

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151540-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151540-2	P	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151540-2	P	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS $\Delta$
7-2151540-1	P	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151540-2	P	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151540-7	J	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: SIEMENS TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.10-4.70 mm [.161-.185 IN]	$\varnothing$ 1.10-1.65 mm [.043-.065 IN]		
TERMINAL APPLICATION SPECIFICATION	114-13060		
TERMINALS APPLIED $\Delta$			
TE TERMINAL	SIEMENS TERMINAL	TE TERMINAL	SIEMENS TERMINAL
1393364-1	V23540X7000Y10	1-1438299-0	
1393367-1	V23540X7000Y11	1393364-2	
1438299-2	V23540X7000Y31	1393367-2	
1438299-1	V23540X7000Y30		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm <sup>2</sup>	0.97 +/- 0.04 [.038 +/- .002]	7.7
22 AWG	0.95 +/- 0.04 [.037 +/- .002]	7.9
0.22mm <sup>2</sup>	0.89 +/- 0.04 [.035 +/- .002]	8.7



- $\Delta$  1 RECOMMENDED SPARE PARTS
- $\Delta$  2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- $\Delta$  3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- $\Delta$  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.
- $\Delta$  5 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- $\Delta$  7 TERMINAL LUBRICANT IS RECOMMENDED.

**\*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)

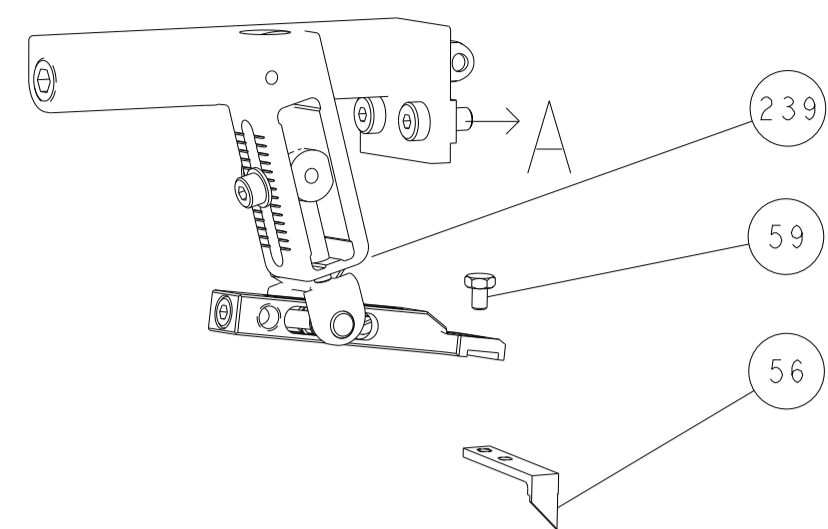
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N		ECR-20-010644					27JUL2020	MEH	TE
P		ECR-20-016565					20NOV2020	FJ	TE
P1		ECR-21-007039					27JUL2021	FJ	CT

-	-	-	1	-	-	2844950-1	AIR FEED MODULE		290
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE		286
-	1	1	1	1	1	1633782-2	FENCE		267
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED		248
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	1	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0		241
-	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	-	1	-	-	1	2844940-1	AIR FEED MODULE		238
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC		164
-	1	1	1	1	1	1-22281-8	SPRING, COMPRESSION		121
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4		119
-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	1	1	1	1	2844908-1	SCREW, LOCKING		99
-	1	1	1	1	1	2844907-1	POST, LOCKING		98
-	1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65		93
-	1	1	1	1	1	455888-4	SPACER, CRIMPER		82
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE		71
-	4	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		69
-	1	1	1	1	1	2-690438-2	FRONT STRIP GUIDE		68
-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0		61
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		60
-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	1	1	1	1	1	1338685-1	PAWL, FEED		56
-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		54
-	2	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14		53
-	1	1	1	1	1	1-1463053-0	HOLDER, TERMINAL		51
-	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED		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	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF		46
-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC		44
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	1	1	1	1	1	1-1752356-8	SUPPORT, TERMINAL		34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	1	1	1	1	2844938-5	PLATE, STRIP GUIDE		29
-	2	2	2	2	2	22281-8	SPRING, COMPRESSION		27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE		26
-	1	1	1	1	1	240792-2	DRAG, TERMINAL		25
-	1	1	1	1	1	1320928-6	STRIP GUIDE		24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED		19
-	1	1	1	1	1	6-240641-7	SPACER		16
-	1	1	1	1	1	2119806-1	INSERT, SHEAR		13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR		11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	1	1	1	1	1-318707-4	FLOATING SHEAR, FRONT		9
-	1	2	2	1	1	1-1333201-9	ANVIL, COMBINATION		8
-	-	-	-	-	-	-	-		7
-	-	-	-	-	-	-	-		6
-	1	1	1	1	1	2119757-2	DEPRESSOR, SHEAR		5
-	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER		4
-	1	2	2	1	1	3-1633966-0	CRIMPER, INSULATION O		3
-	1	1	1	1	1	455888-7	SPACER, CRIMPER		2
-	1	2	2	1	1	3-1803224-5	CRIMPER, WIRE		1

