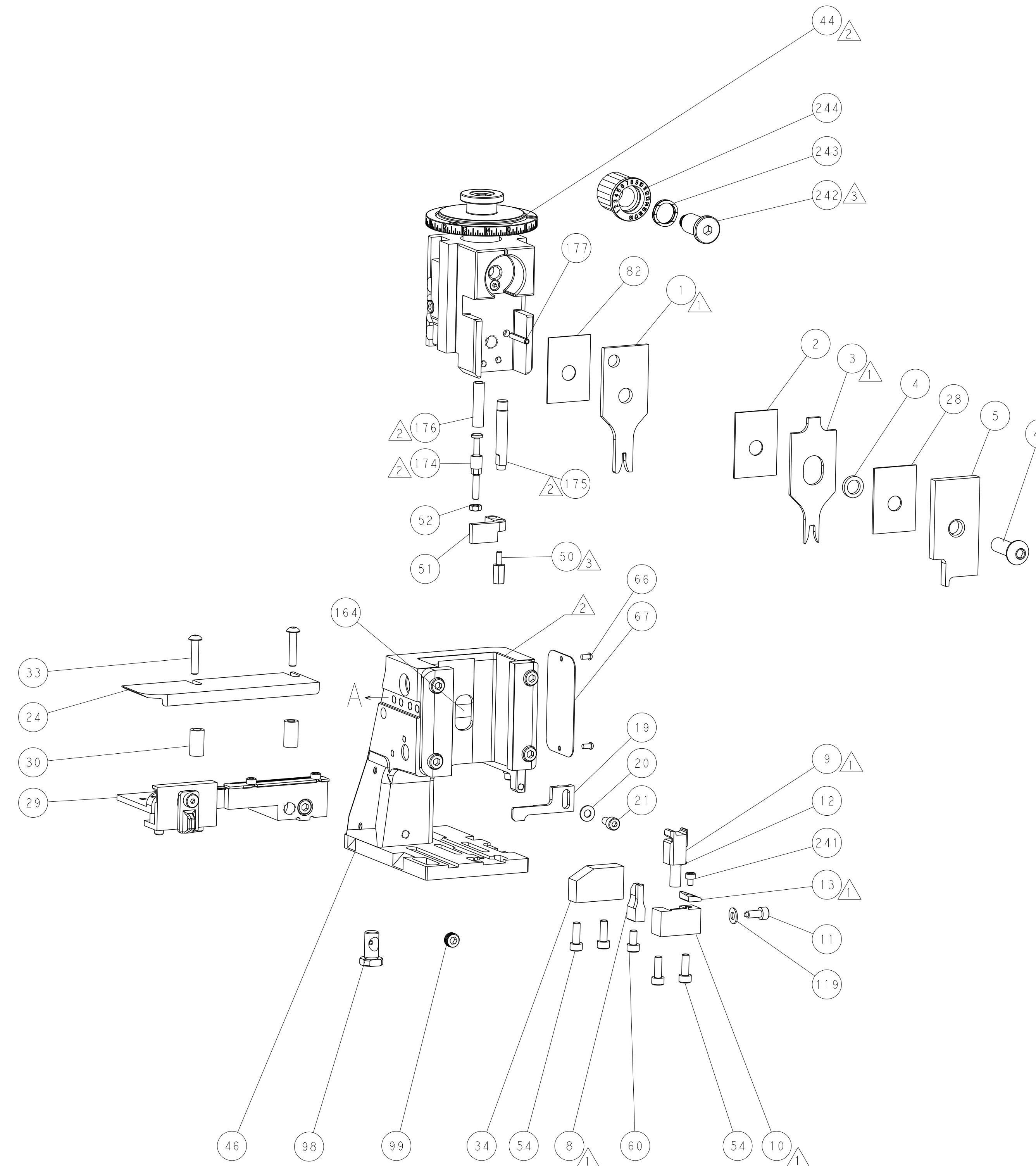
