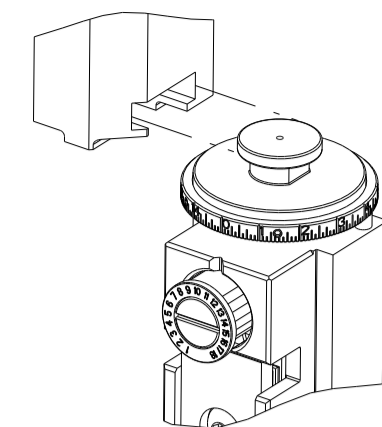


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151083-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151083-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151083-1	K	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151083-2	K	MECHANICAL AND CRIMP TOOLING KIT	PNEUMATIC
7-2151083-7	H	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



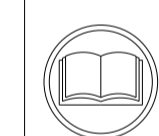
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DYNAMIC D1000 SERIES REC CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5377		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1827572-2	1871731-1	1903114-2	1903122-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HD1 CONTACT 2L SIZE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	114-78021		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2316663-4	2316670-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.86mm <sup>2</sup>	1.15+/-0.03 [.045+/- .001]	4.8
20 AWG OR 0.52mm <sup>2</sup>	1.00+/-0.03 [.039+/- .001]	6.3
22 AWG OR 0.35mm <sup>2</sup>	0.85+/-0.03 [.033+/- .001]	7.8



- 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 ITEMS 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- USE TERMINAL SUPPORT 7-1752356-4 (ITEM 234) FOR TERMINAL 2316663-4. USE TERMINAL SUPPORT 8-1752356-7 (ITEM 34) FOR ALL OTHER TERMINALS.

**\*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
		G1		ECR-18-008851	08JUN2018	KH	LZ
		H		ECR-20-014197	06OCT2020	JWC	RK
		J		ECR-22-151337	02SEP2022	FZ	GB
		K		ECR-23-165048	31JAN2023	TB	TE

-	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	1-22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1803944-1	SPACER, TONKER	297
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	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	7-1752356-4	SUPPORT, TERMINAL	234
-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	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	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	8-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1-1729372-5	ANVIL	8
-	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-6	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1-1803384-6	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	2	1	4-1633730-4	CRIMPER, WIRE	1

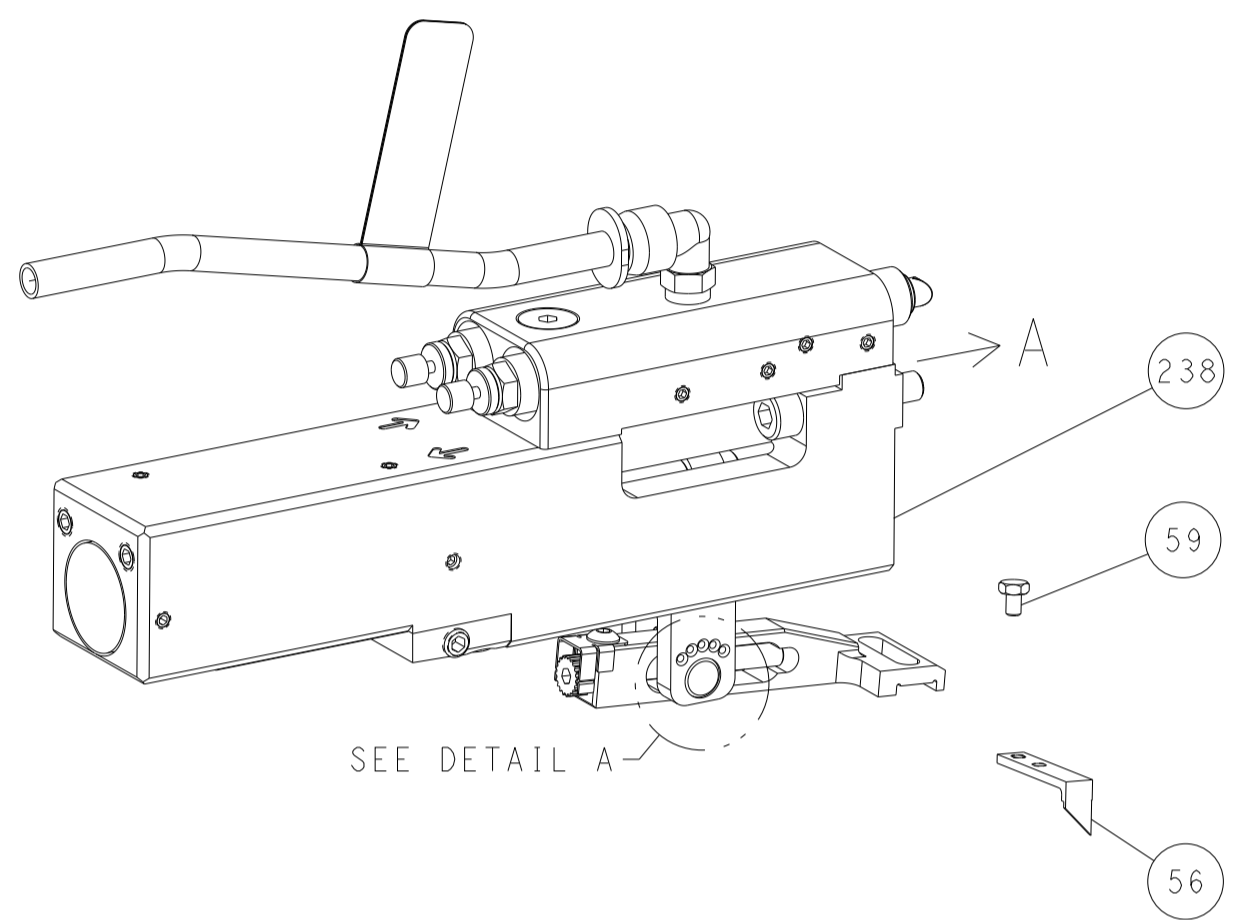
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	DATE	NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	H. HUANG	31AUG2011	TE Connectivity	
	3 PLC ±	4 PLC ±	ANGLES ±	CHK		Harrisburg, PA 17105-3608	
	FINISH			APVD	31AUG2011	Ocean Side Feed	
				PRODUCT SPEC		Applicator	
				APPLICATION SPEC		SIZE	CAGE CODE
						A1	00779
				WEIGHT		DRAWING NO	2151083
						RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE 1:2
						SHEET 1 of 4	REV K