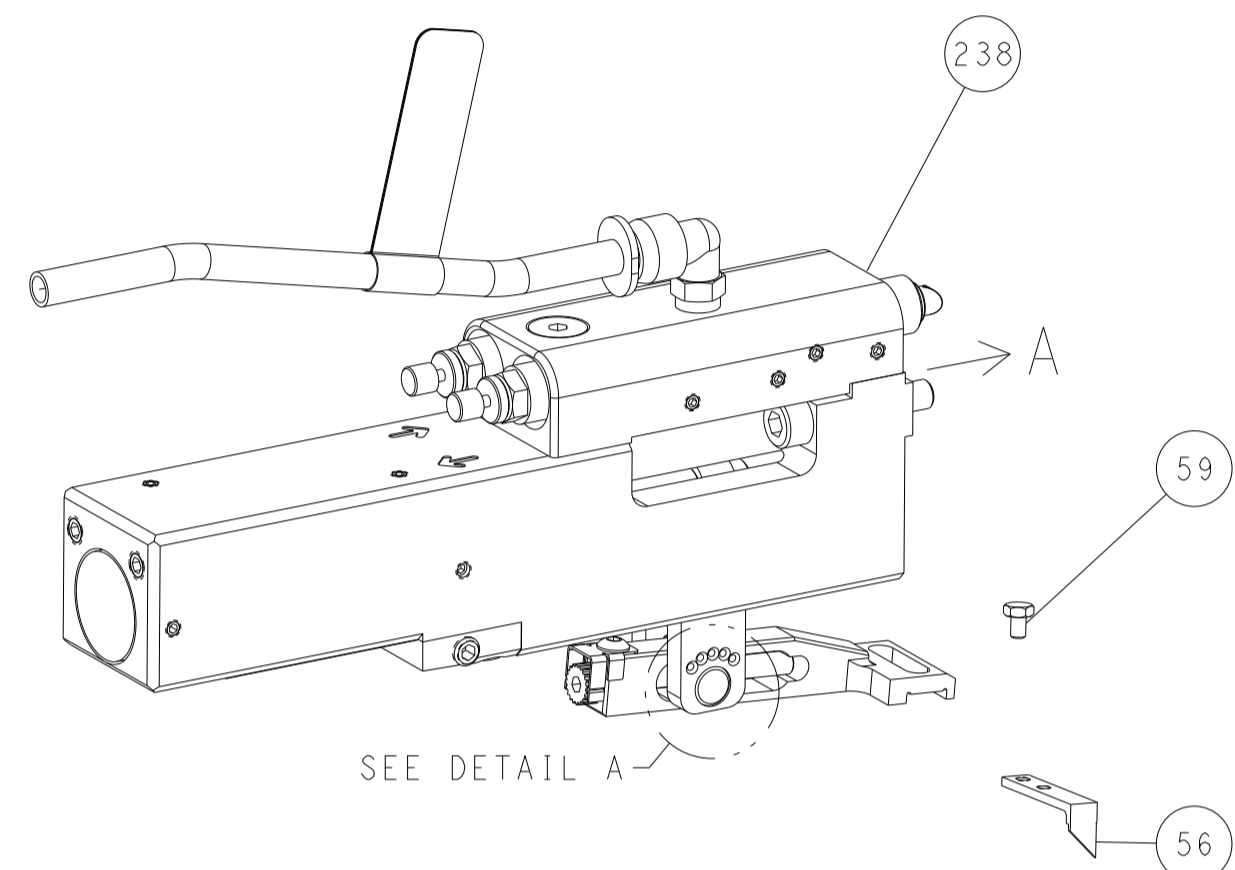
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	1 PLC	±													
	2 PLC	±													
	3 PLC	±													
	4 PLC	±													
	ANGLES	±													

