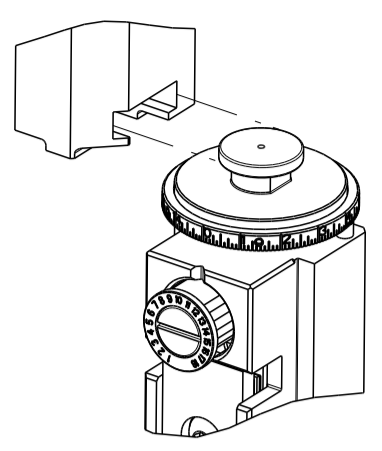


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151927-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151927-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151927-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.20 mm [.165]	F
INSUL	6.20 mm [.244]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 8mm NGI TAB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.50-7.50 mm [.256-.295 IN]		∅	
TERMINAL APPLICATION SPECIFICATION	114-15112	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
1544332-1			1544316-1	3.35-4.30

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.95+/-0.05 [.116+/- .002]	5.3
5.00mm2	2.80+/-0.05 [.110+/- .002]	7.2
4.00mm2	2.65+/-0.05 [.104+/- .002]	8.6
3.00mm2	2.50+/-0.05 [.098+/- .002]	10.2

- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED..
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.
- CUT TO LENGTH AT ASSEMBLY.

**\*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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-18-018046	16NOV2018	TB	CT
		C		ECR-19-008843	05JUN2019	FJ	TE
		D		ECR-19-012934	16AUG2019	FJ	TE
		E		ECR-22-130189	21FEB2022	TB	RK

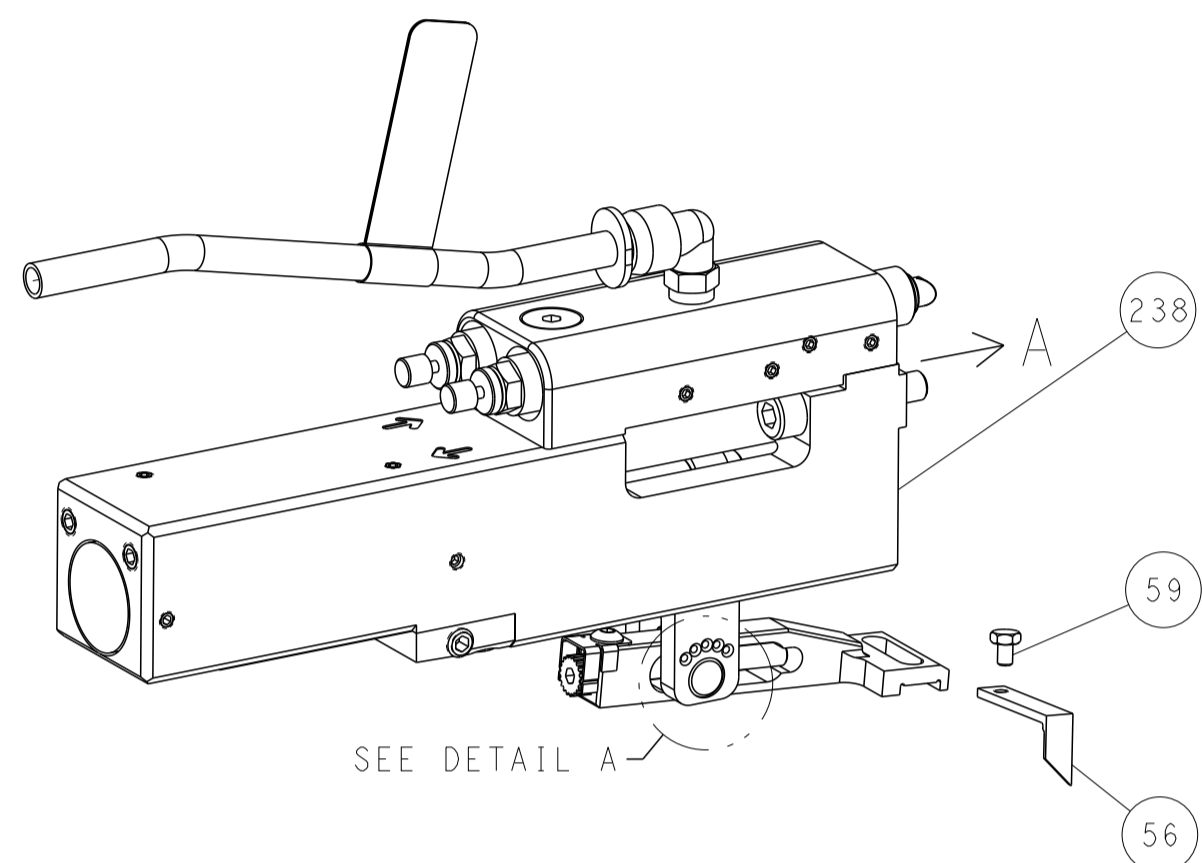
-	1	1	1803078-1	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-2	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	455888-6	SPACER, CRIMPER	82	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1803096-1	EXTENSION PLATE	78	
-	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	985575-5	SCR, FLT SKT HD CAP M3 X 16.0	57	
-	1	1	1-1338683-1	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	690753-2	SPACER, TONKER	50	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1-1803583-7	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1-1752356-9	SUPPORT, TERMINAL	34	
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33	
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-3	SPACER, CRIMPER	28	
-	2	2	22281-8	SPRING, COMPRESSION	27	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-4	STRIP GUIDE	24	
-	1	1	1-690438-0	FRONT STRIP GUIDE	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	1803013-1	STRIPPER, SIDE FEED	18	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-3	STOP, SHEAR	11	
-	1	1	1-2119805-2	SHEAR HOLDER, FRONT	10	
-	1	1	1-318059-0	FLOATING SHEAR, FRONT	9	
-	1	2	1	4-1633927-9	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1803080-1	DEPRESSOR, SHEAR	5	
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	1	1803111-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	2-455888-2	SPACER, CRIMPER	2	
-	1	2	1	4-1633730-8	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH			Customer Accessible Production Drawing	SCALE 1:2
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	

