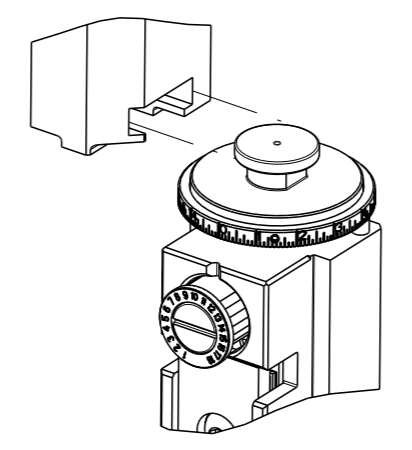


THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151991-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151991-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151991-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	6.73 mm [.265]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DIAMETER 4mm PIN & SOCKET			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.20-5.80 mm [.205-.228 IN]	Ø1.40-3.00 mm [.055-.118 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18072-1		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
965838-1	965839-1			1.4-2.1 mm
				2.2-3.0 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.18+/-0.05 [.086+/-0.002]	5.0
2.00mm2	2.06+/-0.05 [.081+/-0.002]	6.5
1.50mm2	1.94+/-0.05 [.076+/-0.002]	7.8
1.00mm2	1.82+/-0.05 [.072+/-0.002]	9.1

- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- CUT TO LENGTH AT ASSEMBLY.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- APPLY TORO-SEAL IN ALLN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT WEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THE THREADS.

**\*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	#	LY#	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	19FEB2015	RW	TE
		B		ECR-22-134277	29MAR2022	JWC	RR
		B1		ECR-22-139686	19MAY2022	FZ	GB

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1633782-4	FENCE	267
-	1	1	1803078-4	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	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	318563-1	GUARD, FRONT CHIP	89
-	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
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1-1752356-6	SUPPORT, TERMINAL	34
-	4	4	2079383-4	SCR, BHSC, RoHS (M4 X 8)	33
-	1	1	1633744-2	SPACER, STRIP GUIDE	30
-	1	1	2844938-9	PLATE, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	2-1320928-3	STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	1-356885-3	STOP, SHEAR	11
-	1	1	2119805-7	SHEAR HOLDER, FRONT	10
-	1	1	318059-9	FLOATING SHEAR, FRONT	9
-	1	2	1-1633930-8	ANVIL, COMBINATION	8
-	1	1	240641-4	SPACER	7
-	-	-	-	-	6
-	1	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	8-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-8	SPACER, CRIMPER	2
-	1	2	6-657555-9	CRIMPER, WIRE PREMIUM	1

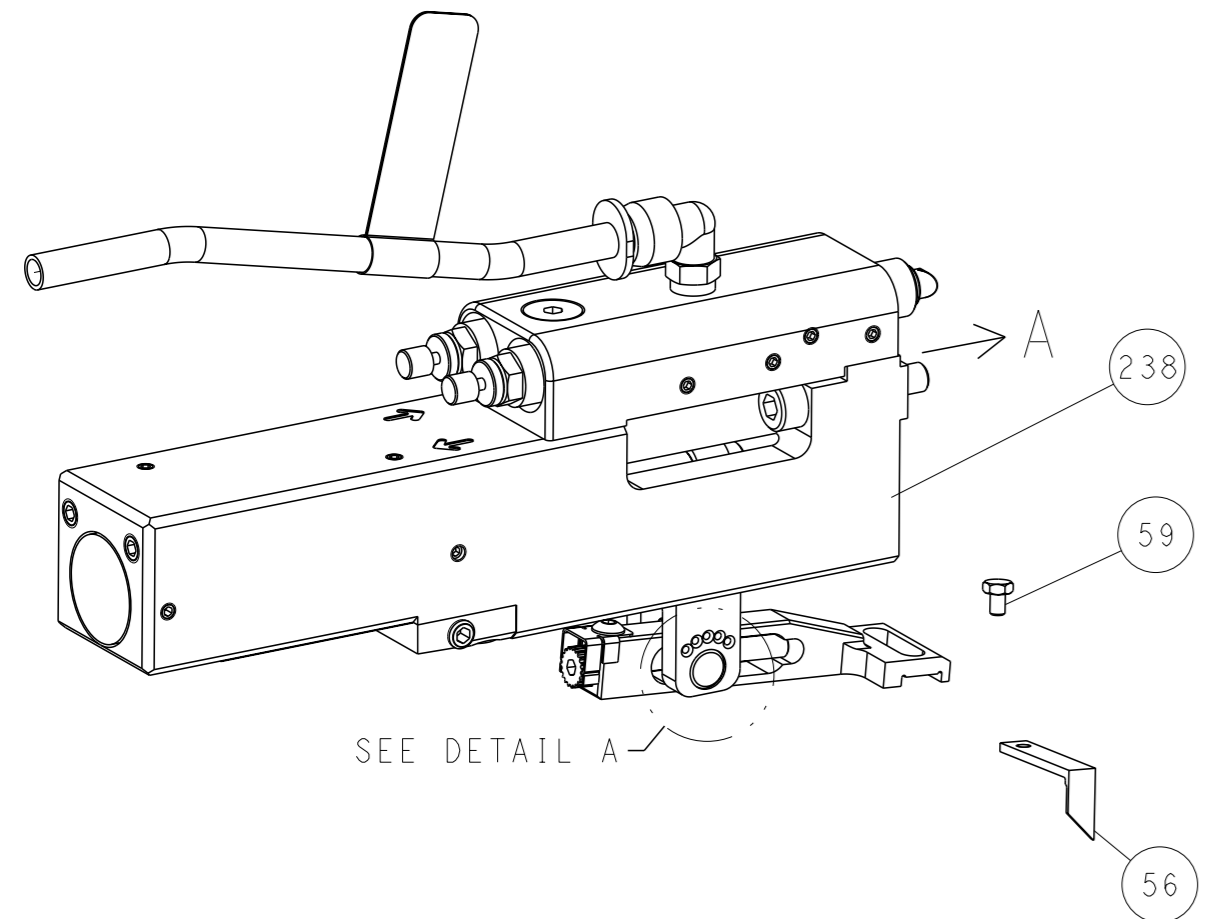
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THE DRAWING IS CONTROLLED DOCUMENT FOR THE PRODUCT. ANY CHANGES TO THE DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE QUALITY CONTROL ENGINEER. ANY CHANGES TO THE DRAWING MUST BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. O. WILSON 26DEC2014 CHK: K. J. STAKEM 29DEC2014 APVD: T. L. ELBIN 29DEC2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CASE CODE: 00779 DRAWING NO: 2151991 SHEET 1 OF 4 REV B1
Customer Accessible Production Drawing			