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

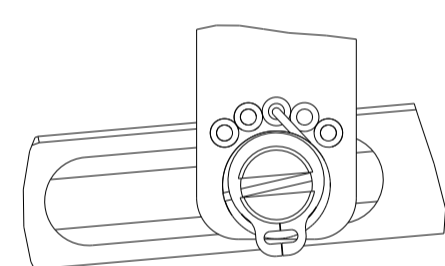
# FEED TYPE MECHANICAL



# PNEUMATIC

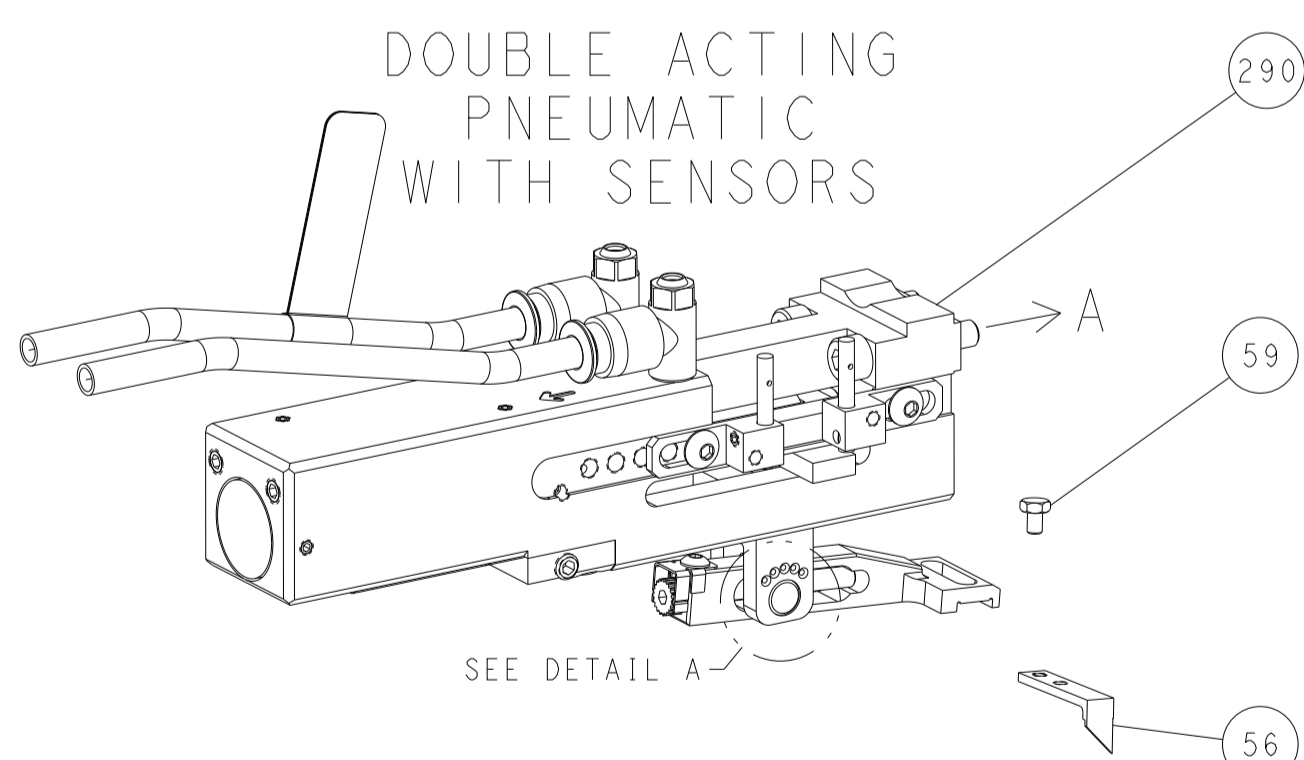


# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