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

# FEED TYPE MECHANICAL



## PNEUMATIC

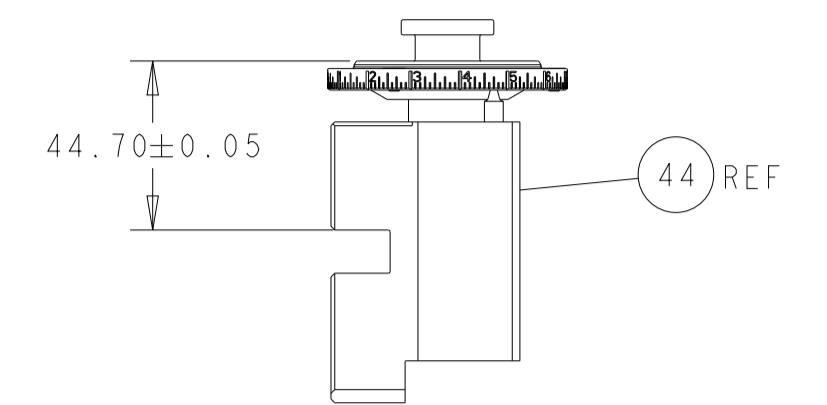
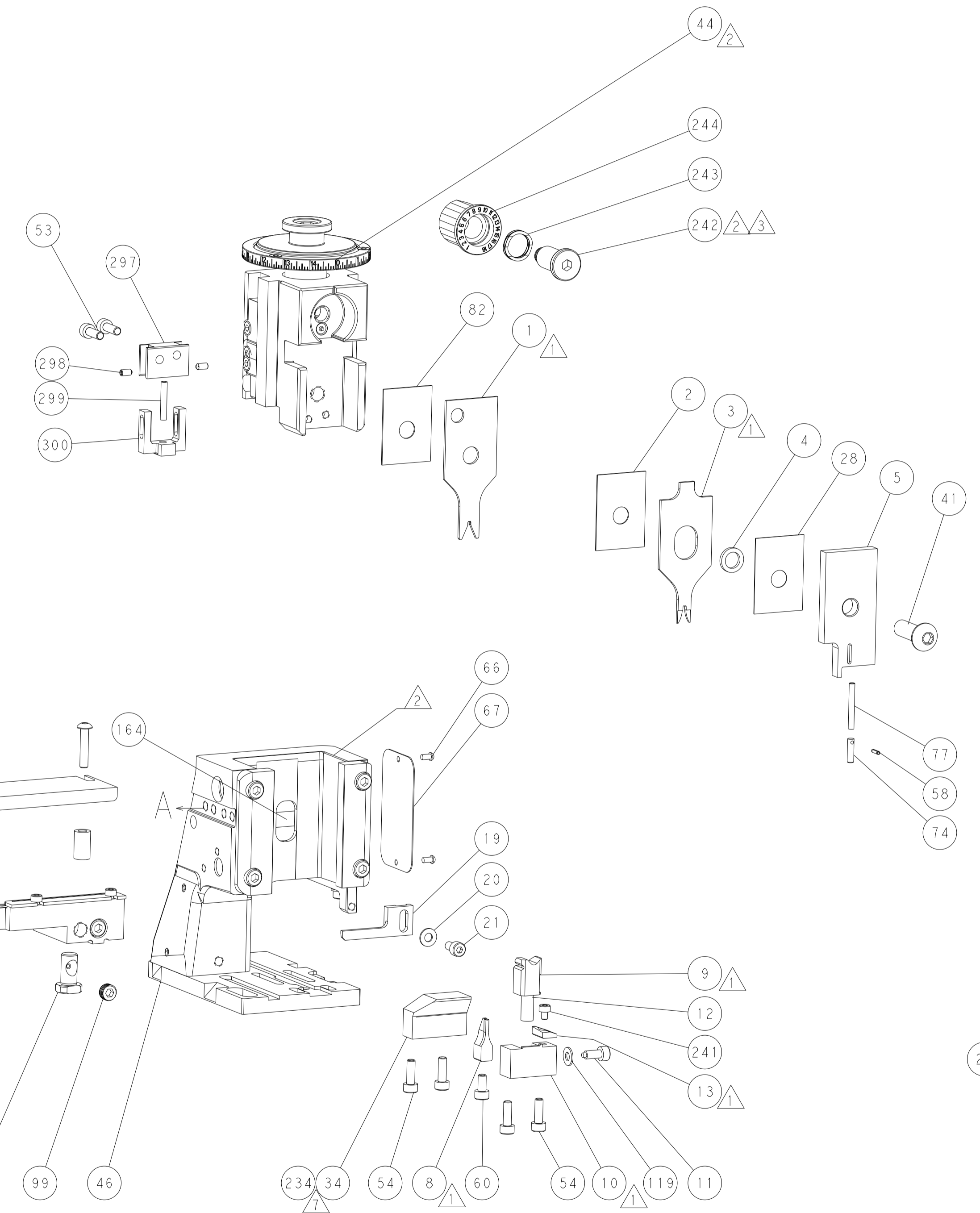
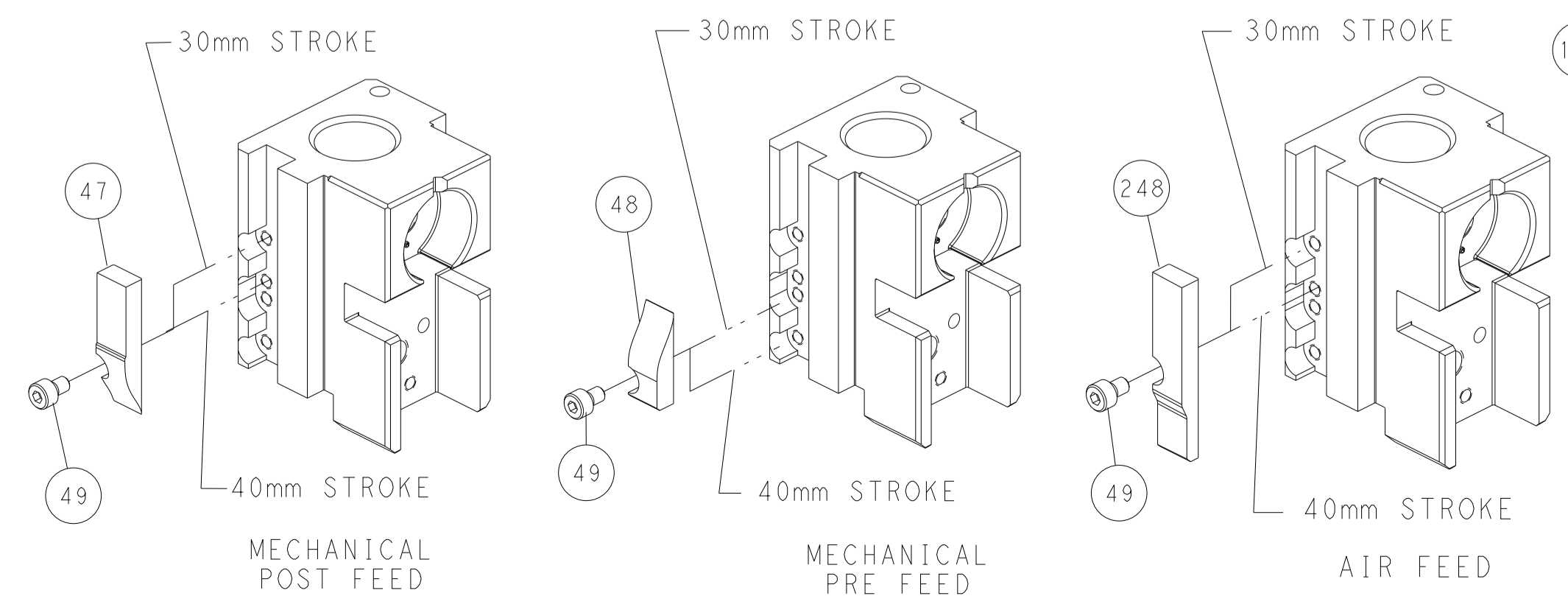


