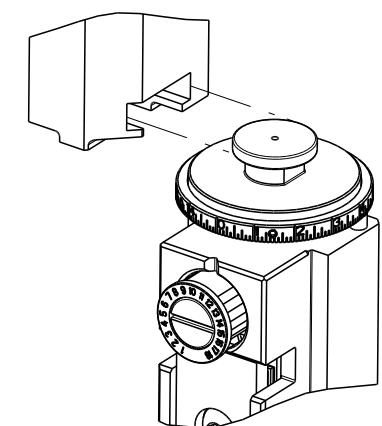


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151723-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151723-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151723-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

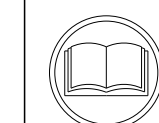


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.89 mm [.153]	F
INSUL	9.53 mm [.375]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: G&H TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MAK 8.0x0.8/9.5x1.2 Terminal			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.40-7.70 mm [.291-.303 IN]		Ø4.00-4.40 mm [.157-.173 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE SEAL	VW SEAL
1572996-1	28469.306.189	2113288-1	0211626A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.50 +/- 0.05 [.098 +/- .002]	6.8



- 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 180. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 APPLY TORO-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.
- 8 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.

**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	DWN	APVD
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		B		ECR-23-174150	03MAY2023	LG	RR

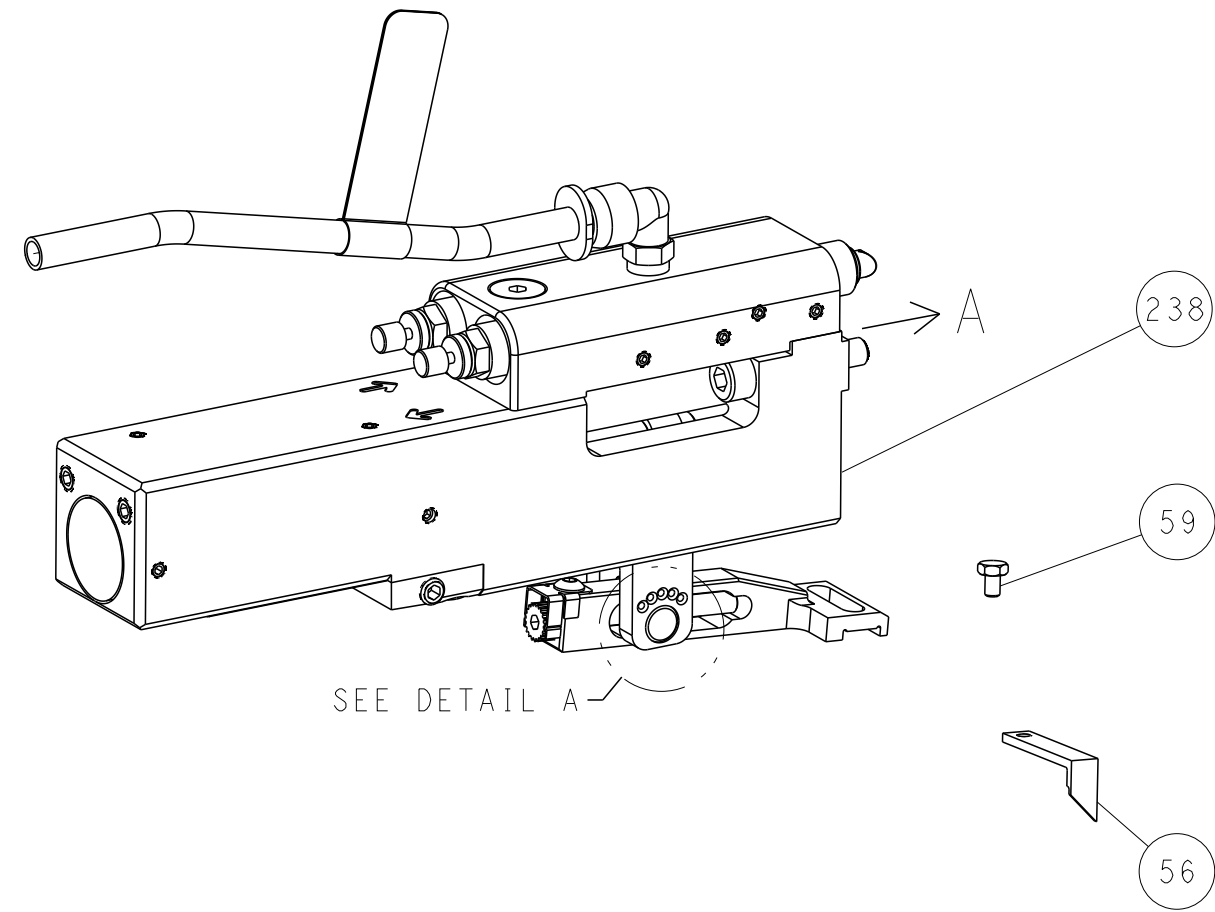
8	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1	1633782-3	FENCE	267
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	1	2844940-2	AIR FEED MODULE	238
3	-	1	1	2-1752354-6	STANDOFF, HOLD-DOWN	180
	-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	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	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	2-690438-2	FRONT STRIP GUIDE	96
	-	1	1	318563-1	GUARD, FRONT CHIP	89
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
	-	1	1	1803096-1	EXTENSION PLATE	78
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	1	2119943-1	WASHER, SPACER	69
	-	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	1338683-8	FEED PAWL	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	1901681-2	HOLDDOWN, TERMINAL	51
	-	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	1-1752356-1	SUPPORT, TERMINAL	34
	-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
	-	2	2	3-2844962-5	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	1320928-8	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	1803013-1	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	1-2119805-0	SHEAR HOLDER, FRONT	10
△	-	1	1	1-318059-0	FLOATING SHEAR, FRONT	9
△	1	2	1	1633930-9	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	1803080-1	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-7	BLOCK, CRIMPER SPACER	4
△	1	2	1	2-1633996-9	CRIMPER, INSULATION SPECIAL	3
	-	1	1	2-455888-5	SPACER, CRIMPER	2
△	1	2	1	7-1633609-2	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	01JAN2012	R. KNEPPER	01JAN2012	L. GROSS	01JAN2012	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
						A   00779		C=2151723		B	