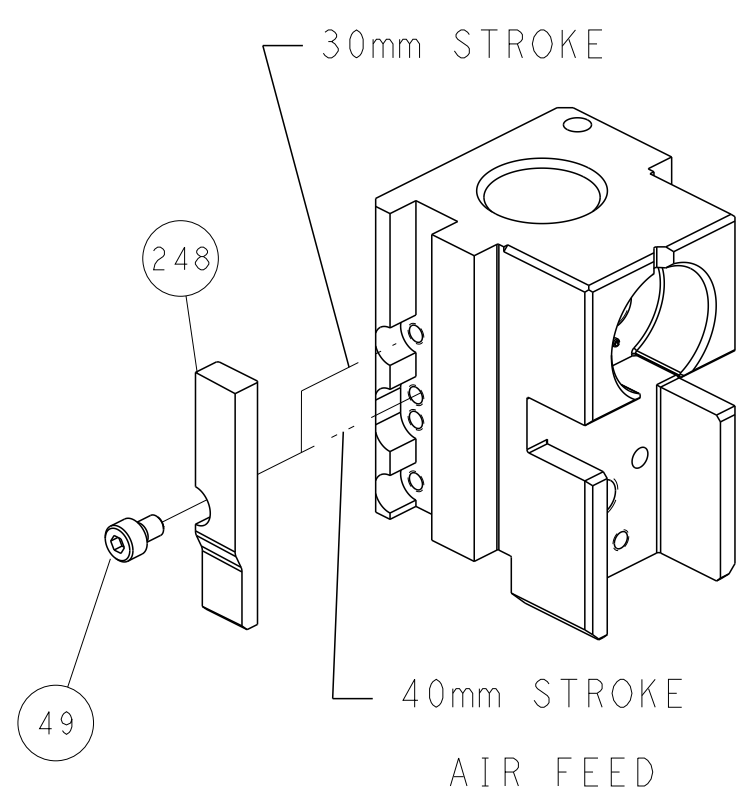
SEE DETAIL A