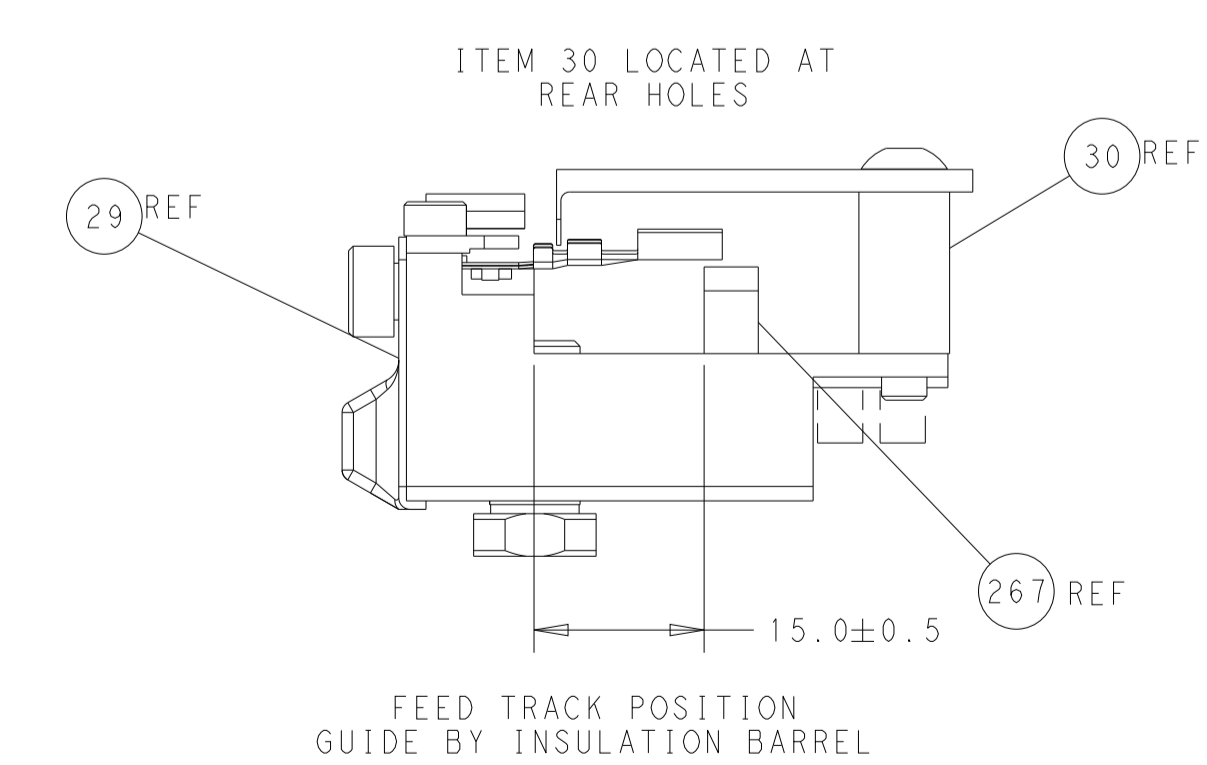
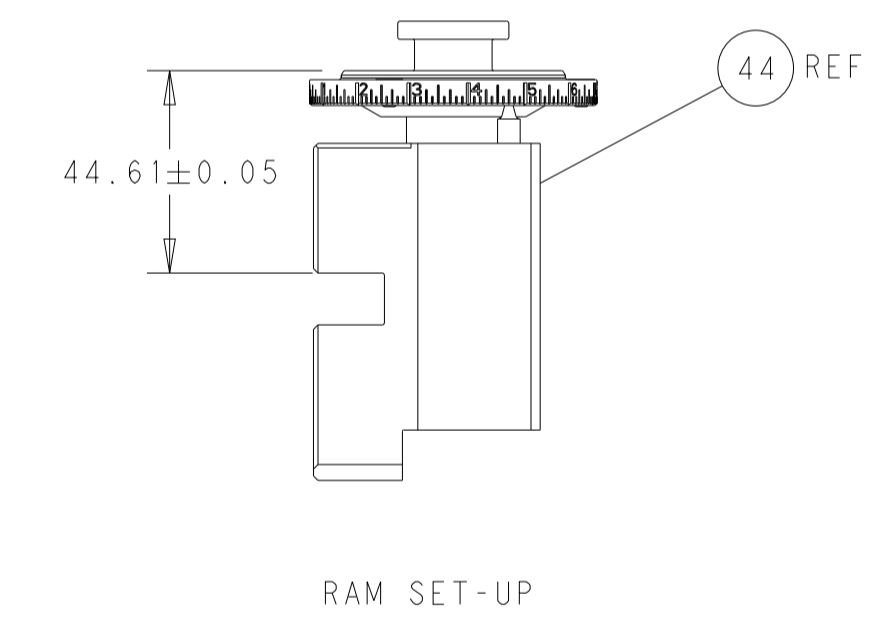
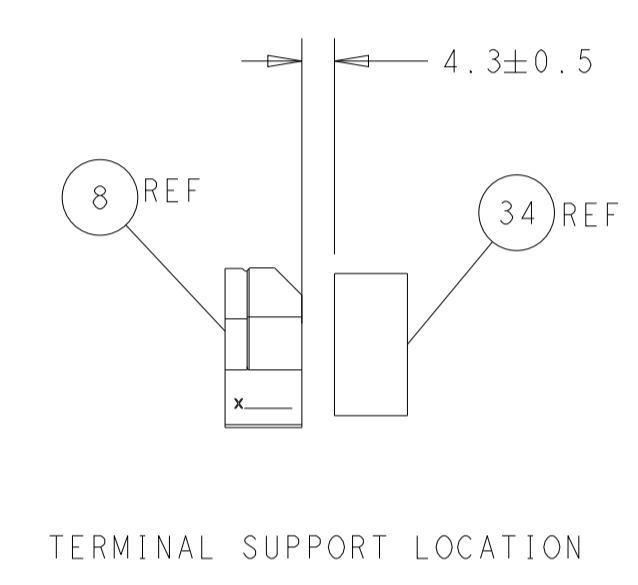
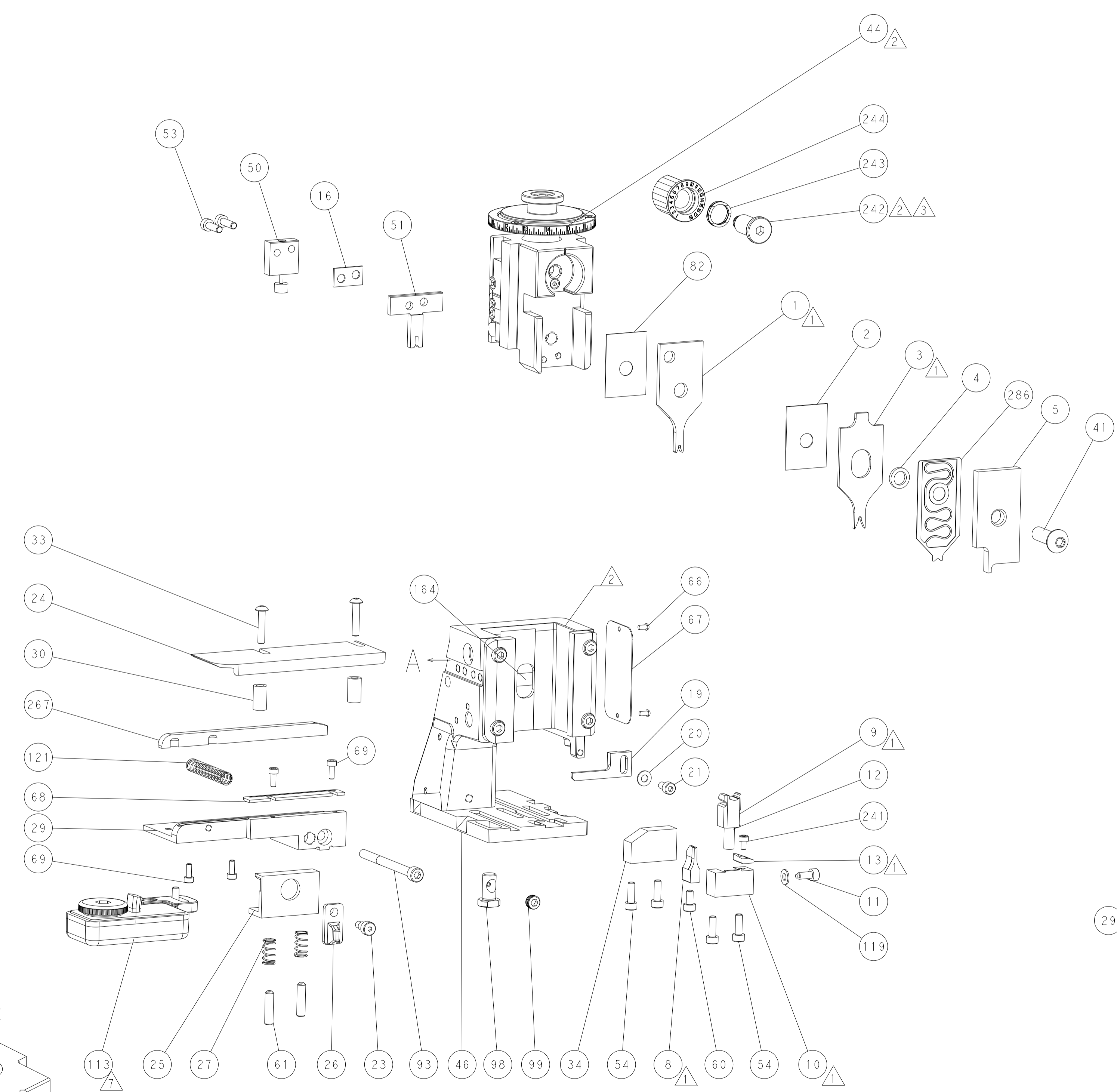
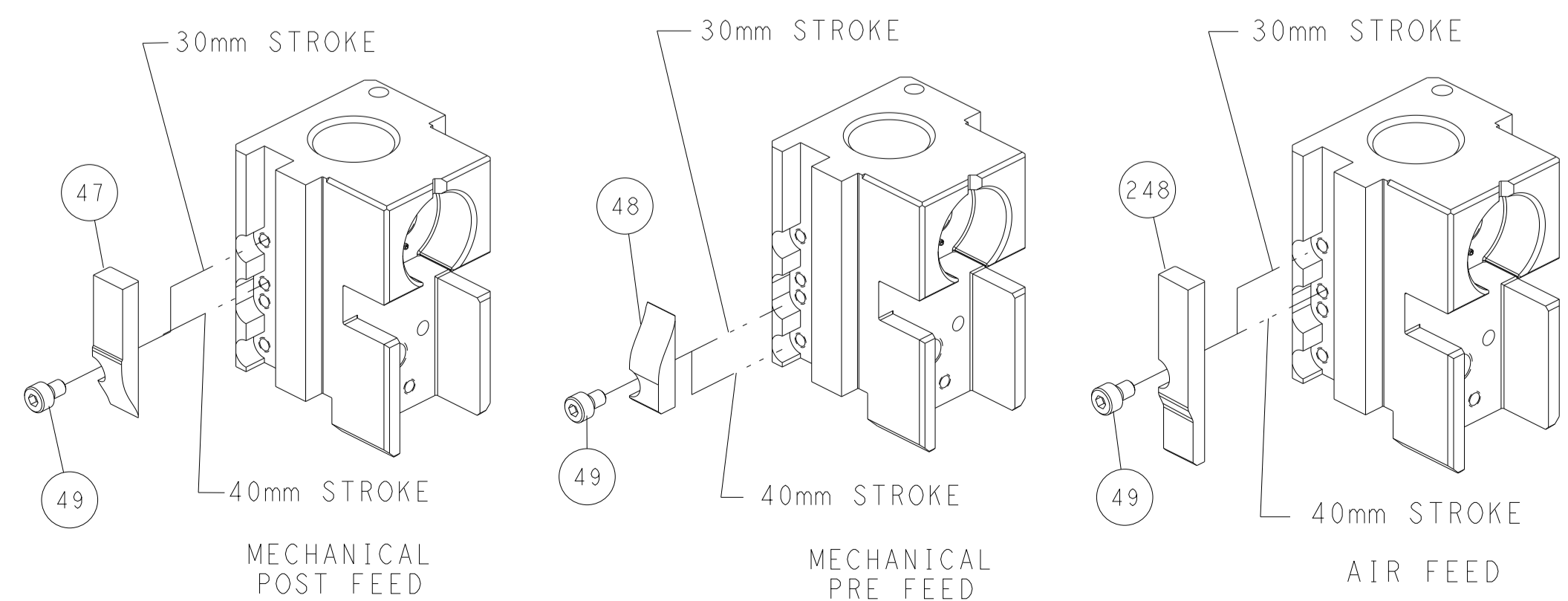