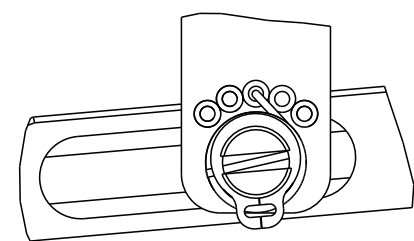
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1	-	-	-

### FEED TYPE

PNEUMATIC

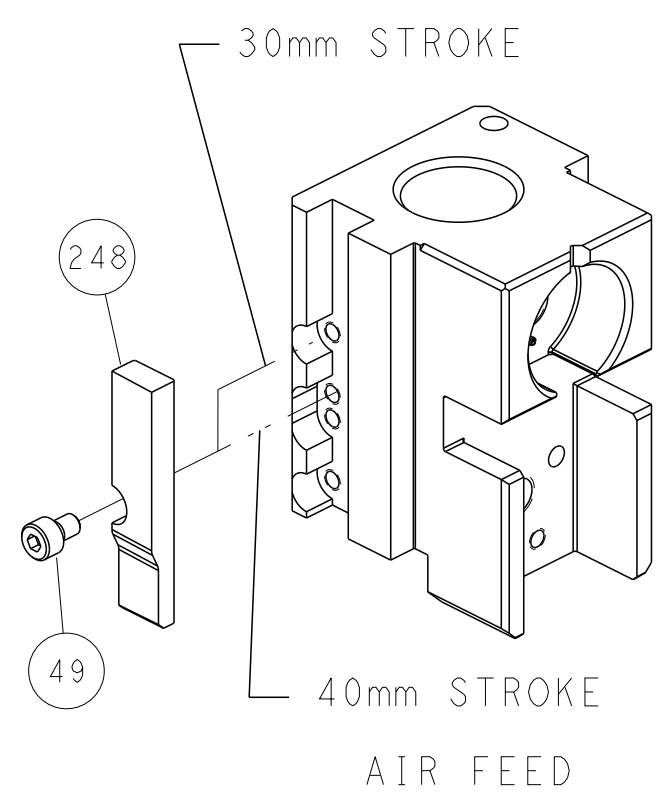