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

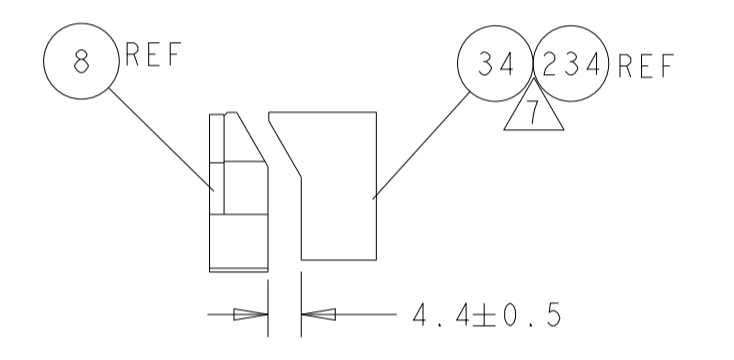


DETAIL A

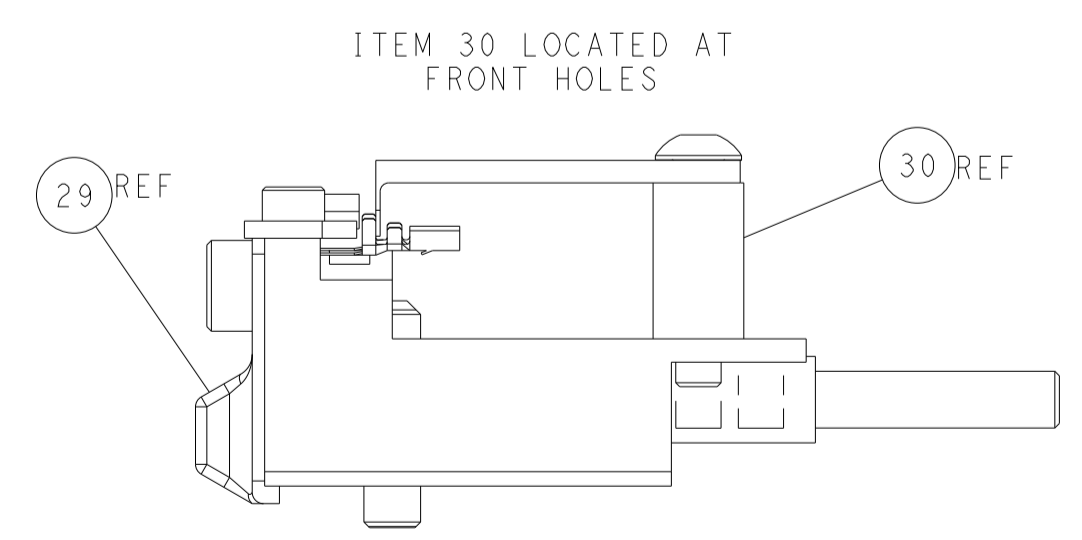
## CAM POSITIONS



RAM SET-UP



TERMINAL SUPPORT LOCATION



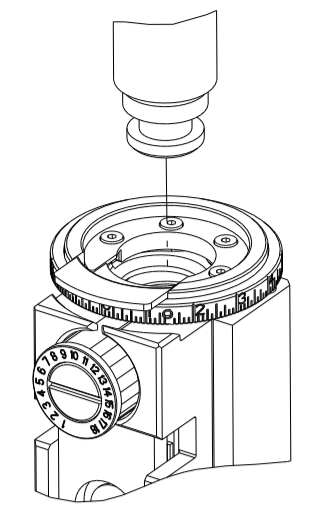
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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: R. HUANG CHK: S. XI APVD: S. XI PRODUCT SPEC: 31AUG2011 APPLICATION SPEC:	DATE: 31AUG2011 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151083 RESTRICTED TO:
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH:	WEIGHT: Customer Accessible Production Drawing SCALE: 1:2 SHEET: 2 of 4 REV: K	TE Connectivity Harrisburg, PA 17105-3608	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151083-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151083-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151083-7	H	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DYNAMIC D1000 SERIES REC CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5377	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1827572-2	1871731-1	1903114-2	1903122-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HD1 CONTACT 2L SIZE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	114-78021	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2316663-4	2316670-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.86mm <sup>2</sup>	1.15+/-0.03 [.045+/-0.001]	4.8
20 AWG OR 0.52mm <sup>2</sup>	1.00+/-0.03 [.039+/-0.001]	6.3
22 AWG OR 0.35mm <sup>2</sup>	0.85+/-0.03 [.033+/-0.001]	7.8

- 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 ITEMS 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- USE TERMINAL SUPPORT 7-1752356-4 (ITEM 234) FOR TERMINAL 2316663-4.  
USE TERMINAL SUPPORT 8-1752356-7 (ITEM 34) FOR ALL OTHER TERMINALS.

**\*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	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	1803945-4	TONKER	300
-	1	1	1-22278-9	SPRING, COMPRESSION	299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	1	1	2119082-4	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
	1	1	7-1752356-4	SUPPORT, TERMINAL	234
-	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	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	1	1	8-1752356-7	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	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	1803095-6	FLOATING SHEAR, FRONT	9
	1	1	3-1729372-5	ANVIL	8
-	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	238011-6	BLOCK, CRIMPER SPACER	4
	1	1	2-1803384-6	CRIMPER, INSULATION F	3
-	1	1	455888-5	SPACER, CRIMPER	2
	1	1	4-1633730-4	CRIMPER, WIRE	1
-	77	-	22-21	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
APVD: S. XI 31AUG2011		APVD: S. XI 31AUG2011		WEIGHT: -		SCALE: 1:2	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2		SHEET: 3 OF 4		REV: K	

