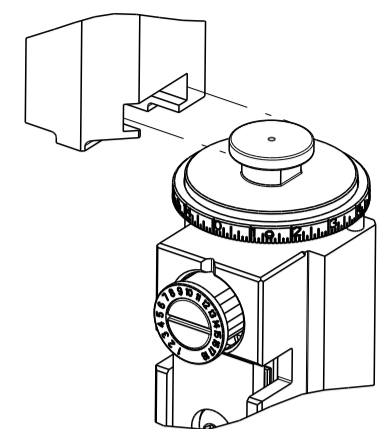


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151661-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151661-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151661-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.19 mm [.165]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JPT LITEALUM CONTACT, SWS			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.20-4.80 mm [.165-.189 IN]		Ø2.88-3.04 mm [.113-.120 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94204	-	-
TERMINALS APPLIED <sup>5</sup>			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2-2208043-1		963292-1	
			SEAL INSULATION DIAMETER RANGE
			2.0-2.7mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.56+/-0.04 [.0614+/- .0016]	7.5



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- <sup>3</sup> APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- <sup>4</sup> 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.
- <sup>5</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>6</sup> 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.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

**\*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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	F		ECR-15-015265	19OCT2015	MR	JDG
		G		ECR-18-018240	21NOV2018	MZ	KZ
		H		ECR-19-000059	03JAN2019	RK	GB

-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-7	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	2063440-1	AIR FEED MODULE	238
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	240638-1	SPRING, FEED FINGER	163
-	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-2	SPACER, CRIMPER	82
-	1	1	1803607-1	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	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	1803382-7	HOLD DOWN, SPRING LOADED	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2-1803583-3	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	690472-2	STRIPPER	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	1803318-1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	1633996-3	CRIMPER, INSULATION SPECIAL	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	2	456407-5	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL		FINISH		WEIGHT		SCALE	
-		-		-		1:2	