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

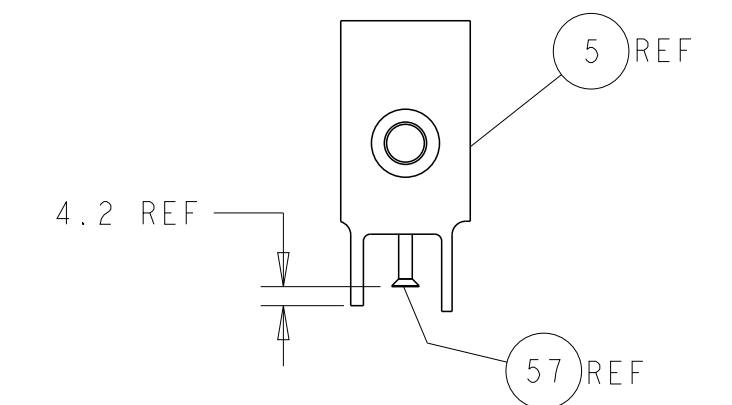
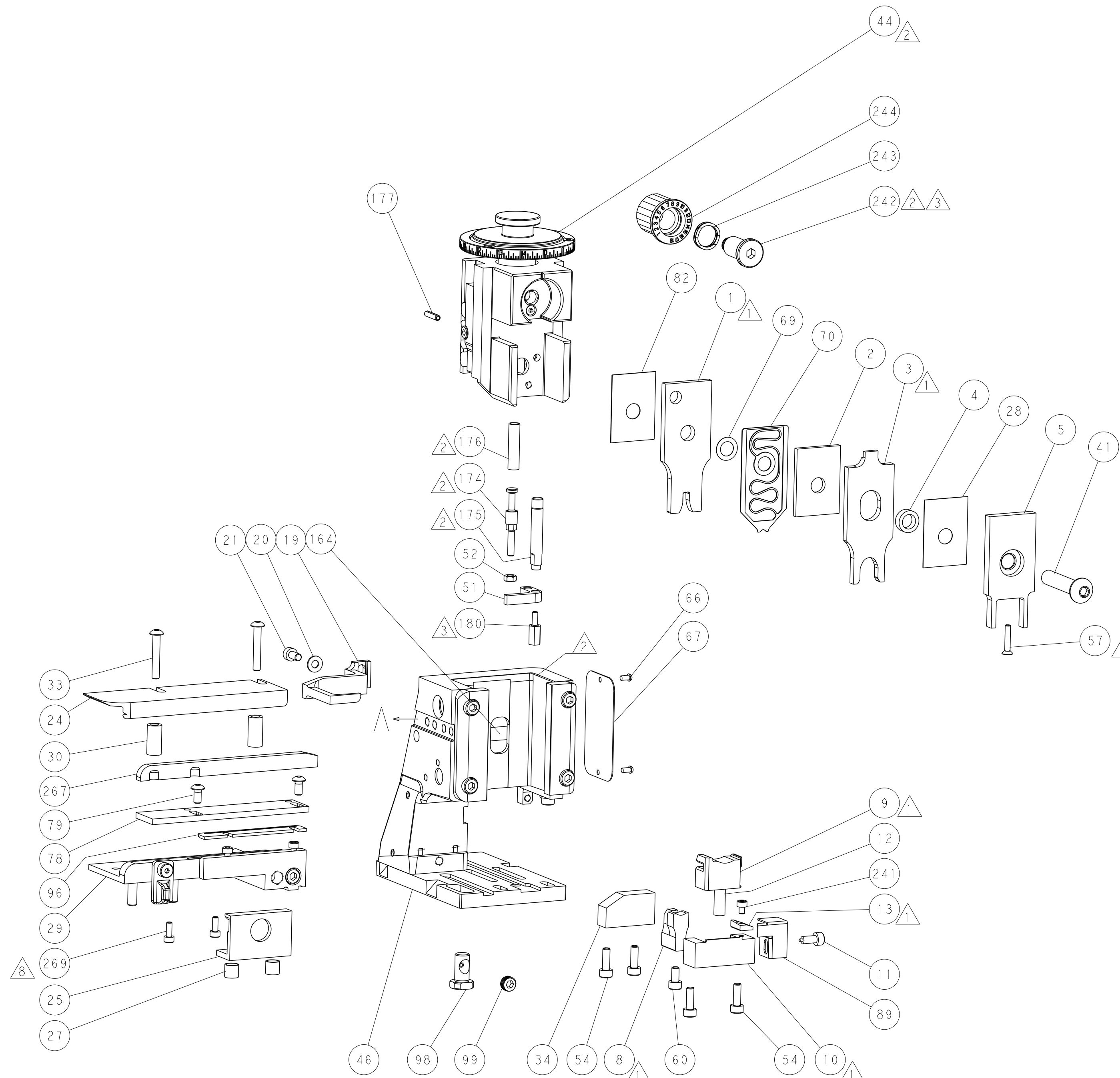