**STE** TE Connectivity  
Harrisburg, PA 17105-3608

**Ocean Side Feed Applicator**

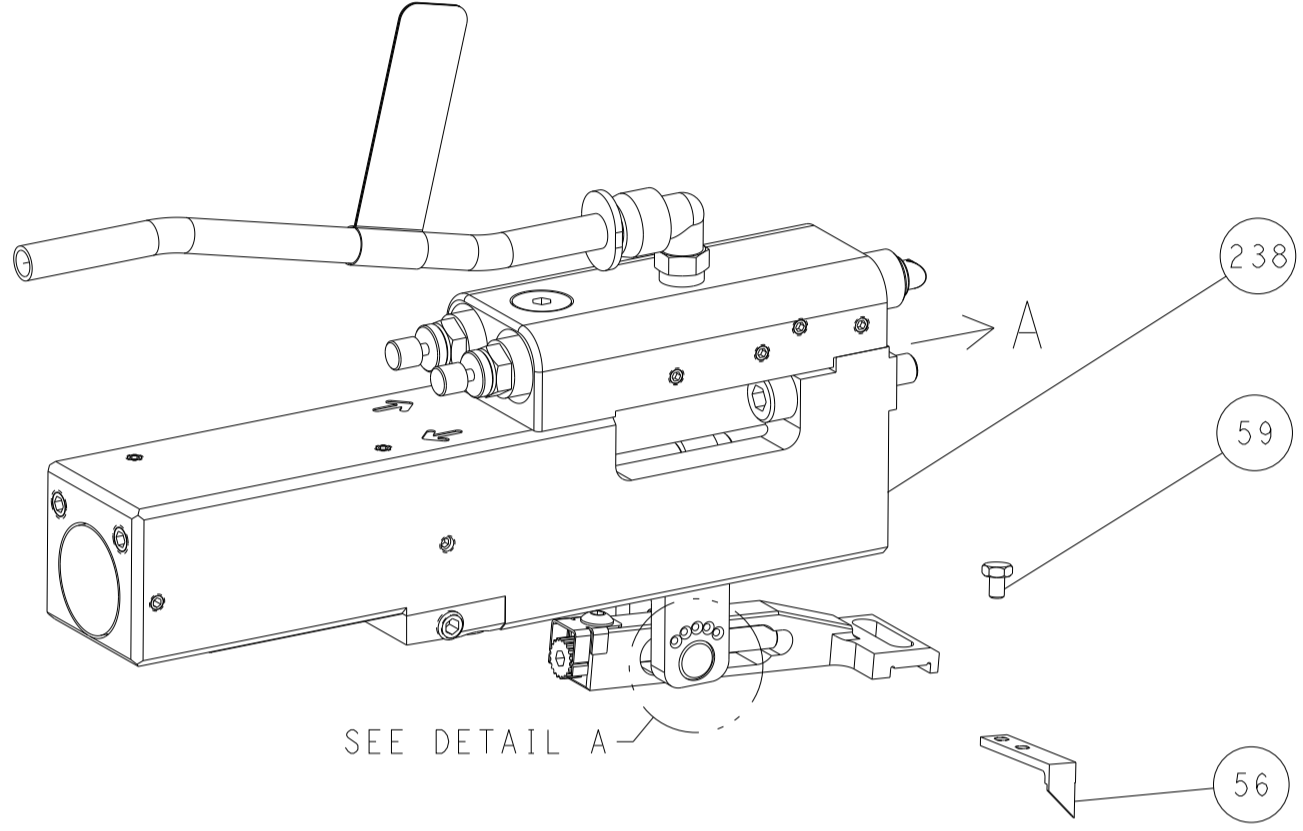
SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151083