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

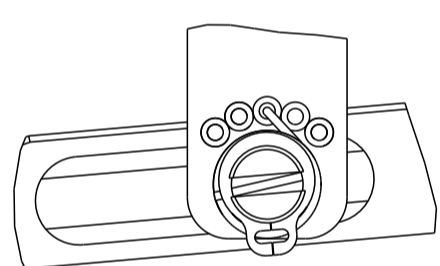
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-

### FEED TYPE PNEUMATIC



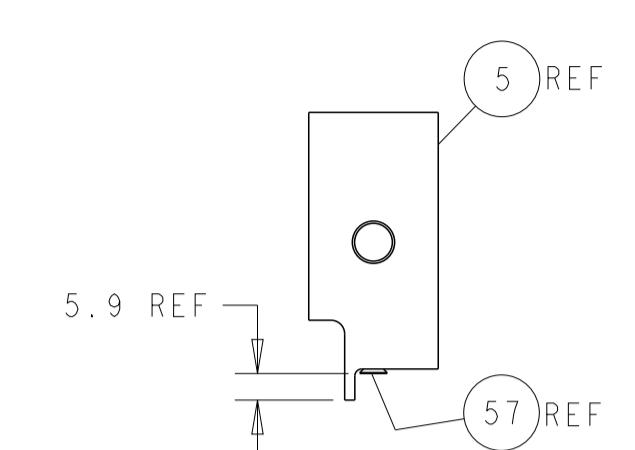
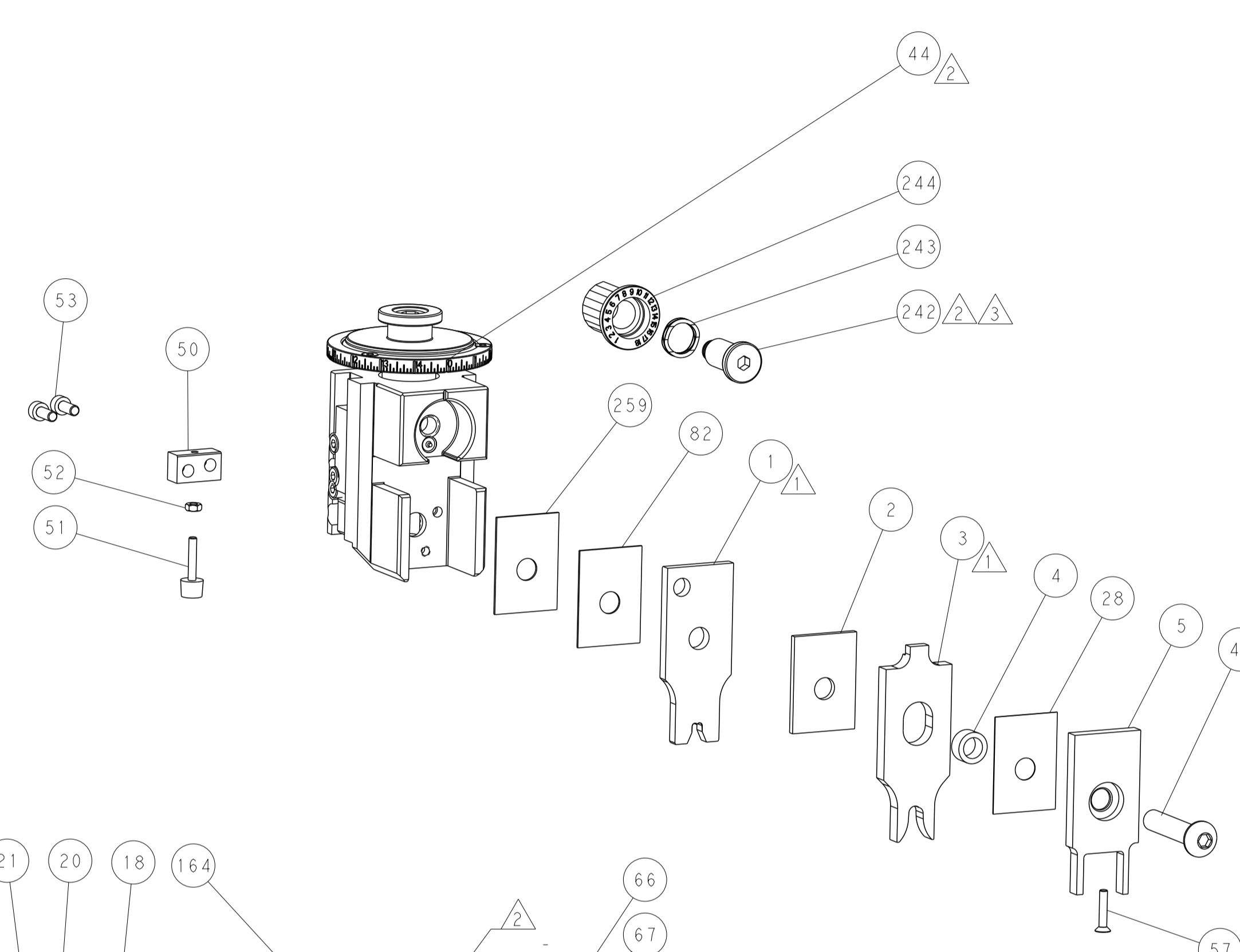
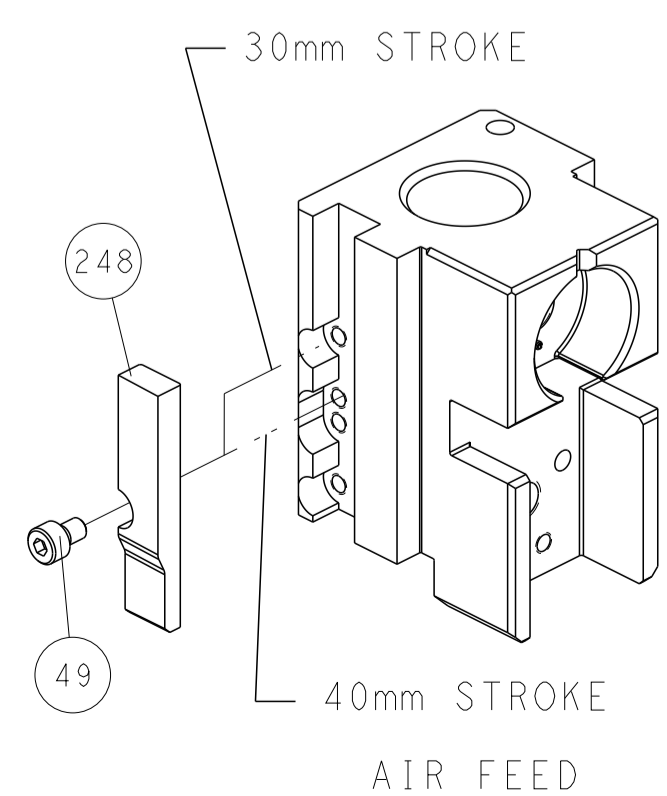
SEE DETAIL A