DETAIL A

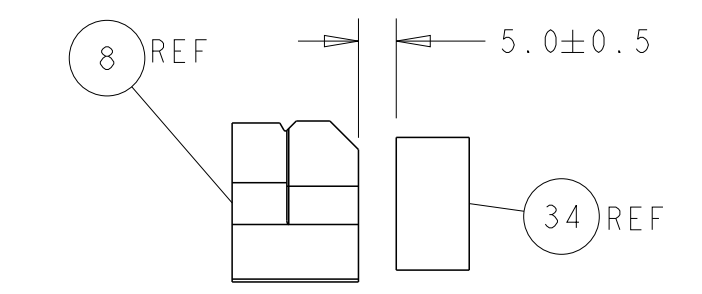
### CAM POSITION



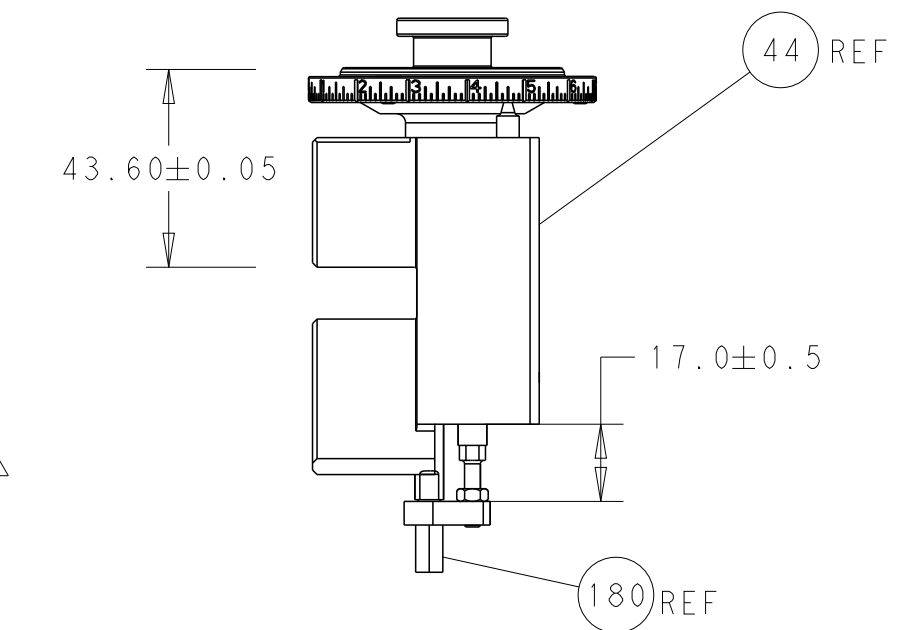
AIR FEED



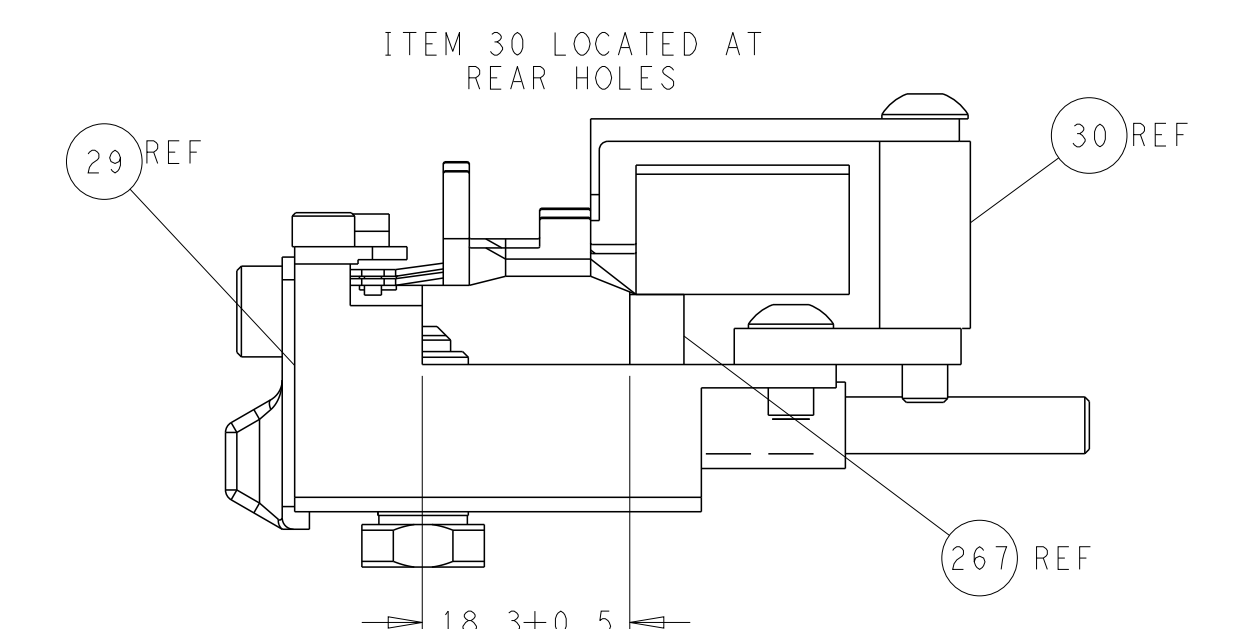
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



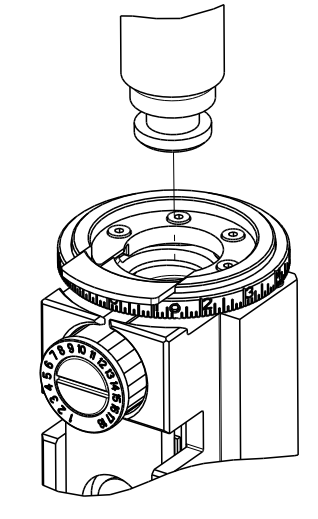
FEED TRACK POSITION GUIDE BY WIRE BARREL