DETAIL A

# DOUBLE ACTING PNEUMATIC WITH SENSORS



# CAM POSITIONS



**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 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: 2151540	RESTRICTED TO: REV P1
MATERIAL:		WEIGHT:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:2 SHEET: 2 OF 4

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151540-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151540-2	P	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151540-2	P	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151540-7	J	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: SIEMENS TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.10-4.70 mm [1.61-.185 IN]	Ø1.10-1.65 mm [.043-.065 IN]		
TERMINAL APPLICATION SPECIFICATION	114-13060		
TERMINALS APPLIED			
TE TERMINAL	SIEMENS TERMINAL	TE TERMINAL	SIEMENS TERMINAL
1393364-1	V23540X7000Y10	1-1438299-0	
1393367-1	V23540X7000Y11	1393364-2	
1438299-2	V23540X7000Y31	1393367-2	
1438299-1	V23540X7000Y30		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.97 +/- 0.04 [.038 +/- .002]	7.7
22 AWG	0.95 +/- 0.04 [.037 +/- .002]	7.9
0.22mm2	0.89 +/- 0.04 [.035 +/- .002]	8.7

- 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 & 151.
- 6 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

**\*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)

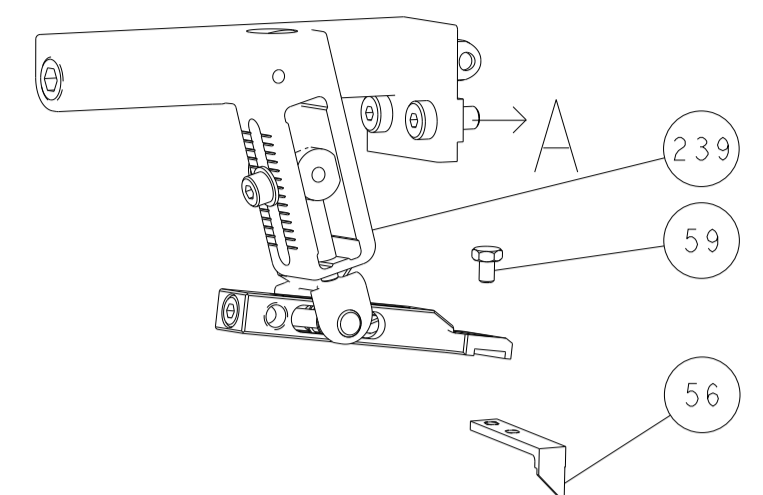
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	-	-	2844950-1	AIR FEED MODULE		290
-	1	1	1	2119791-5	DEPRESSOR, WIRE		286
-	1	1	1	1633782-2	FENCE		267
-	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0		241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	-	1	-	2844940-1	AIR FEED MODULE		238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC		164
-	-	1	-	2119641-2	FEED CAM, AIR FEED		151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		143
-	-	-	1	2119653-2	FEED CAM, POST FEED		142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC		140
-	1	1	1	1-22281-8	SPRING, COMPRESSION		121
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4		119
-	1	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	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65		93
-	1	1	1	455888-4	SPACER, CRIMPER		82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE		71
-	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		69
-	1	1	1	2-690438-2	FRONT STRIP GUIDE		68
-	1	1	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0		61
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	1	1	1	1338685-1	PAWL, FEED		56
-	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14		53
-	1	1	1	1-1463053-0	HOLDER, TERMINAL		51
-	1	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	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	1	1	1	1-1752356-8	SUPPORT, TERMINAL		34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	1	1	2844938-5	PLATE, STRIP GUIDE		29
-	2	2	2	22281-8	SPRING, COMPRESSION		27
-	1	1	1	356835-1	LEVER, DRAG RELEASE		26
-	1	1	1	240792-2	DRAG, TERMINAL		25
-	1	1	1	1320928-6	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
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED		19
-	1	1	1	6-240641-7	SPACER		16
-	1	1	1	2119806-1	INSERT, SHEAR		13
-	1	1	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1	1	1-356885-4	STOP, SHEAR		11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	1	1	1-318707-4	FLOATING SHEAR, FRONT		9
-	1	1	1	1-1333201-9	ANVIL, COMBINATION		8
-	-	-	-	-	-		7
-	-	-	-	-	-		6
-	1	1	1	2119757-2	DEPRESSOR, SHEAR		5
-	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER		4
-	1	1	1	3-1633966-0	CRIMPER, INSULATION O		3
-	1	1	1	455888-7	SPACER, CRIMPER		2
-	1	1	1	3-1803224-5	CRIMPER, WIRE		1