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

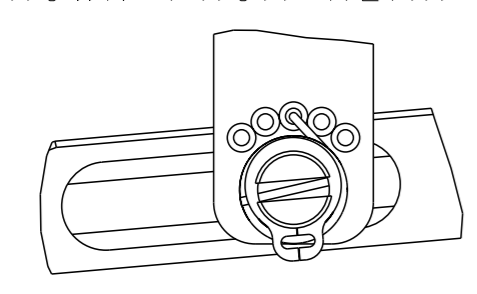
# FEED TYPE

## PNEUMATIC



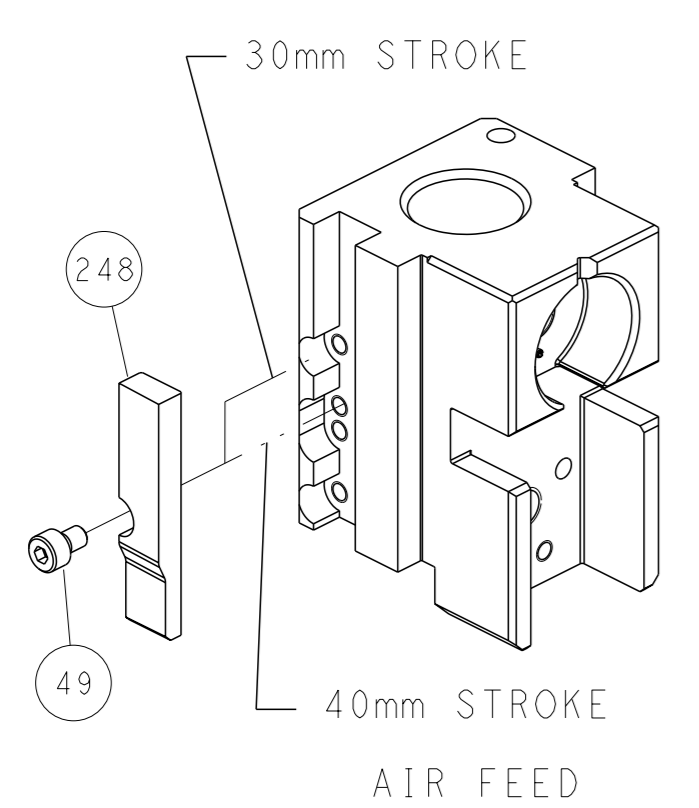