**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. KNEPPER 01JAN2012 CHK: L. GROSS 01JAN2012 APVD: T. ELBIN 01JAN2012	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151723	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2	SHEET 2 OF 4 REV B	RESTRICTED TO: -

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151723-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151723-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.89 mm [1.53]	F
INSUL	9.53 mm [3.75]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: G&H TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MAK 8.0x0.8/9.5x1.2 Terminal			
WIRE STRIP LENGTH 7.40-7.70 mm [1.291-.303 IN]		INSULATION DIAMETER RANGE Ø4.00-4.40 mm [1.57-.173 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL 1572996-1	G&H TERMINAL 28469.306.189	TE SEAL 2113288-1	G&H SEAL 0211626A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm <sup>2</sup>	2.50+/-0.05 [1.098+/-0.02]	6.8



- 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 180. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 APPLY TORO-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.
- 8 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.

**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

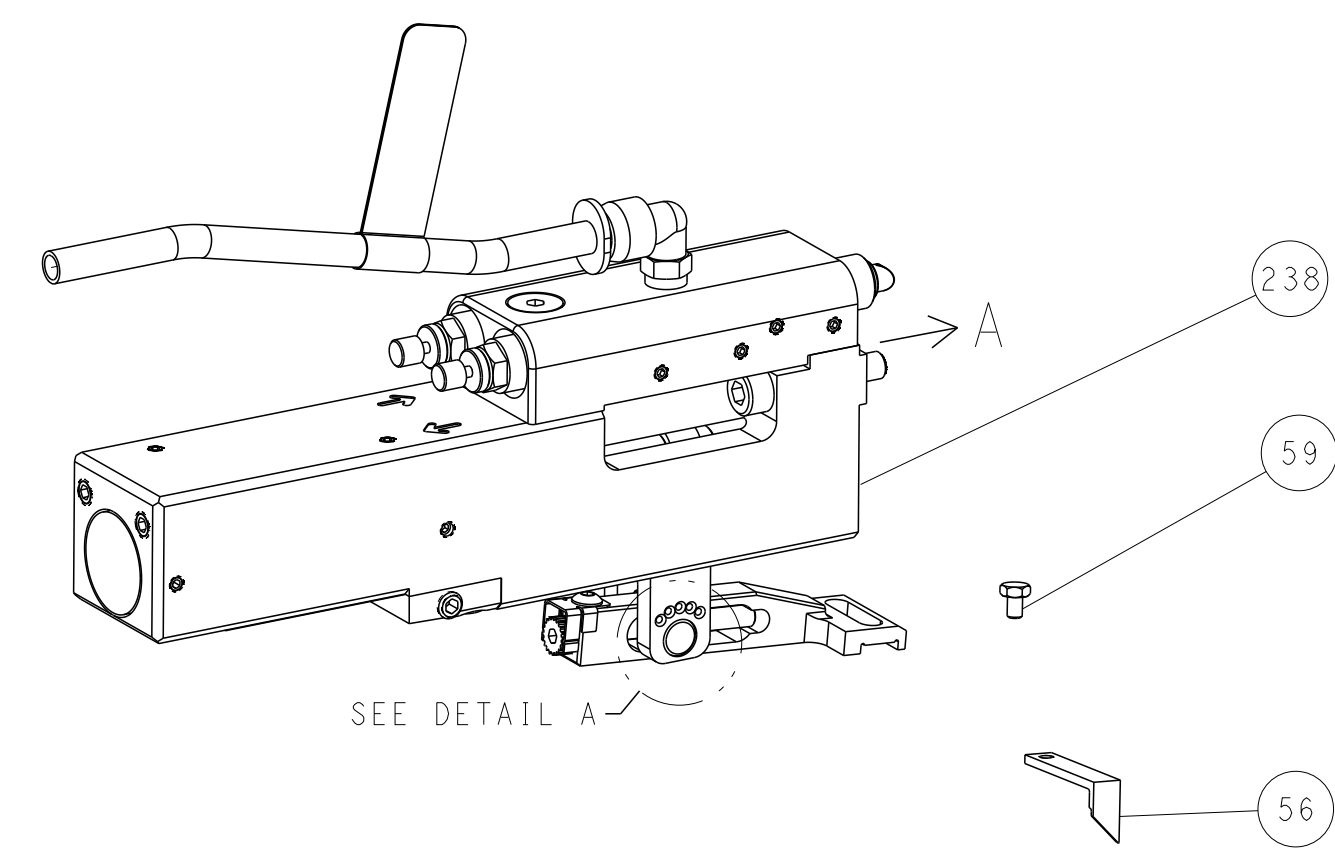
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