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

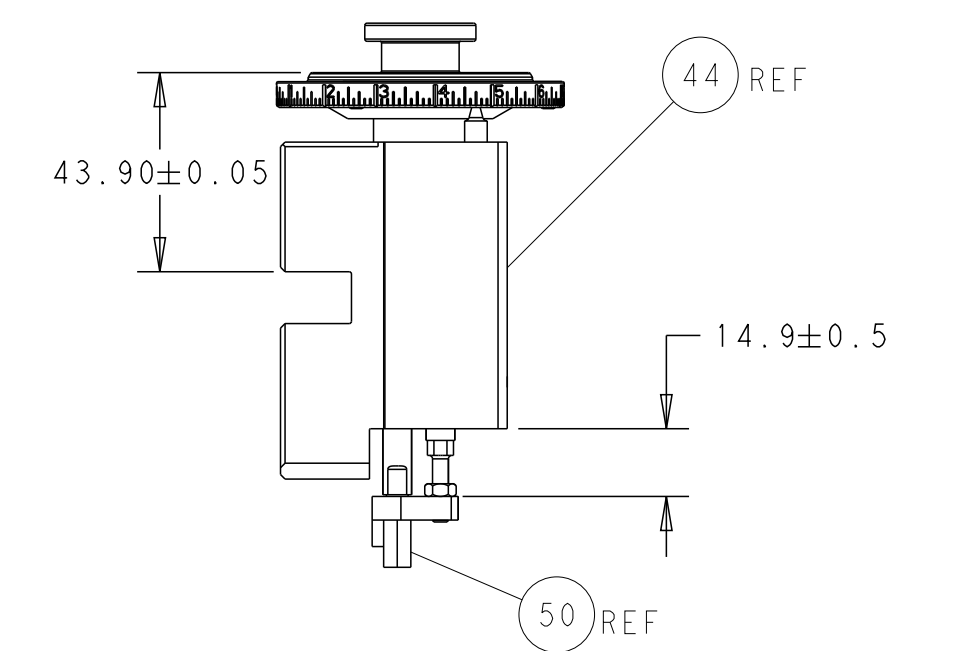


DETAIL A

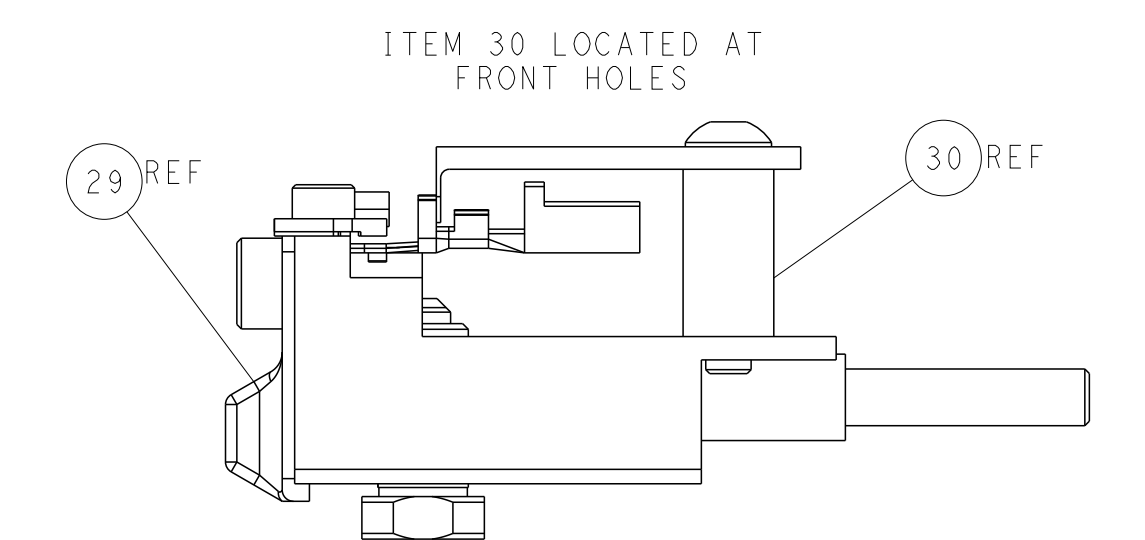
### CAM POSITION



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



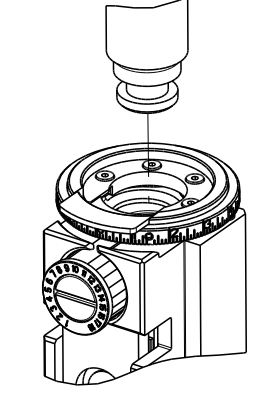
FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

**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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DMN: R. STAKEM 10JAN2012 CHK: G. BAILEY 10JAN2012 APVD: T. ELBIN 10JAN2012	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151553	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: - SCALE: 1:2 SHEET: 2 OF 4 REV: E	Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151553-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151553-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



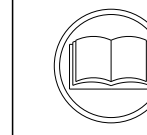
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: POSITIVE LOCK RECEPTACLE		
WIRE STRIP LENGTH 3.80-3.81 mm [1.50-.150 IN]		INSULATION DIAMETER RANGE ∅2.00-3.30 mm [1.079-.130 IN]
TERMINAL APPLICATION SPECIFICATION 114-20036	-	-

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
880646-1	880646-2	880646-5	880646-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm <sup>2</sup>	1.63 +/- 0.05 [1.064 +/- .002]	8.7
0.75mm <sup>2</sup>	1.52 +/- 0.05 [1.060 +/- .002]	9.8
0.50mm <sup>2</sup>	1.45 +/- 0.05 [1.057 +/- .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 ITEM 50. 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. 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	REV	DATE	DESCRIPTION	DATE	BY	APVD
A	66			SEE SHEET 1			