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

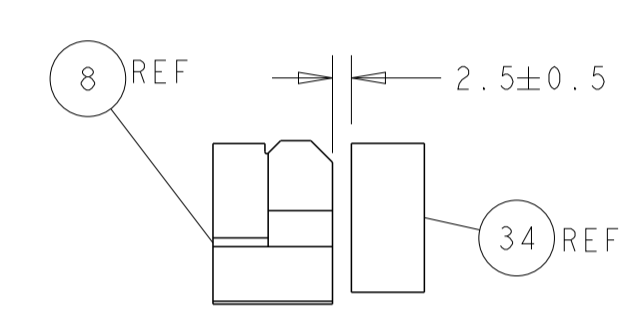


DETAIL A

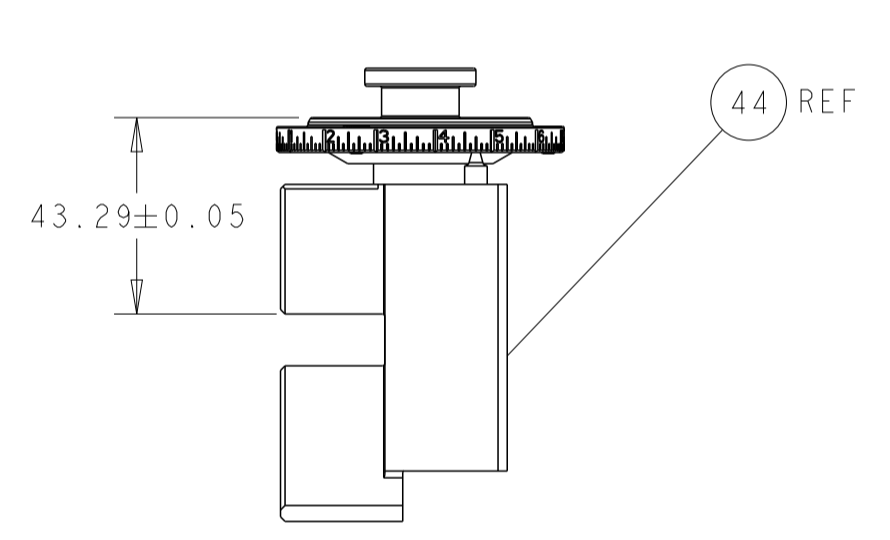