8	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	-	1	1633782-3	FENCE	267
-	-	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
3	-	1	2-1752354-6	STANDOFF,HOLD-DOWN	180
-	-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	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	1-1803583-8	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	2-690438-2	FRONT STRIP GUIDE	96
-	-	1	318563-1	GUARD, FRONT CHIP	89
-	-	1	455888-4	SPACER, CRIMPER	82
-	-	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	-	1	1803096-1	EXTENSION PLATE	78
-	-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	-	1	2119791-9	DEPRESSOR, WIRE	70
-	-	1	2119943-1	WASHER, SPACER	69
-	-	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	-	1	985575-5	SCR, FLT SKT HD CAP M3 X 16.0	57
-	-	1	1338683-8	FEED PAWL	56
-	-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	1	1901681-2	HOLDDOWN, TERMINAL	51
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	-	1	1-1752356-1	SUPPORT, TERMINAL	34
-	-	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	-	2	3-2844962-5	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	1320928-8	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	1803013-1	STRIPPER, SIDE FEED	19
1	-	1	2119806-1	INSERT, SHEAR	13
-	-	1	3-22280-3	SPRING, COMPRESSION	12
-	-	1	1-356885-3	STOP, SHEAR	11
1	-	1	1-2119805-0	SHEAR HOLDER, FRONT	10
1	-	1	1-318059-0	FLOATING SHEAR, FRONT	9
1	1	1	1633930-9	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	-	1	1803080-1	DEPRESSOR, SHEAR	5
-	-	1	2-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	2-1633996-9	CRIMPER, INSULATION SPECIAL	3
-	-	1	2-455888-5	SPACER, CRIMPER	2
1	1	1	7-1633609-2	CRIMPER, WIRE	1
-77	-22	PART NO		DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A	00779	©=2151723	3	4	B
Customer Accessible Production Drawing															

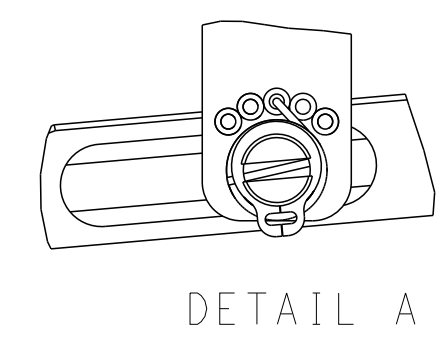
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