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

# FEED TYPE MECHANICAL



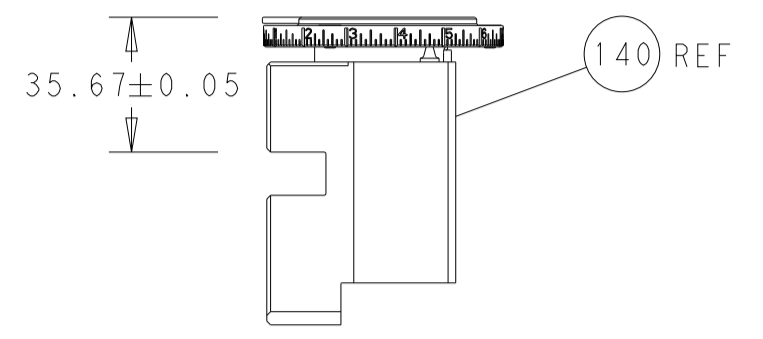
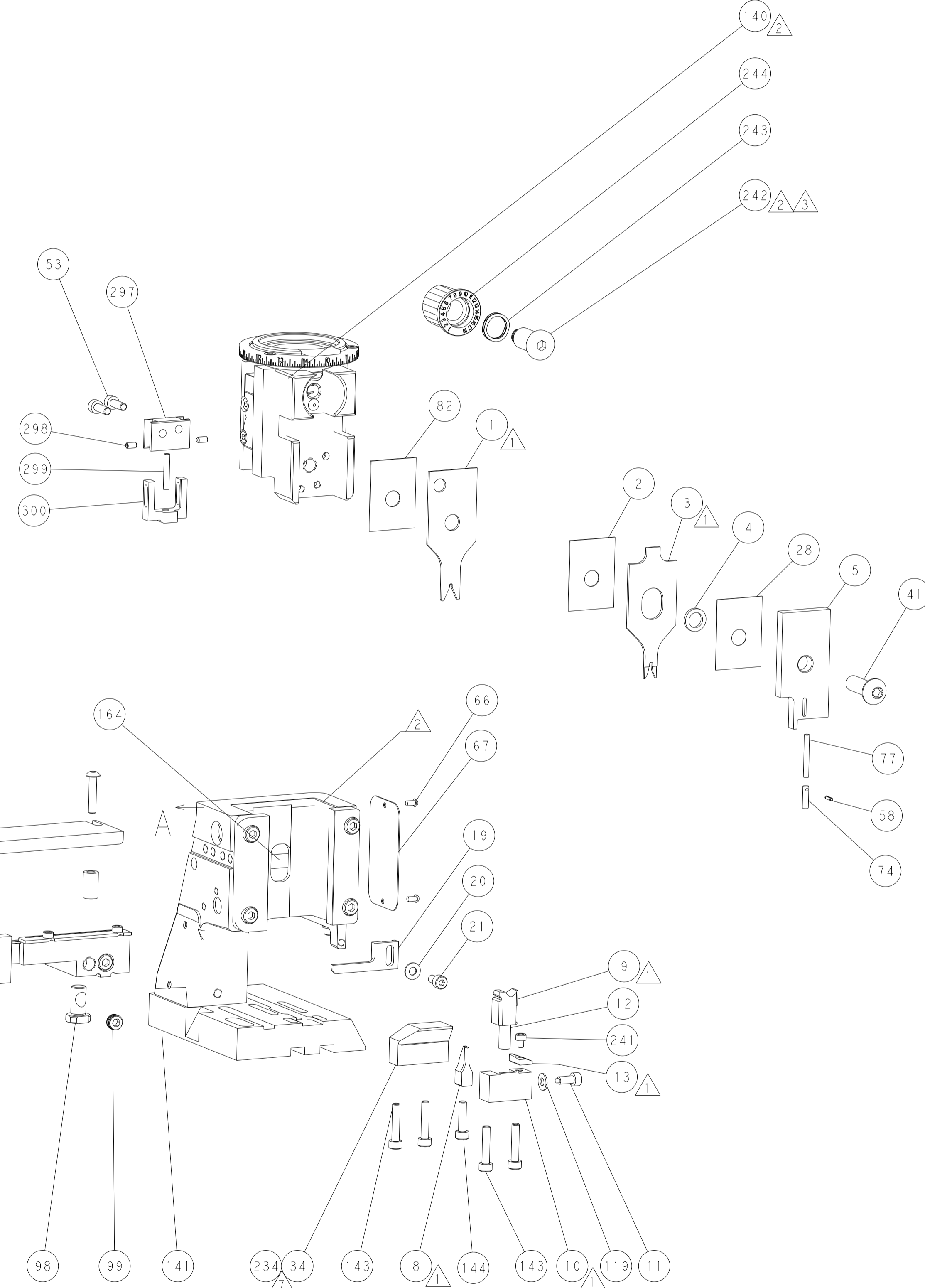
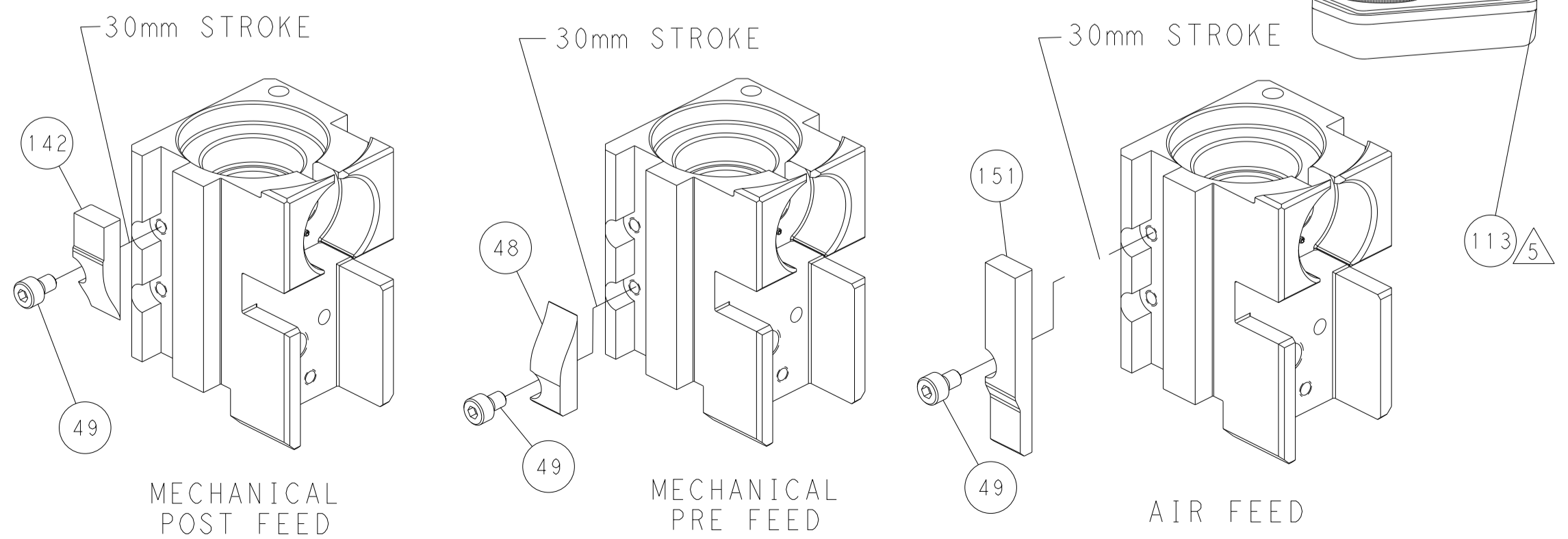
## PNEUMATIC