### CAM POSITION



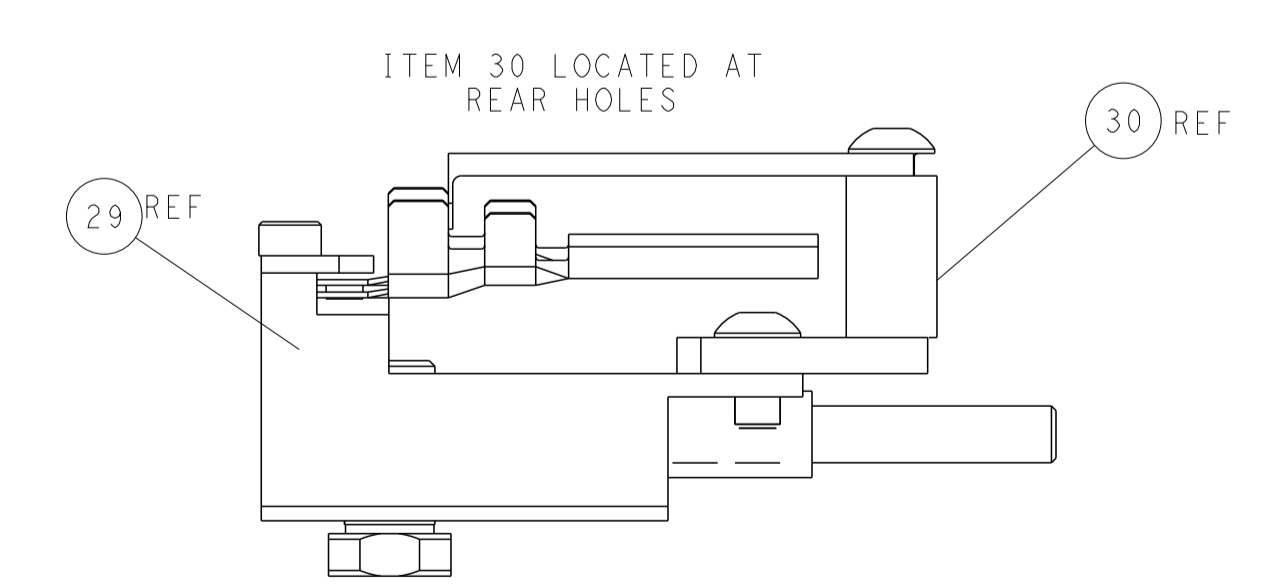
SHEAR DEPRESSOR DETAIL



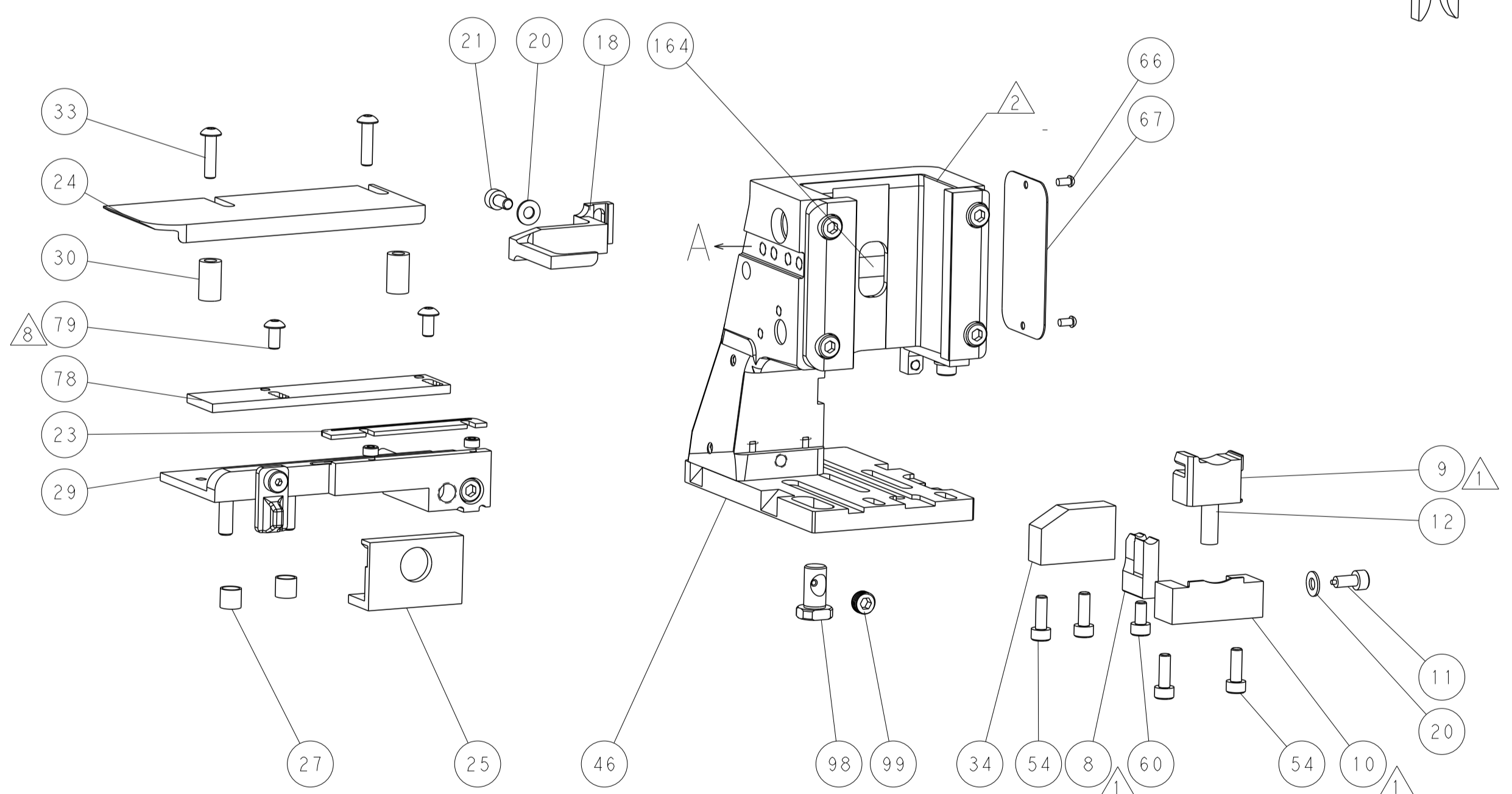
TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