### FEED TYPE PNEUMATIC



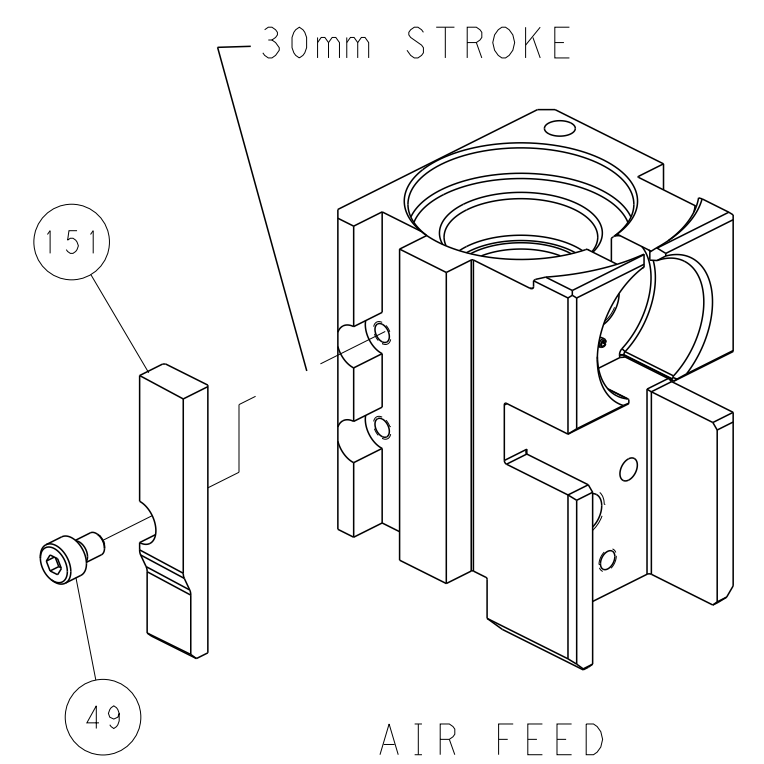
SEE DETAIL A

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

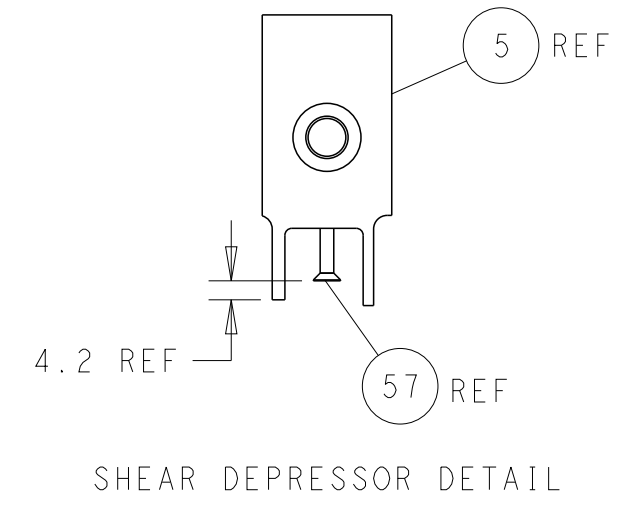
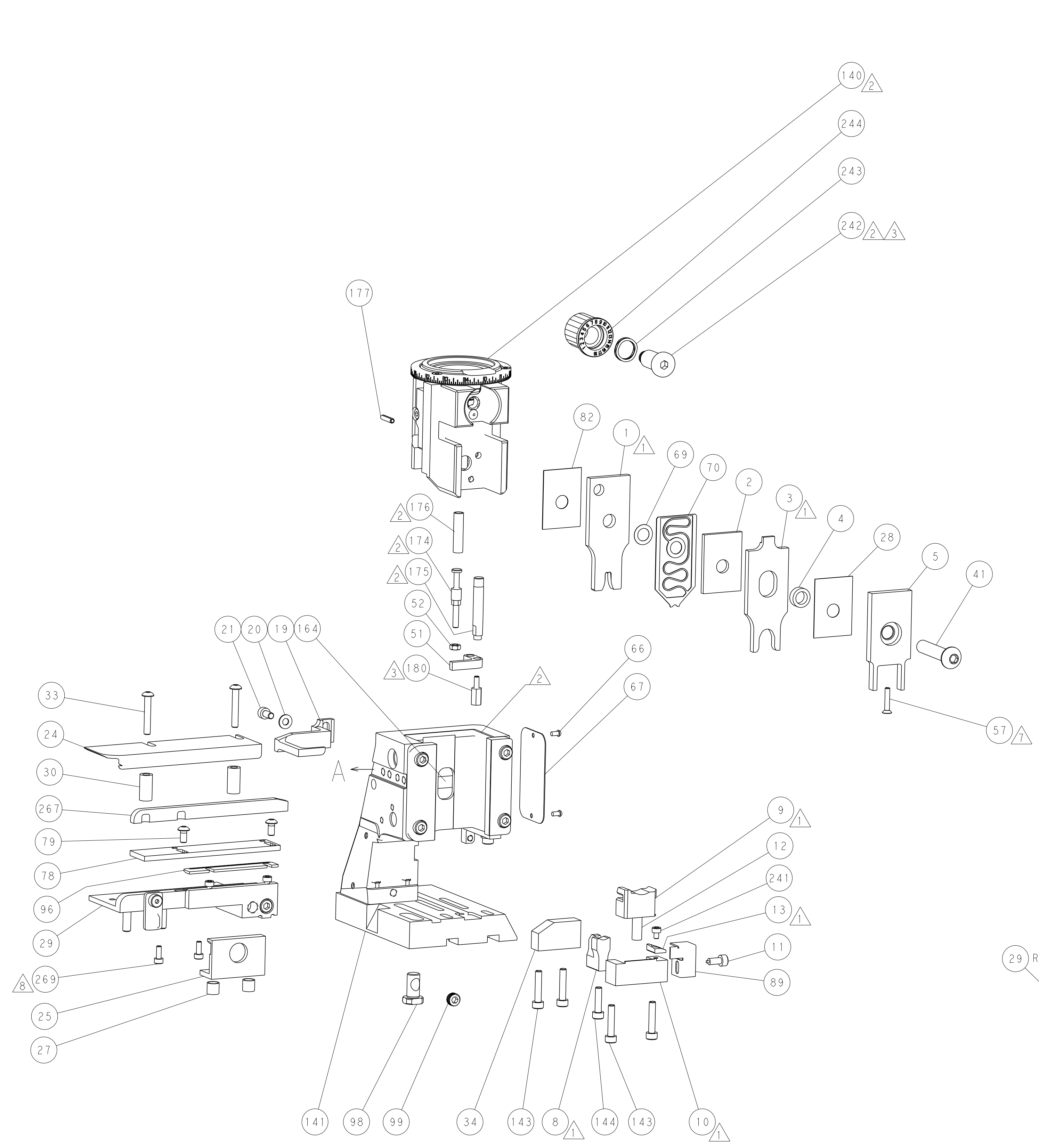