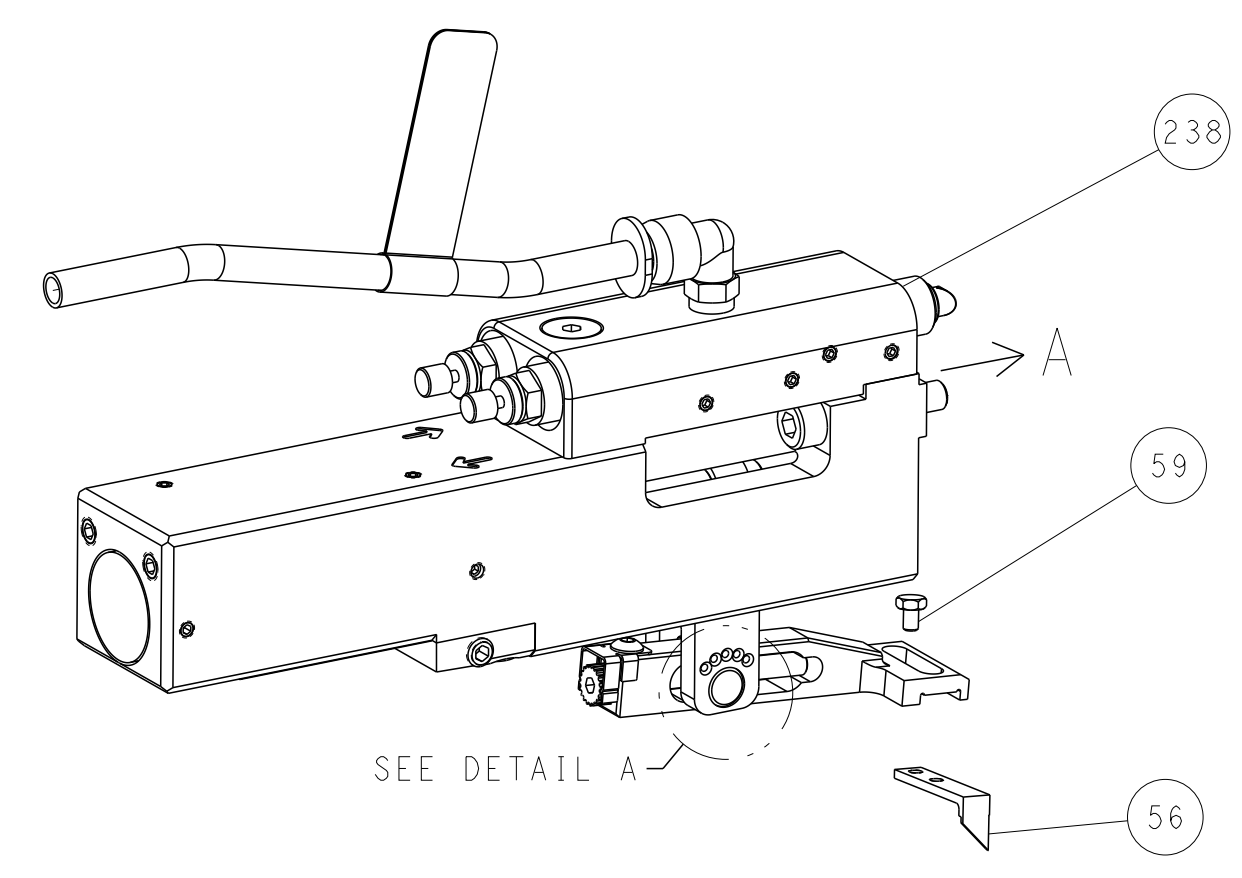
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	2844940-2	AIR FEED MODULE	238	
-	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	455888-5	SPACER, CRIMPER	82	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	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	
-	1	1338685-1	PAWL, FEED	56	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1901681-1	HOLDDOWN, TERMINAL	51	
3	-	1	2-1752354-6	STANDOFF, HOLD-DOWN	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	3-1752356-3	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1320928-2	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	2119533-1	STRIPPER, SIDE FEED	19	
1	-	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	454276-5	FLOATING SHEAR, FRONT	9
1	1	1633920-3	ANVIL, COMBINATION	8	
-	-	-	-	7	
-	-	-	-	6	
-	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	238011-8	BLOCK, CRIMPER SPACER	4	
1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3	
-	1	455888-8	SPACER, CRIMPER	2	
1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1	
-	-	-	-	-	