SEE DETAIL A

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

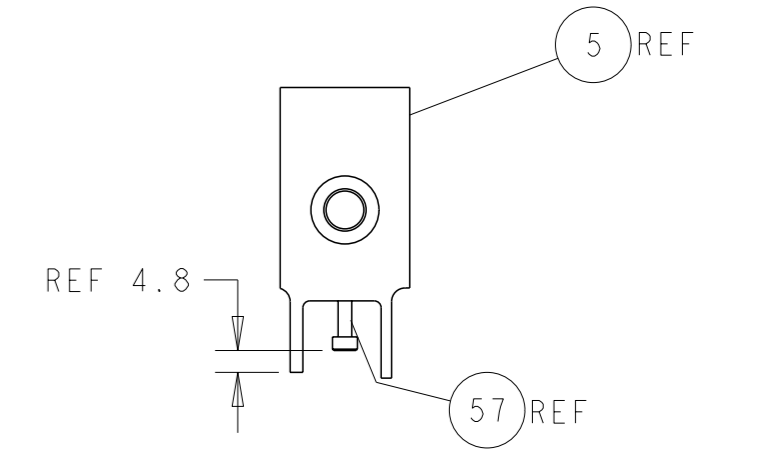
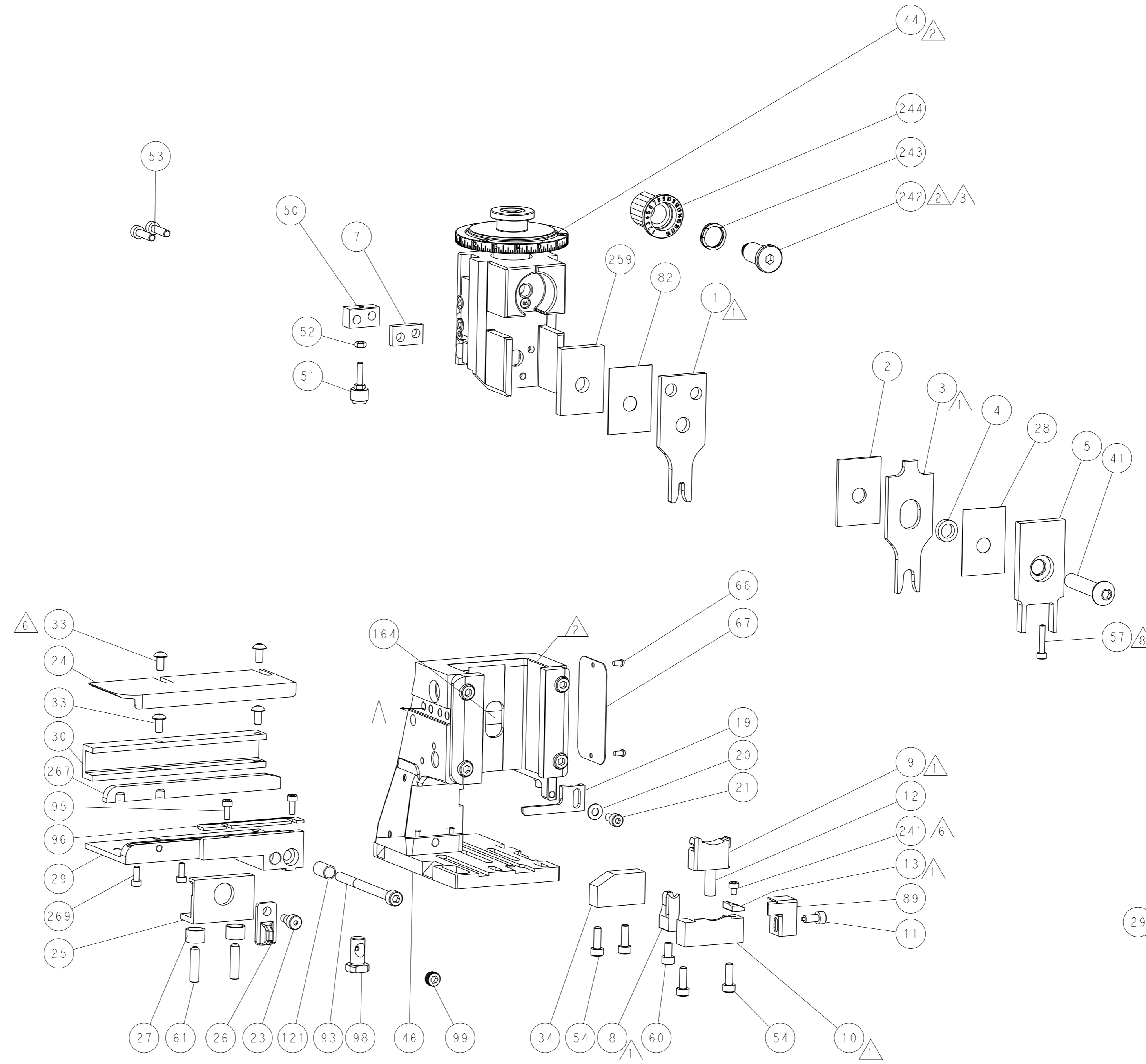