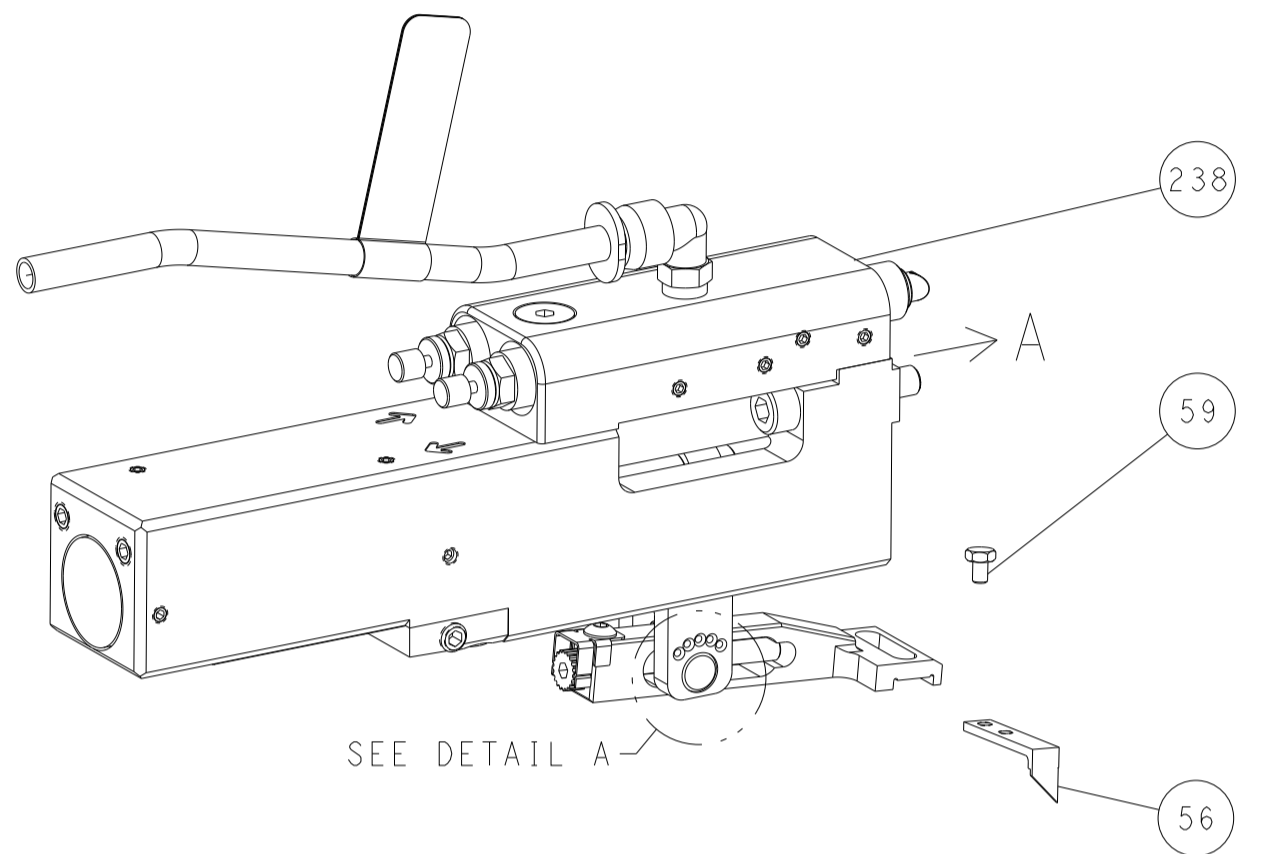
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LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
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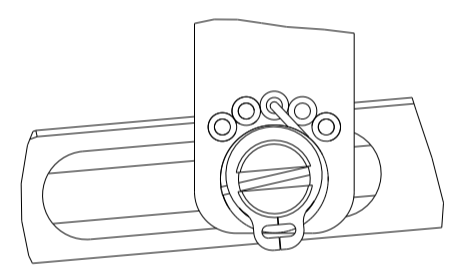
# FEED TYPE MECHANICAL