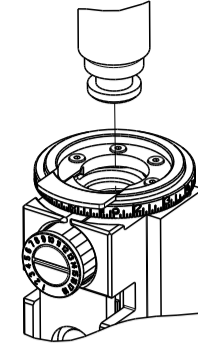


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 13JUN2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD: M. CLIFFORD 13JUN2013		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 2 OF 4		REV E	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151927-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151927-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.20 mm [1.65]	F
INSUL	6.20 mm [2.44]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: 8mm NGI TAB	
WIRE STRIP LENGTH 6.50-7.50 mm [2.56-.295 IN]	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION 114-15112	

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
1544332-1			1544316-1	3.35-4.30

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.95+/-0.05 [1.16+/-0.02]	5.3
5.00mm2	2.80+/-0.05 [1.10+/-0.02]	7.2
4.00mm2	2.65+/-0.05 [1.04+/-0.02]	8.6
3.00mm2	2.50+/-0.05 [0.98+/-0.02]	10.2

- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.
- CUT TO LENGTH AT ASSEMBLY.

**\*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	REV	DATE	BY	APPV
A	66				

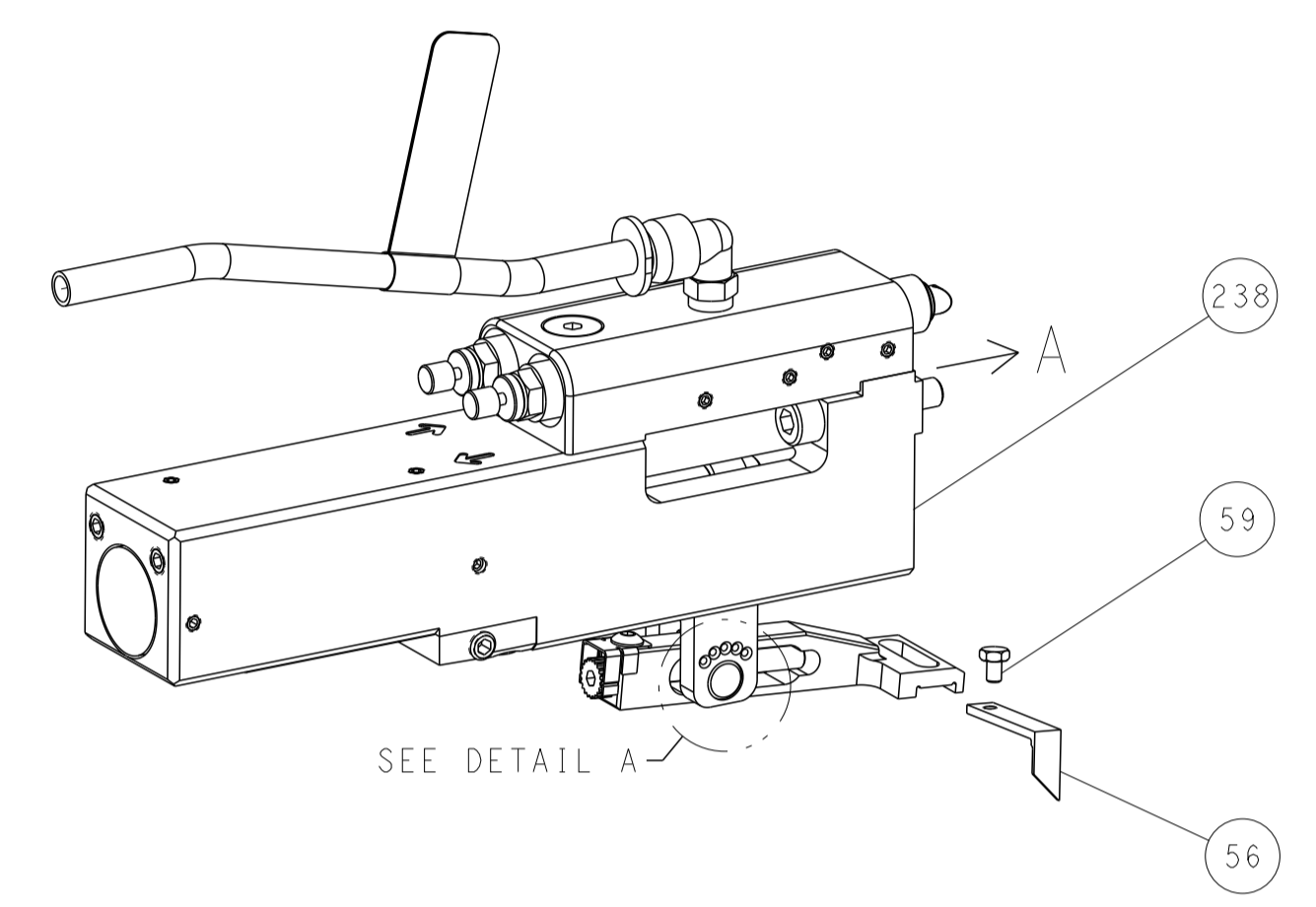
REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	1	1803078-1		SPACER, PRECISION			259
-	1	2119082-6		CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	2079764-1		WASHER, WAVE SPRING, CREST-TO-CREST			243
3	-	2119083-1		RETAINER, INSULATION DIAL			242
-	1	2844940-2		AIR FEED MODULE			238
-	REF	994970-2		COUNTER, 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	1-1803583-8		APPLICATOR BASIC ASSEMBLY, SF			141