DETAIL A

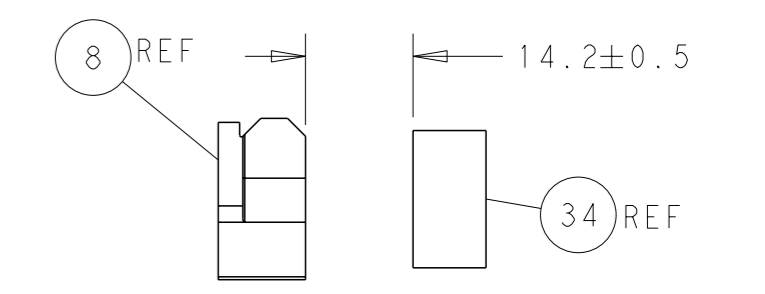
## CAM POSITION



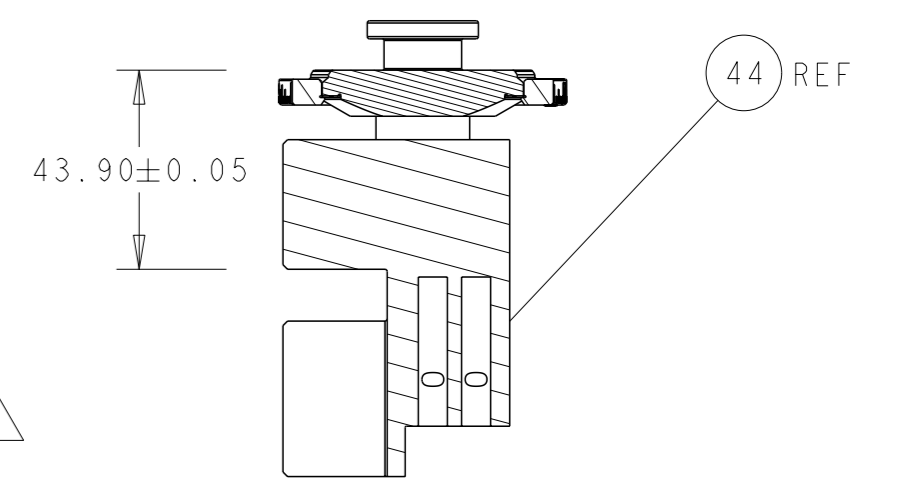
AIR FEED



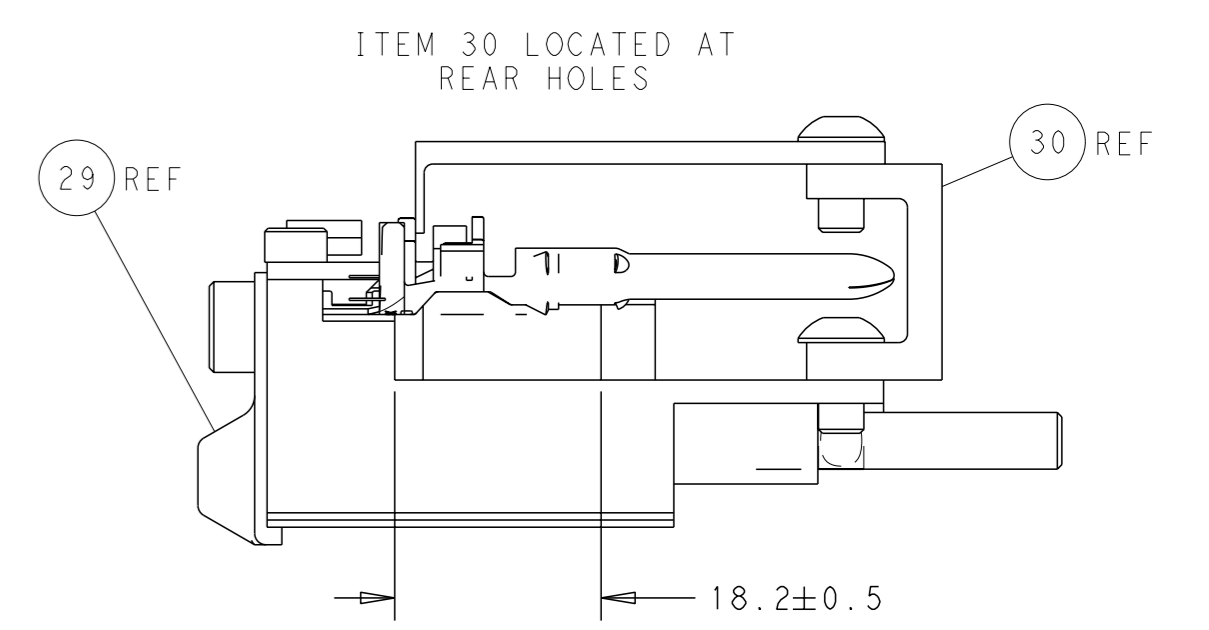
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



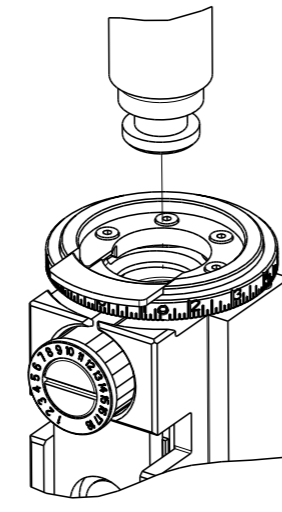
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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>		DWG: R. O. WILSON 26DEC2014 CHK: K. J. STAKEM 29DEC2014 APVD: J. L. ELBIN 29DEC2014	NAME: Ocean Side Feed Applicator SIZE: A1 SCALE: 1:2
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:	CAGE CODE DRAWING NO: 00779 ©=2151991 RESTRICTED TO: B1 SHEET 2 OF 4