DETAIL A

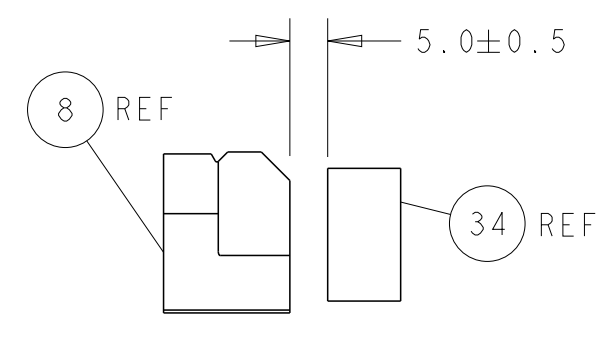
### CAM POSITION



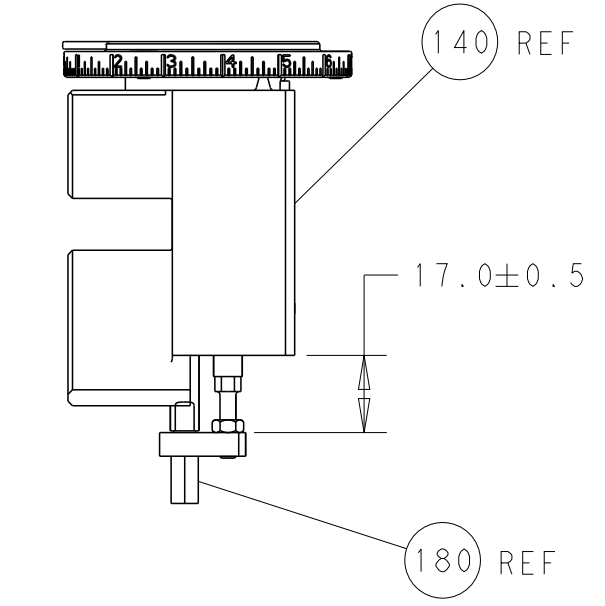
AIR FEED



SHEAR DEPRESSOR DETAIL

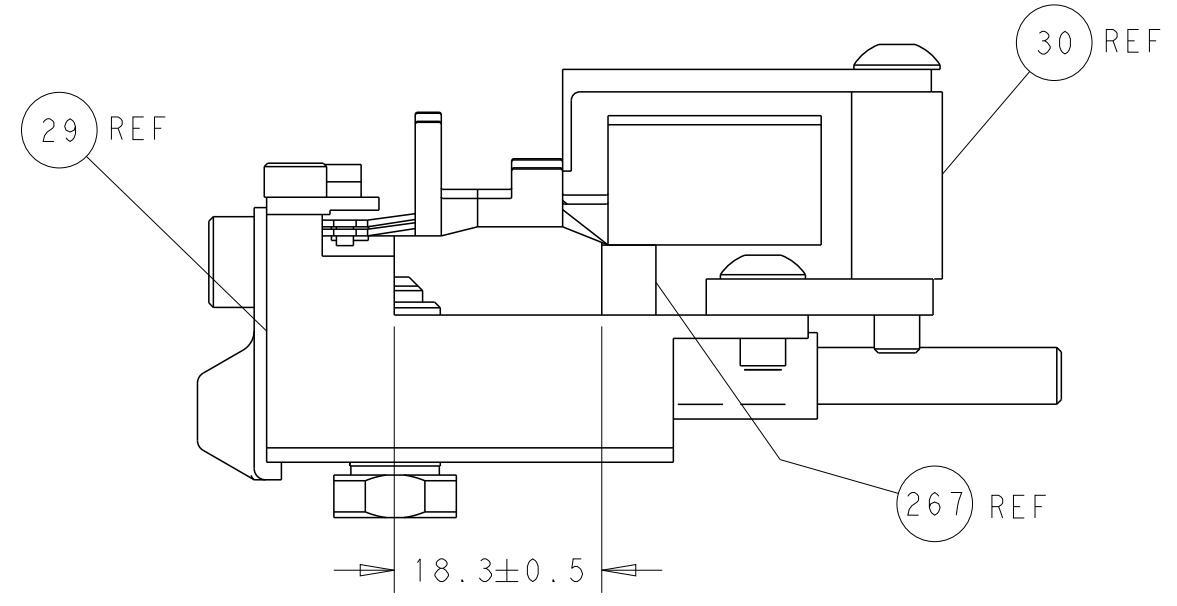


TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

**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 UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE POLICY OF TYCO ELECTRONICS CORPORATION TO CONTINUE TO IMPROVE ITS PRODUCTS. THEREFORE, THIS DRAWING IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER ASSUMES ALL RESPONSIBILITY FOR THE LATEST REVISION.</small>		DWN: R. KNEPPER 01JAN2012 CHK: L. GROSS 01JAN2012 APVD: T. ELBIN 01JAN2012	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151723	RESTRICTED TO: B
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	APPLICATION SPEC: - WEIGHT: - SCALE: 1:2 SHEET: 4 OF 4 REV: B	CUSTOMER ACCESSIBLE PRODUCTION DRAWING		