-	1	1803516-2		RAM ASSEMBLY, SF PACIFIC			140
-	1	2844908-1		SCREW, LOCKING			99
-	1	2844907-1		POST, LOCKING			98
-	1	455888-6		SPACER, CRIMPER			82
8	-	2079383-4		SCR, BHSC, RoHS (M4 X 8)			79
-	1	1803096-1		EXTENSION PLATE			78
-	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
7	-	985575-5		SCR, FLT SKT HD CAP M3 X 16.0			57
-	1	1-1338683-1		FEED PAWL			56
-	2	1-2168083-0		SCR, SKT HD CAP, RoHS, M4 X 10			53
-	1	5018030-1		NUT, HEX, REG, RoHS, M3			52
-	1	811242-5		BUMPER, HOLD DOWN			51
-	1	690753-2		SPACER, TONKER			50
-	1	18023-9		SCR, SKT HD CAP M4 X 6.0			49
-	1	1803602-2		SCR, BHSC, RoHS (M8 X 40)			41
-	1	1-1752356-9		SUPPORT, TERMINAL			34
-	2	2079383-8		SCR, BHSC, RoHS (M4 X 16)			33
-	2	2-2844962-6		SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	2844992-5		ASSEMBLY, STRIP GUIDE			29
-	1	455888-3		SPACER, CRIMPER			28
-	2	22281-8		SPRING, COMPRESSION			27
-	1	240792-1		DRAG, TERMINAL			25
-	1	1320928-4		STRIP GUIDE			24
-	1	1-690438-0		FRONT STRIP GUIDE			23
-	1	2168083-2		SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	2	1-18028-2		WASHER, FLAT, REG M4			20
-	1	1803013-1		STRIPPER, SIDE FEED			18
-	1	3-22280-3		SPRING, COMPRESSION			12
-	1	1-356885-3		STOP, SHEAR			11
1	-	1-2119805-2		SHEAR HOLDER, FRONT			10
1	-	1-318059-0		FLOATING SHEAR, FRONT			9
1	1	4-1633927-9		ANVIL, COMBINATION			8
-	-	-		-			7
-	-	-		-			6
-	1	1803080-1		DEPRESSOR, SHEAR			5
-	1	4-238011-4		BLOCK, CRIMPER SPACER			4
1	1	1803111-1		CRIMPER, INSULATION OVERLAP PREMIUM			3
-	1	2-455888-2		SPACER, CRIMPER			2
1	1	4-1633730-8		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)