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COMPANY TO	BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		
NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151991-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151991-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [ .120 ]	F
INSUL	6.73 mm [ .265 ]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DIAMETER 4mm PIN & SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.80 mm [ .205-.228 IN ]		∅1.40-3.00 mm [ .055-.118 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-18072-1		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
965838-1	965839-1		963243-1	1.4-2.1 mm
			963244-1	2.2-3.0 mm

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.18 +/- 0.05 [ .086 +/- .002 ]	5.0
2.00mm2	2.06 +/- 0.05 [ .081 +/- .002 ]	6.5
1.50mm2	1.94 +/- 0.05 [ .076 +/- .002 ]	7.8
1.00mm2	1.82 +/- 0.05 [ .072 +/- .002 ]	9.1

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- CUT TO LENGTH AT ASSEMBLY.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- APPLY TORO-SEAL IN ALLN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT WEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THE THREADS.

**\*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)

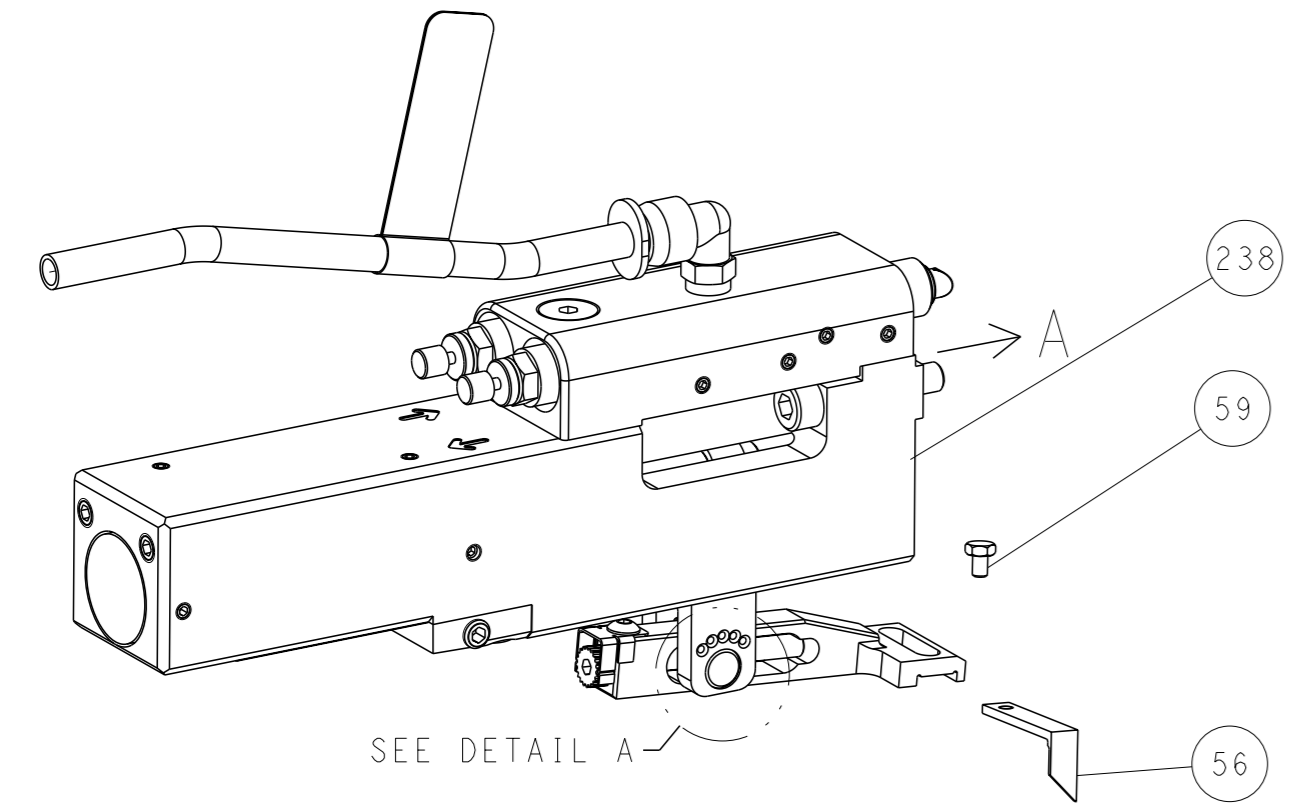
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1633782-4	FENCE	267	
-	1	1803078-4	SPACER, PRECISION	259	
-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	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	
-	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	1-22281-8	SPRING, COMPRESSION	121	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	1-690438-0	FRONT STRIP GUIDE	96	
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	318563-1	GUARD, FRONT CHIP	89	
-	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	
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	1	1-1338683-1	FEED PAWL	56	
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1-1752356-6	SUPPORT, TERMINAL	34	
	-	4	2079383-4	SCR, BHSC, RoHS (M4 X 8)	33
-	1	1633744-2	SPACER, STRIP GUIDE	30	
-	1	2844938-9	PLATE, STRIP GUIDE	29	
-	1	455888-3	SPACER, CRIMPER	28	
-	2	22283-1	SPRING, COMPRESSION	27	
-	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	240792-1	DRAG, TERMINAL	25	
-	1	2-1320928-3	STRIP GUIDE	24	
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	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	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1-356885-3	STOP, SHEAR	11	
	-	1	2119805-7	SHEAR HOLDER, FRONT	10
	-	1	318059-9	FLOATING SHEAR, FRONT	9
	1	1	1-1633930-8	ANVIL, COMBINATION	8
-	1	240641-4	SPACER	7	
-	-	-	-	6	
-	1	1803080-1	DEPRESSOR, SHEAR	5	
-	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
	1	1	8-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1-455888-8	SPACER, CRIMPER	2	
	1	1	6-657555-9	CRIMPER, WIRE PREMIUM	1
-	-	-77 -22	PART NO	DESCRIPTION	ITEM NO