# PNEUMATIC

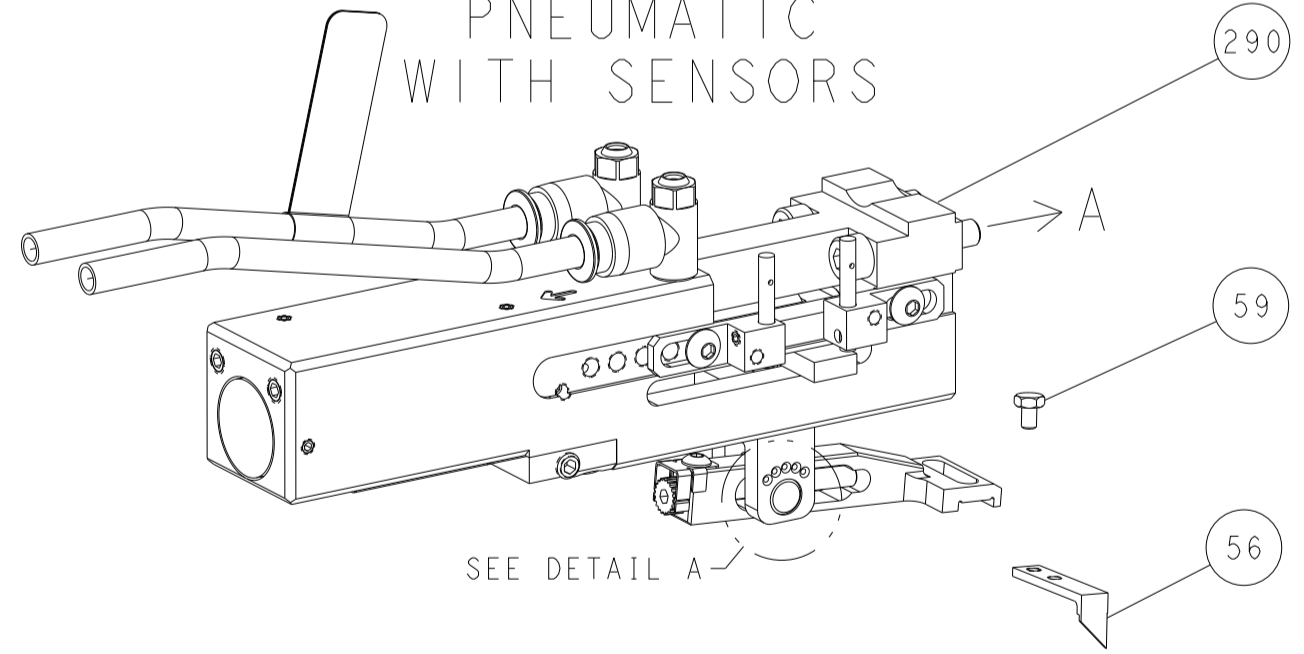


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

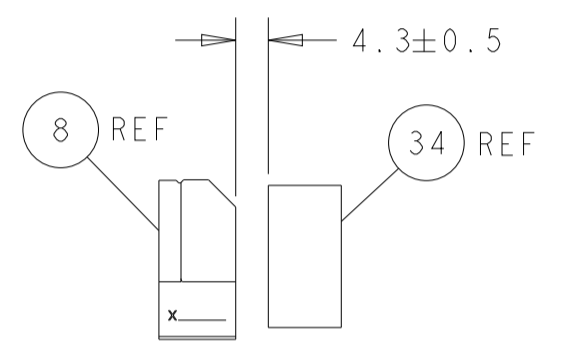
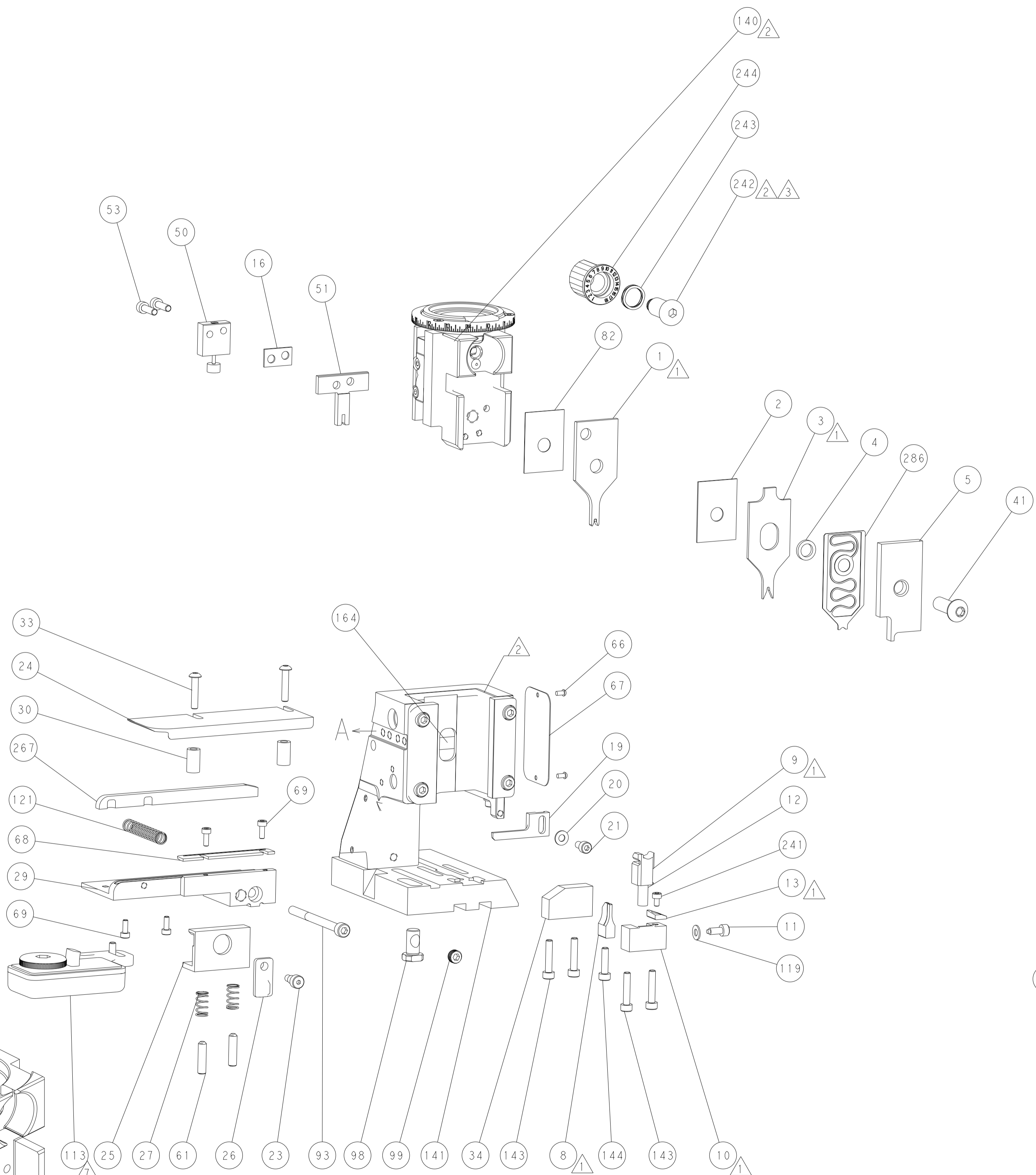
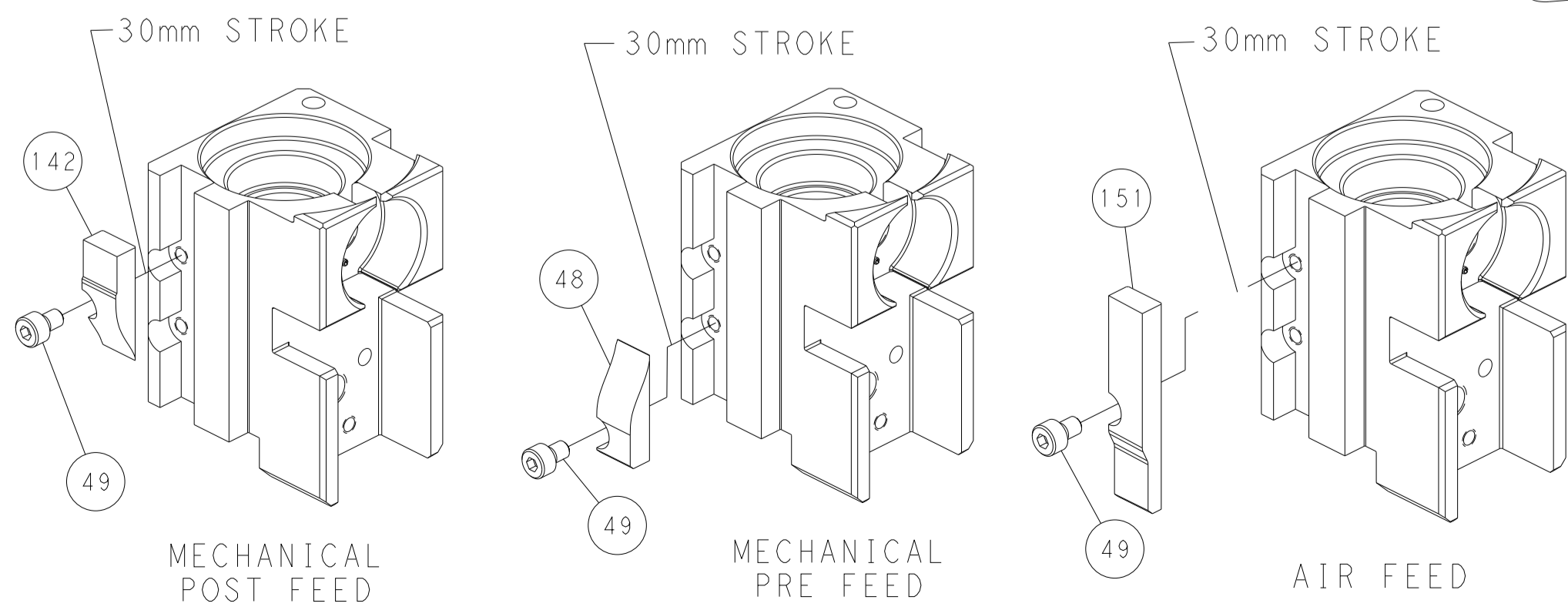