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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151927 RESTRICTED TO: -
MATERIAL: -		WEIGHT: -	SCALE: 1:2 SHEET: 3 OF 4 REV: E

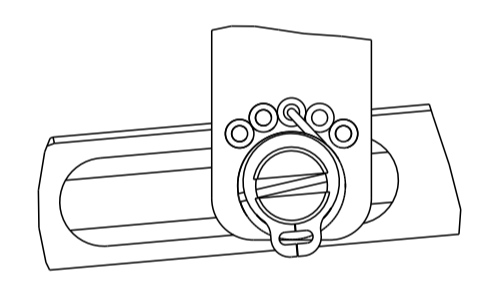
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

### FEED TYPE PNEUMATIC



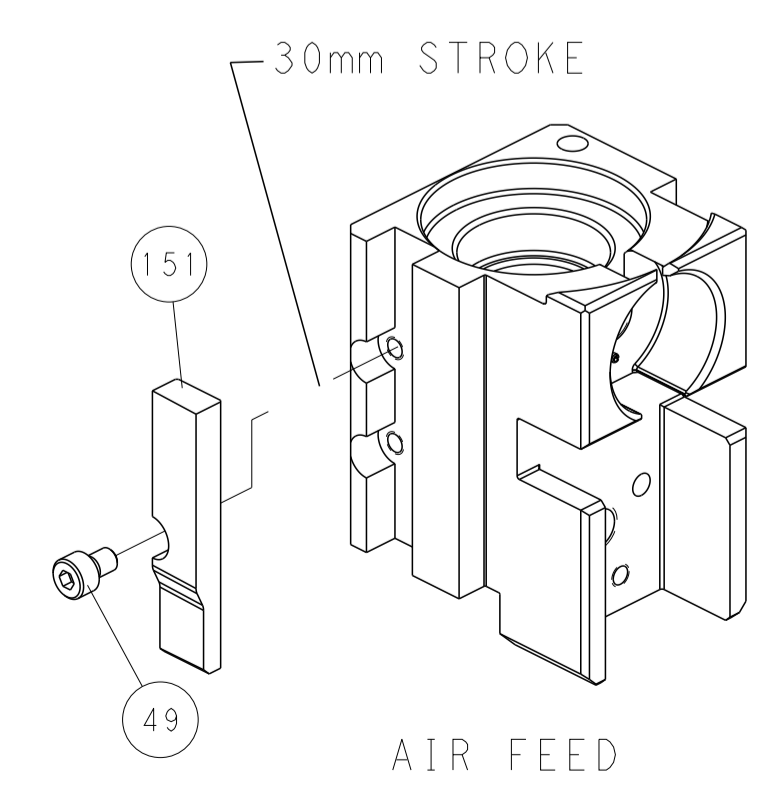
SEE DETAIL A

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

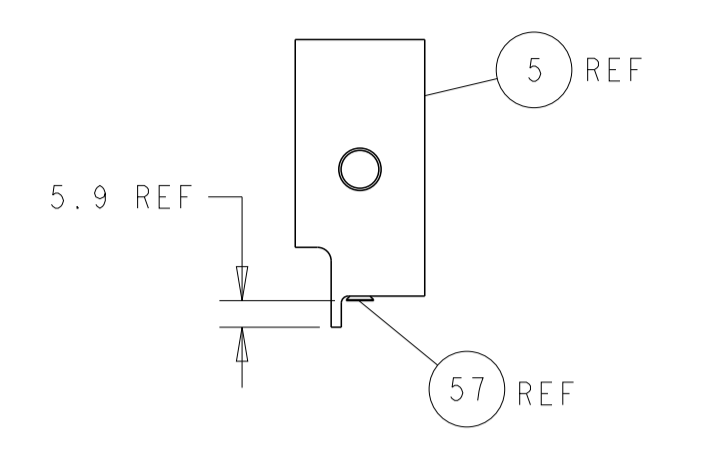
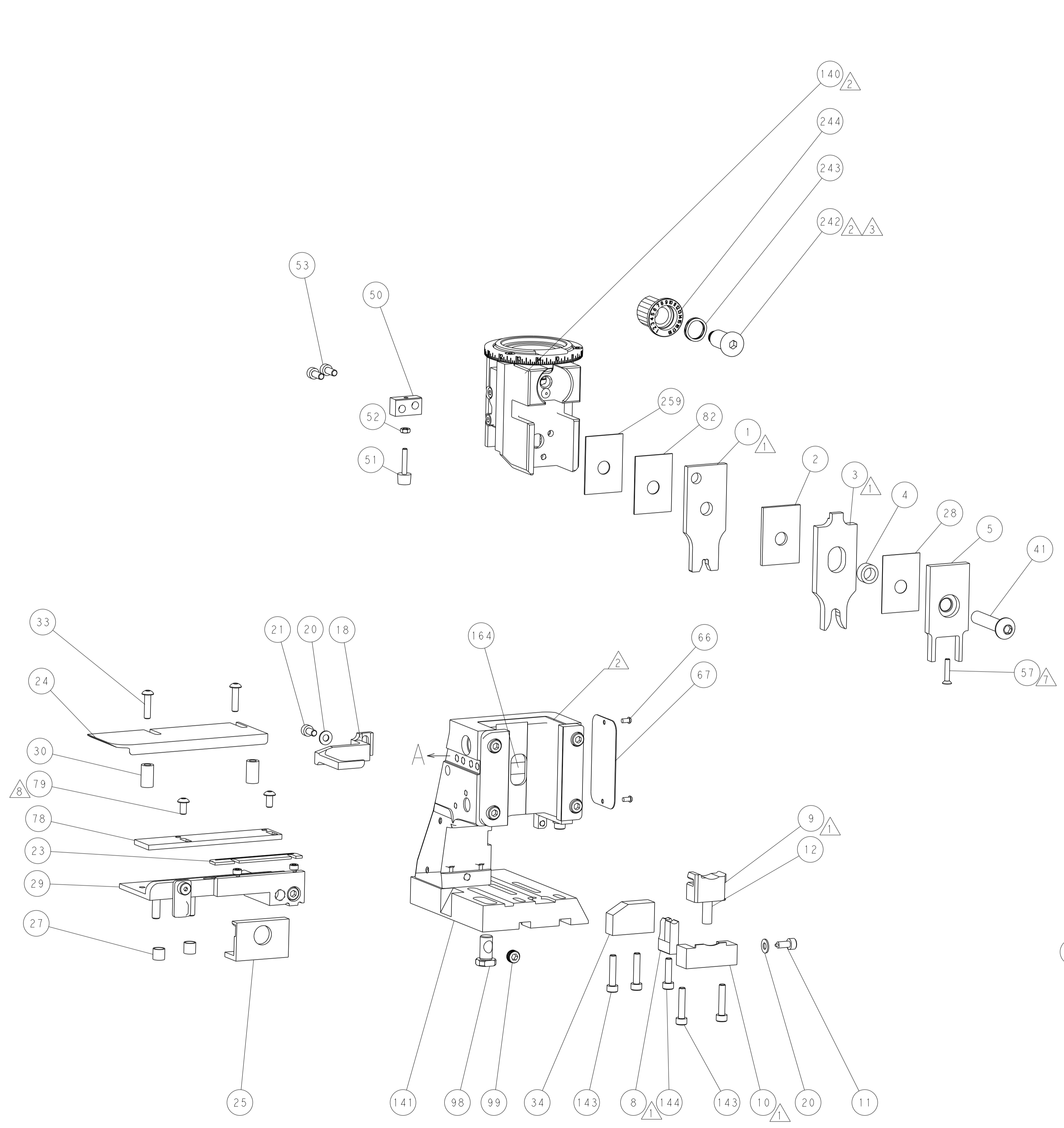