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD	DATE	DESCRIPTION	ITEM NO
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	T. ELBIN	10JAN2012	TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL		APVD	DATE	NAME	
		G. BAILEY	10JAN2012	Ocean Side Feed Applicator	
FINISH		APVD	DATE	SIZE	
				00779	
WEIGHT		APVD	DATE	SCALE	
				1:2	
Customer Accessible Production Drawing		APVD	DATE	SHEET	
				3 of 4	
				REV	
				E	

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

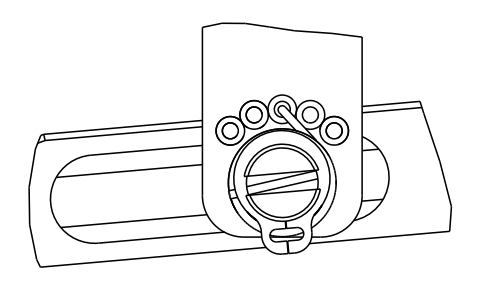
### FEED TYPE

#### PNEUMATIC



SEE DETAIL A

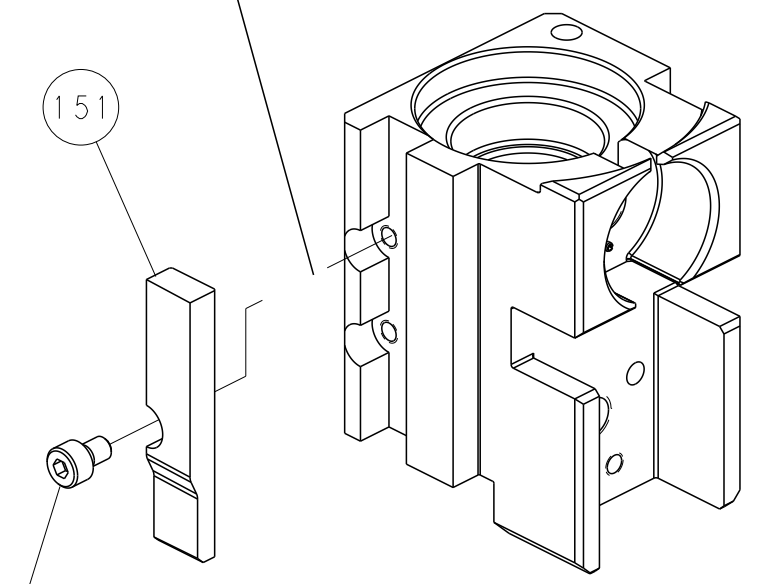
#### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