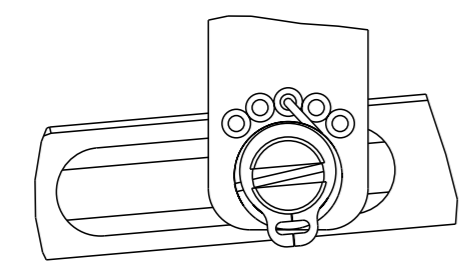
<small>THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. O. WILSON 26DEC2014 CHK: K. J. STAKEM 29DEC2014 APVD: T. L. ELBIN 29DEC2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES 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: 2151991 RESTRICTED TO: -
MATERIAL: -		WEIGHT: -	SCALE: 1:2 SHEET: 3 of 4 REV: B1

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

### FEED TYPE PNEUMATIC

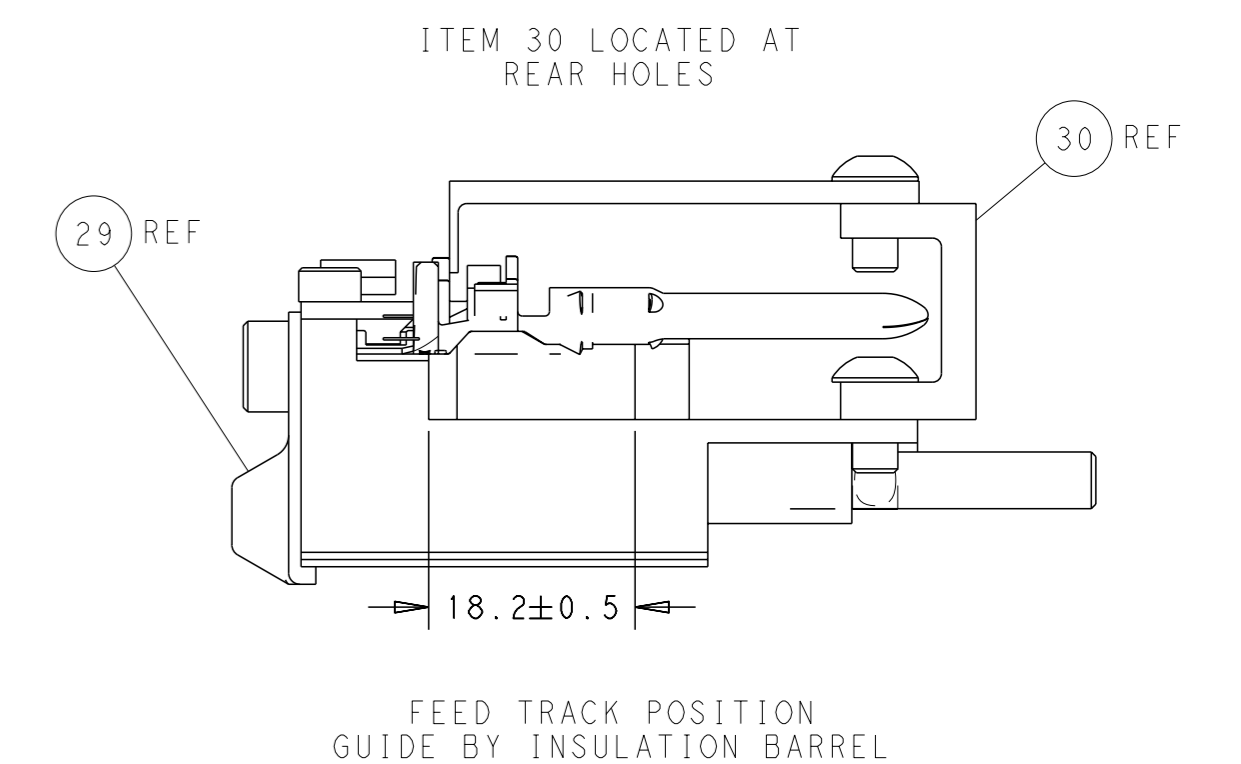
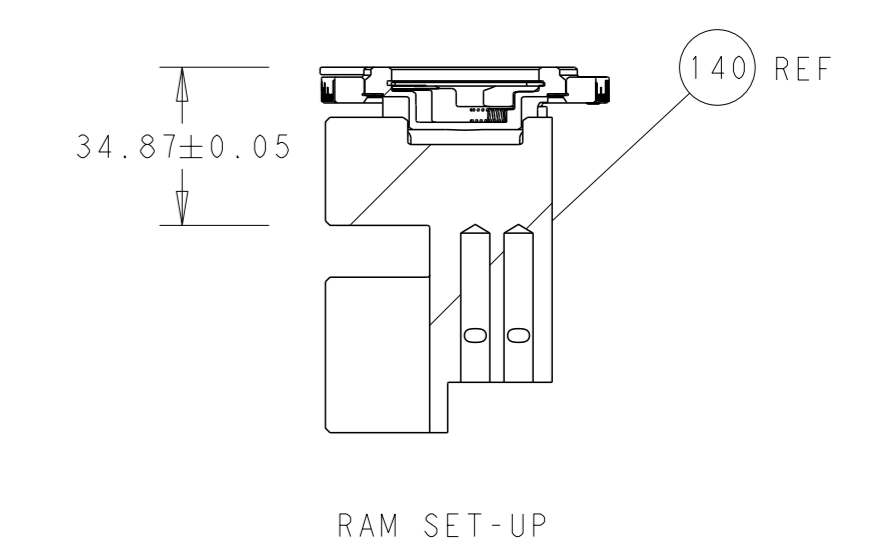
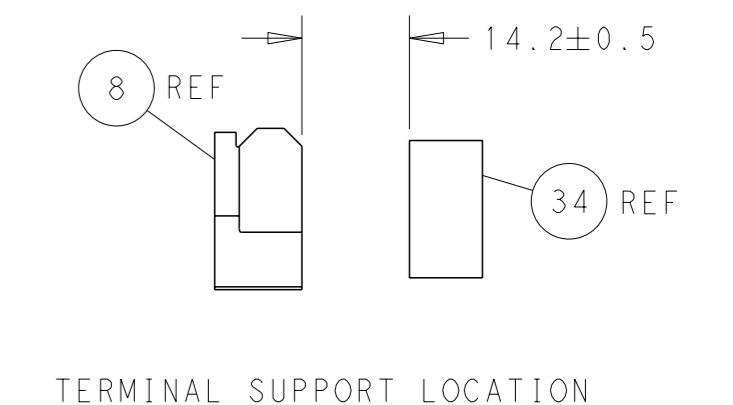
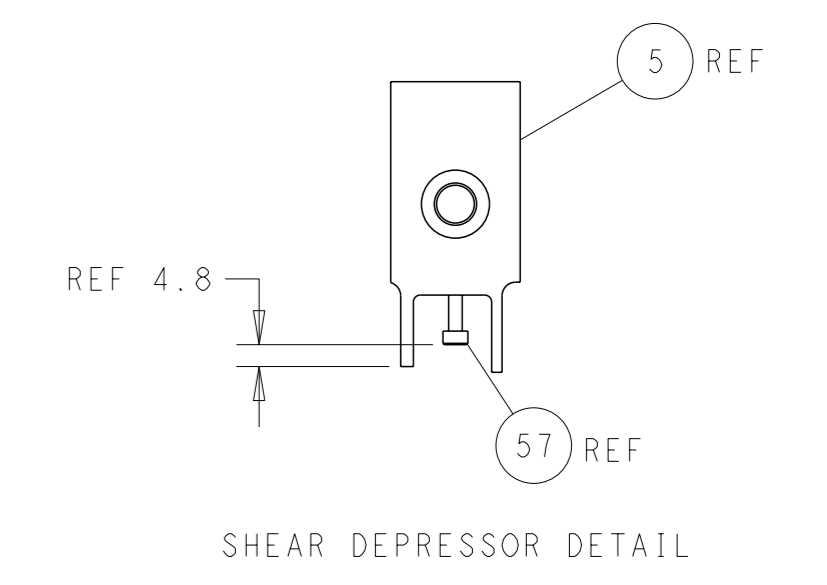
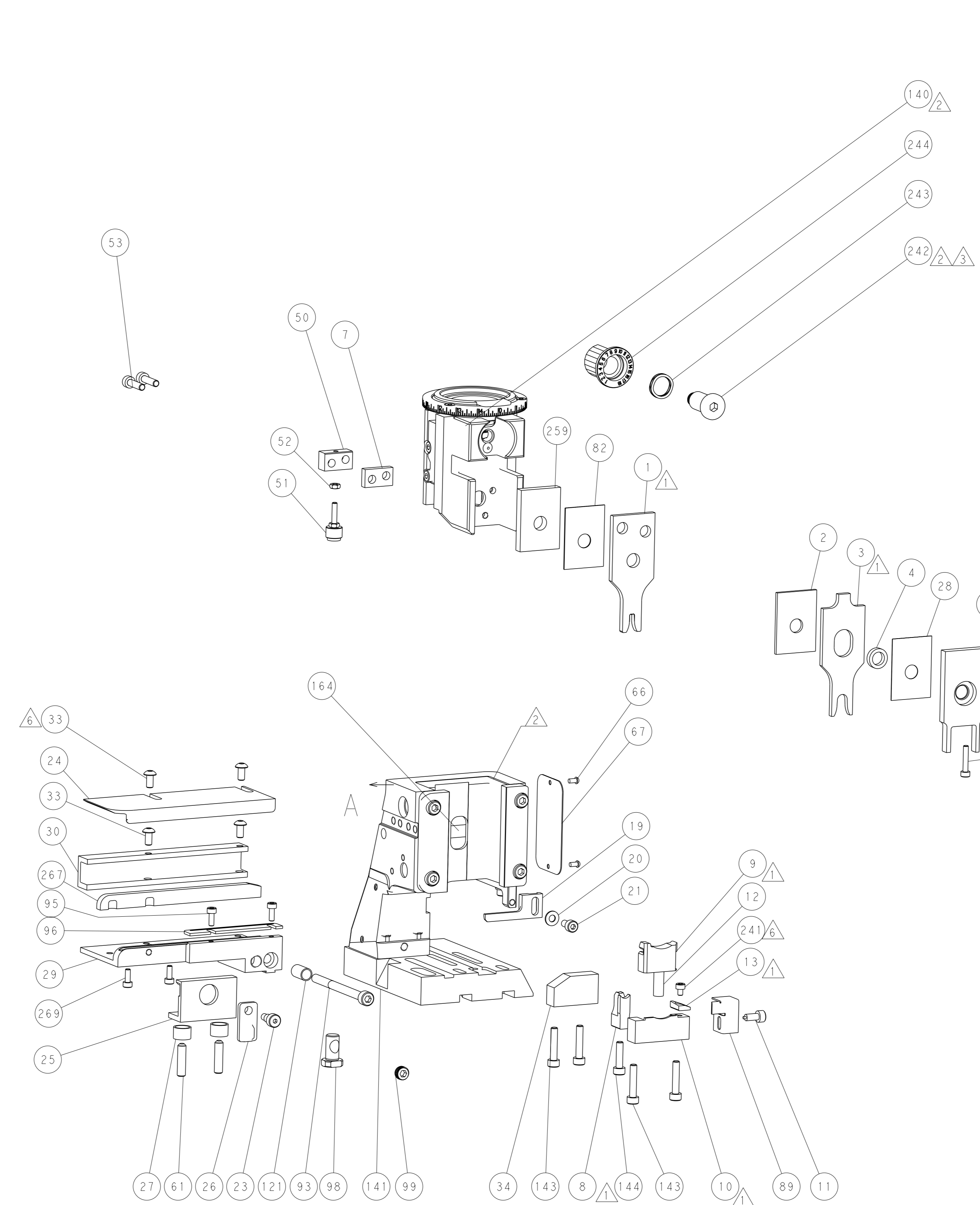
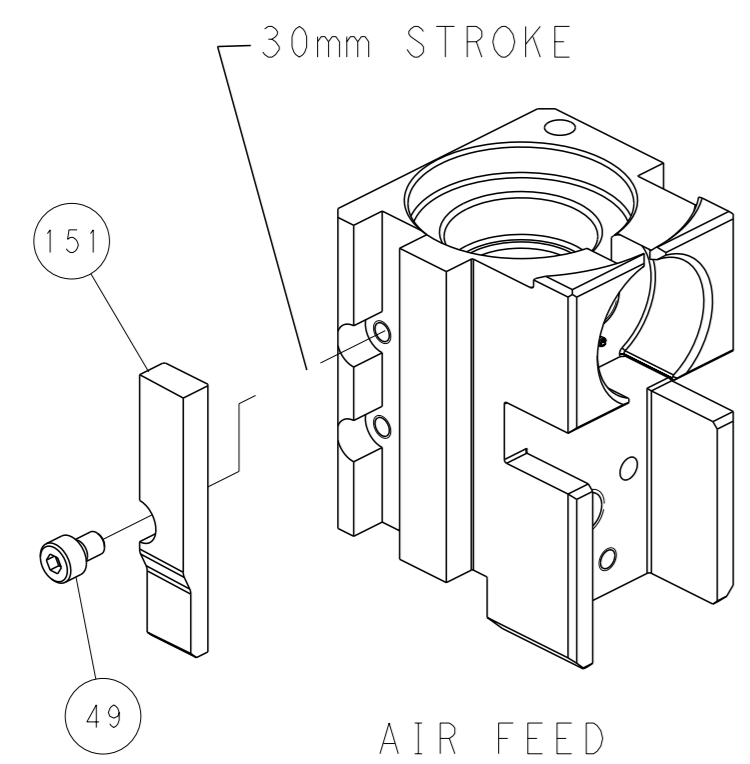


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

### CAM POSITION



**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 ITS CONTENTS ARE NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. O. WILSON CHK: K. J. STAKEM APVD: J. L. ELBIN	26DEC2014 29DEC2014 29DEC2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151991	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: B1
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		MATERIAL: - WEIGHT: - APPLICATION SPEC: - PRODUCT SPEC: -		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	