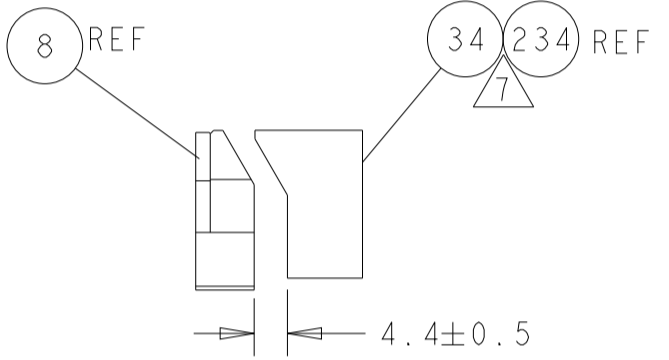
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



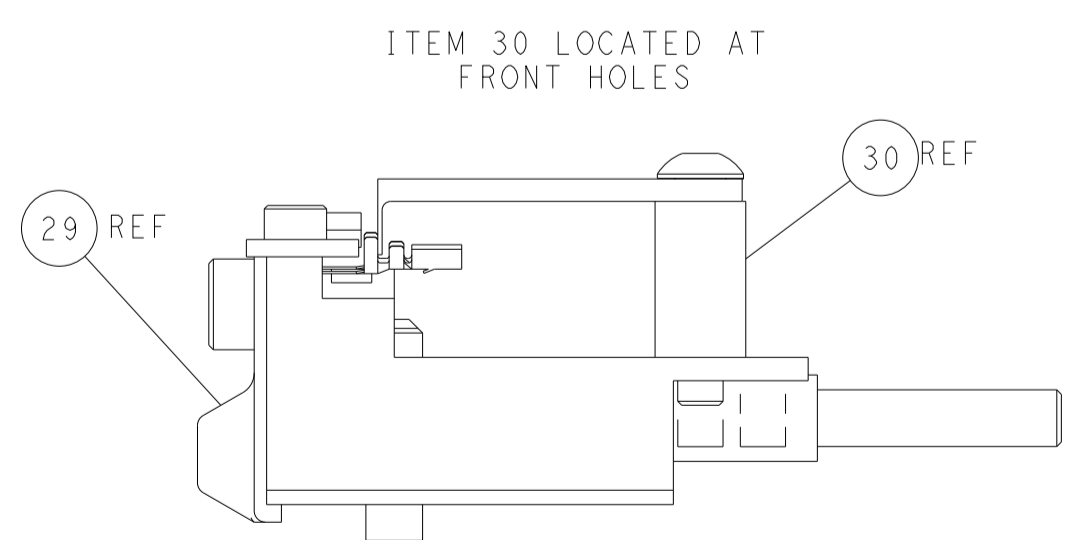
## CAM POSITIONS



RAM SET-UP



TERMINAL SUPPORT LOCATION



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN: H. HUANG 31AUG2011 CHK: S. XI 31AUG2011 APVD: S. XI 31AUG2011 PRODUCT SPEC APPLICATION SPEC WEIGHT: A   00779 SCALE: 1:2 SHEET: 4 OF 4 REV: K		NAME: Ocean Side Feed Applicator SIZE: A   CAGE CODE: 00779 DRAWING NO: C-2151083 RESTRICTED TO: Customer Accessible Production Drawing	
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