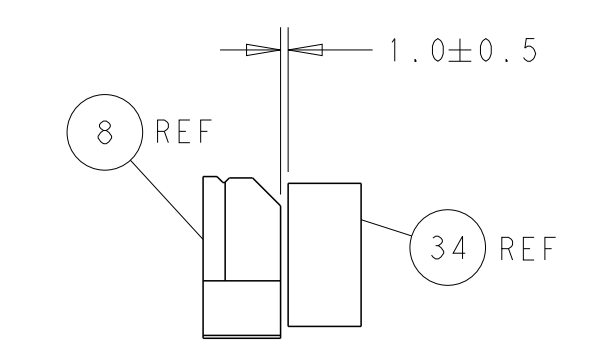
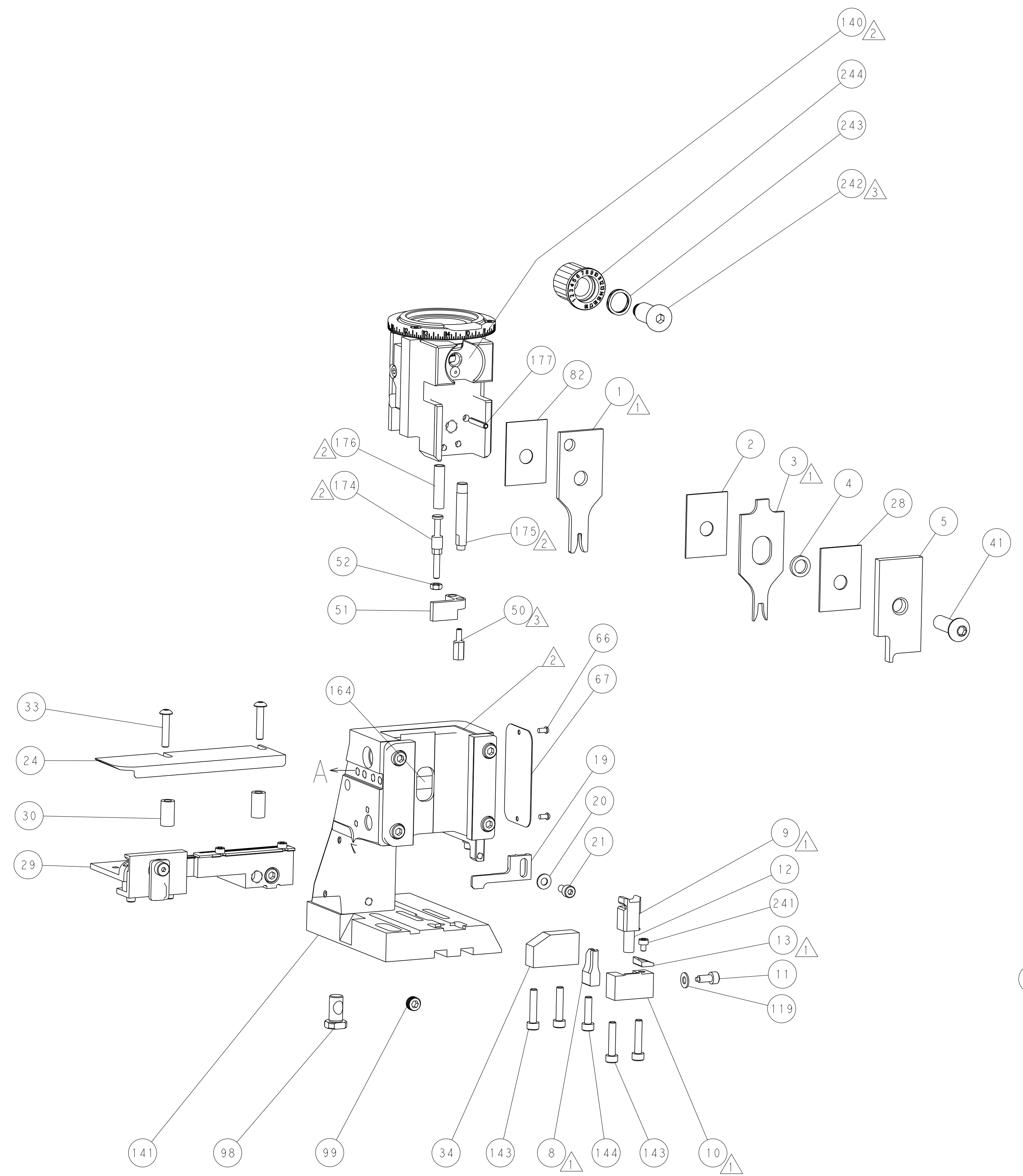
DETAIL A