DETAIL A

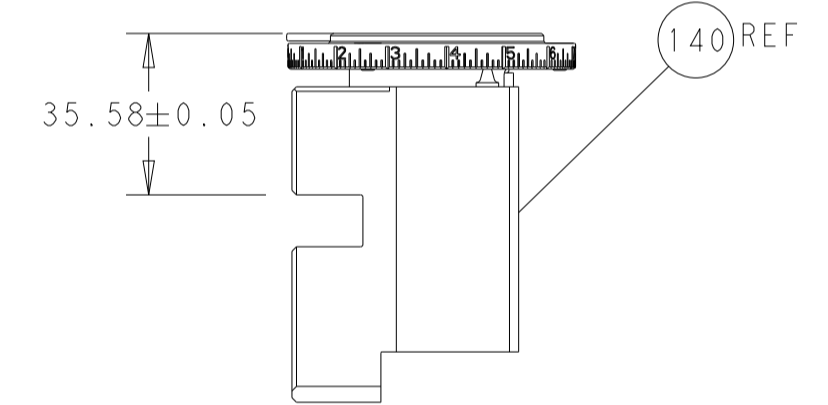
# DOUBLE ACTING PNEUMATIC WITH SENSORS



# CAM POSITIONS

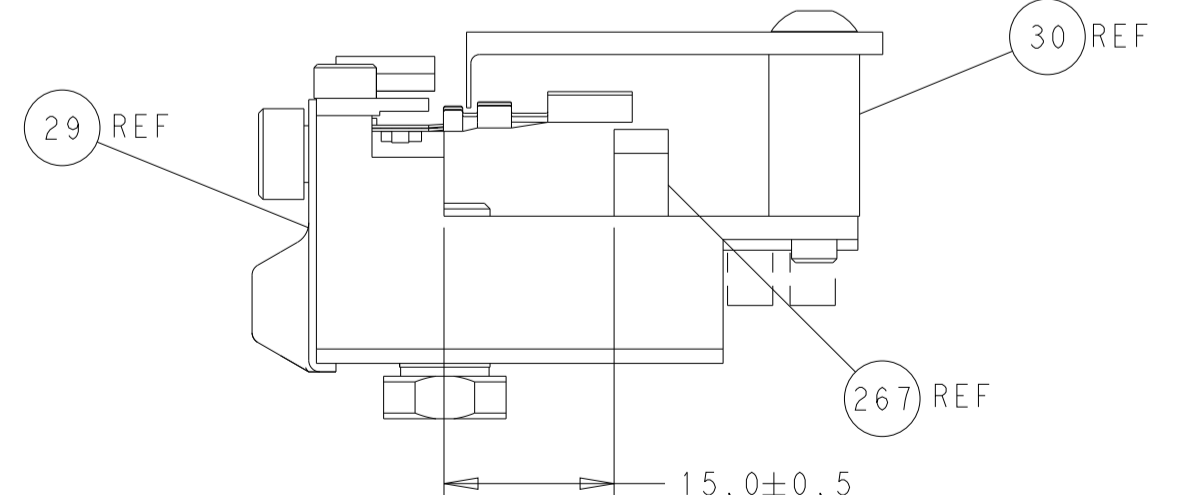


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES



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 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151540	RESTRICTED TO: SCALE: 1:2 SHEET: 4 OF 4 REV: P1
MATERIAL:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	