DETAIL A

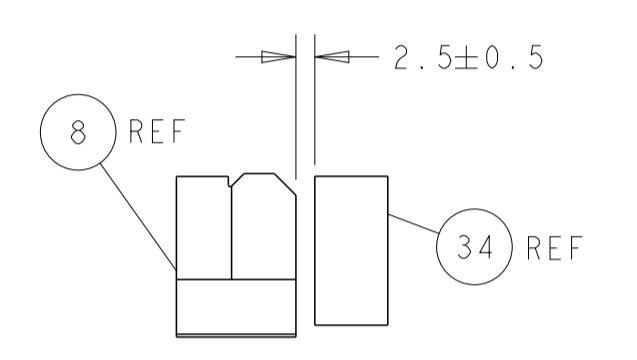
### CAM POSITION



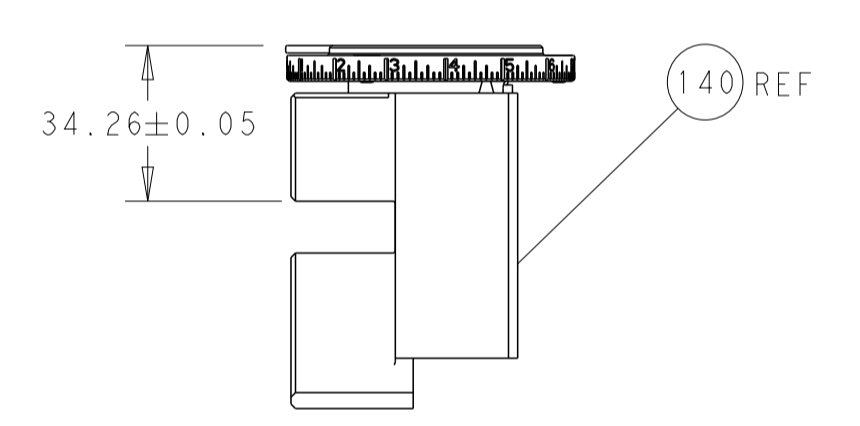
AIR FEED



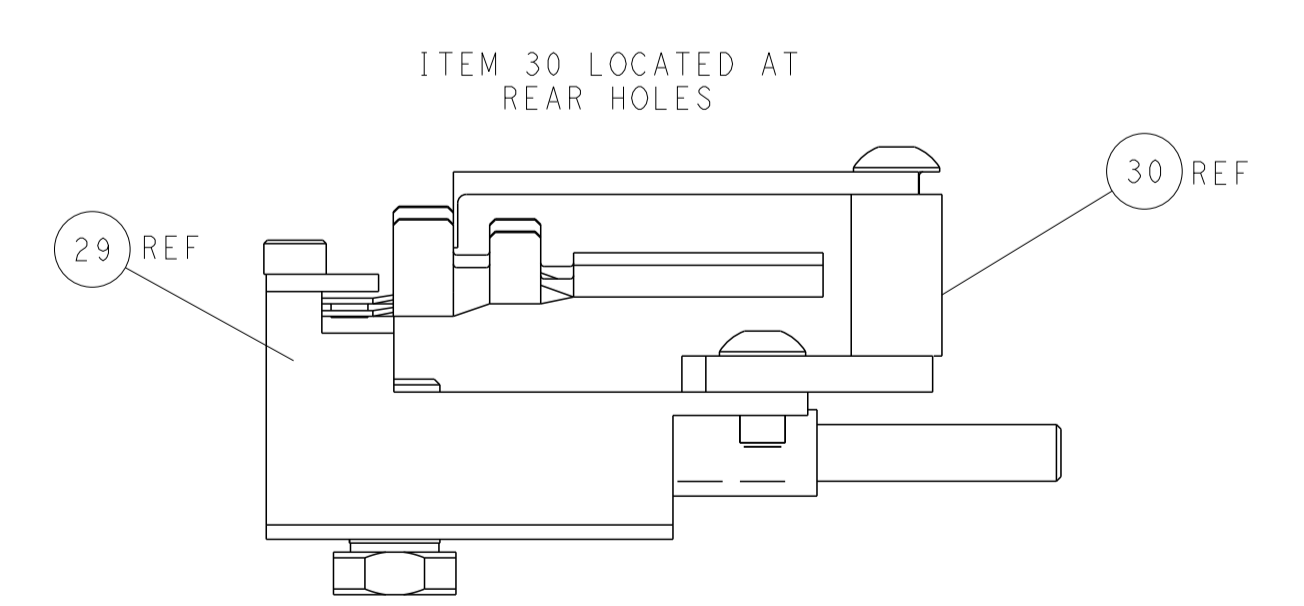
SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 13JUN2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD: M. CLIFFORD 13JUN2013		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 4 OF 4		REV E	