### CAM POSITION

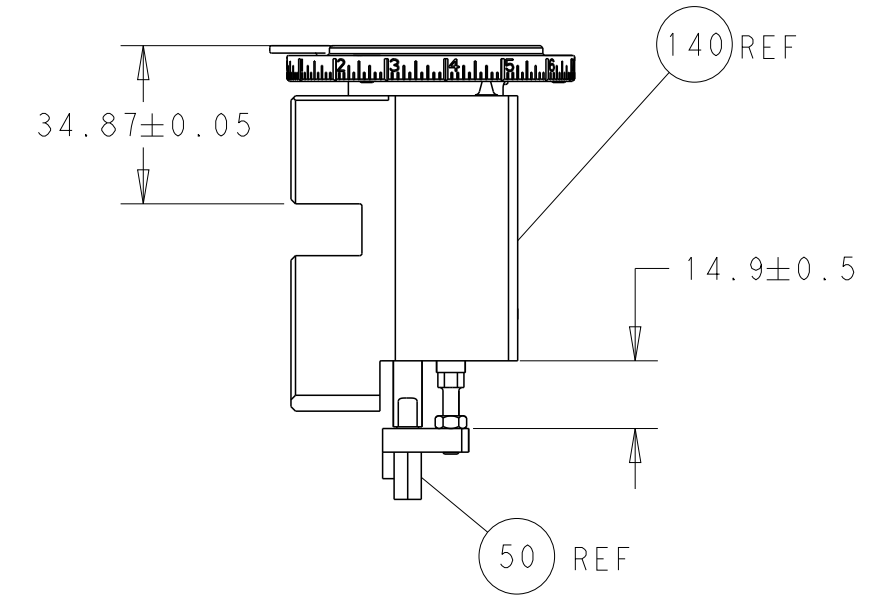
30mm STROKE



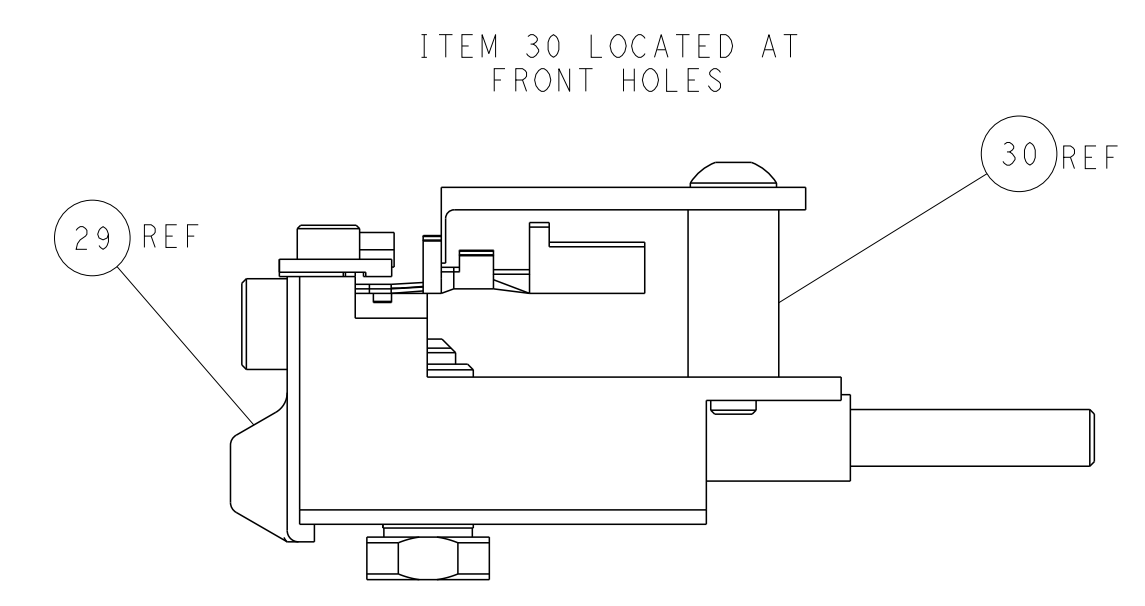
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151553 SHEET 4 OF 4 REV E