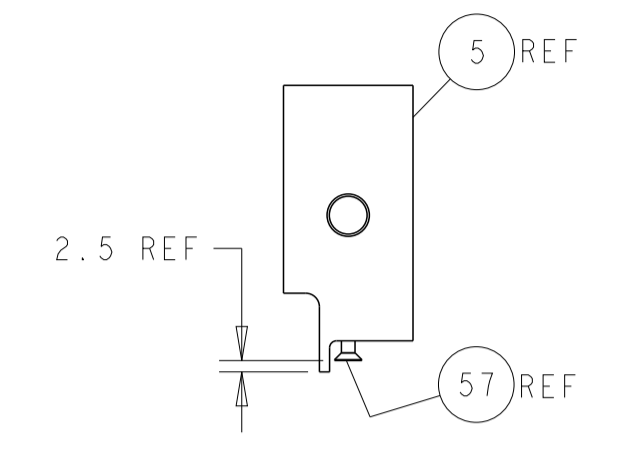
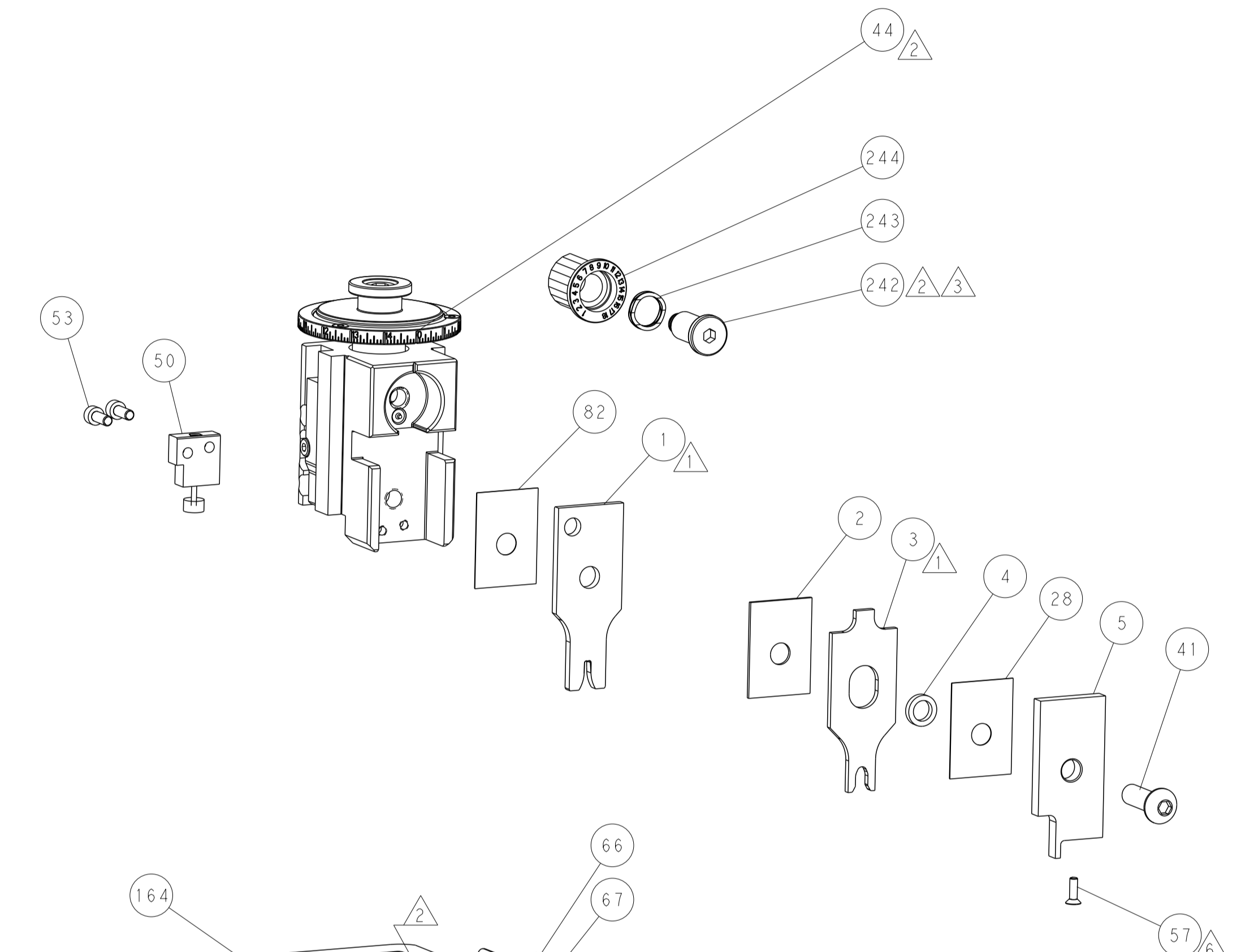
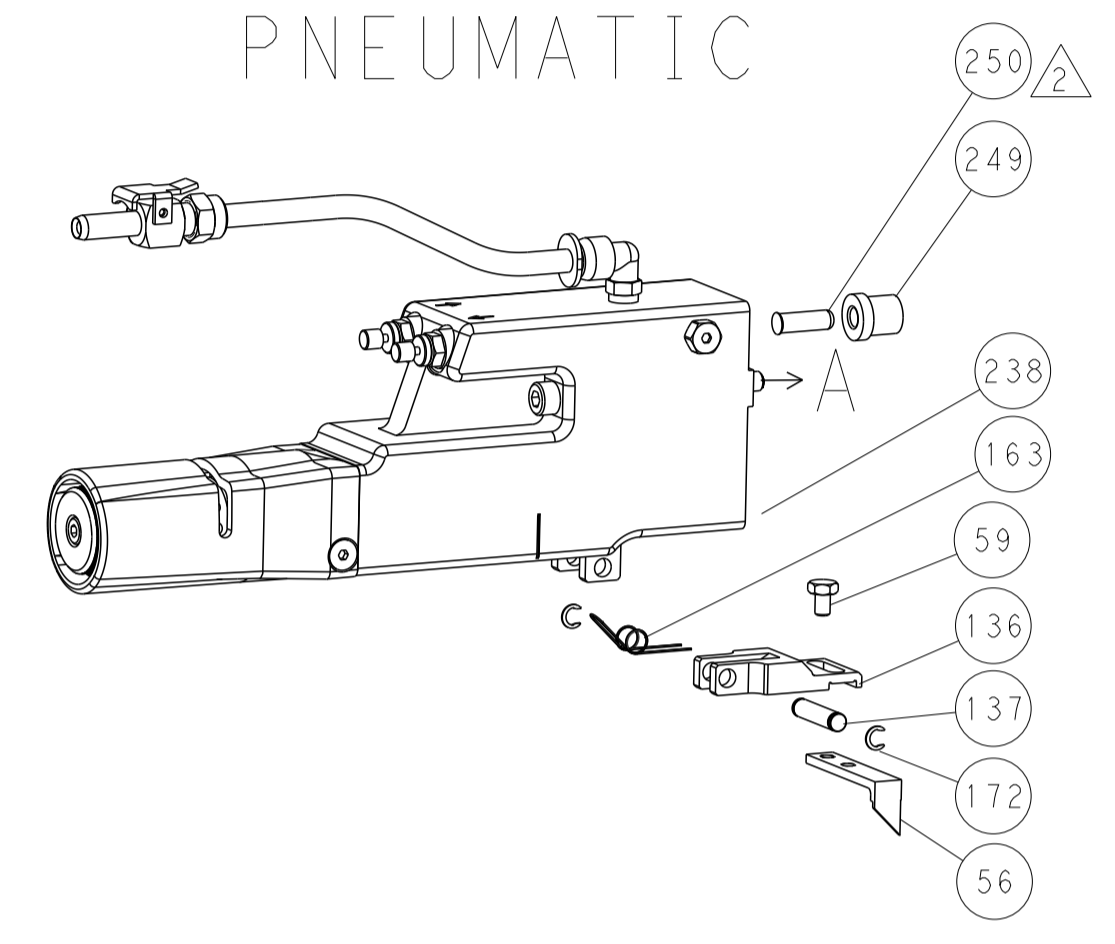
OWN	CHK	APVD	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Y. YIN	G. BAILEY	S. XI	16MAY2012	G. BAILEY	A1	00779	2151661	-

Customer Accessible Production Drawing

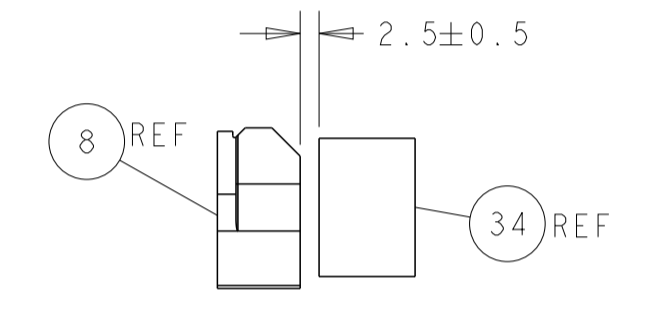
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

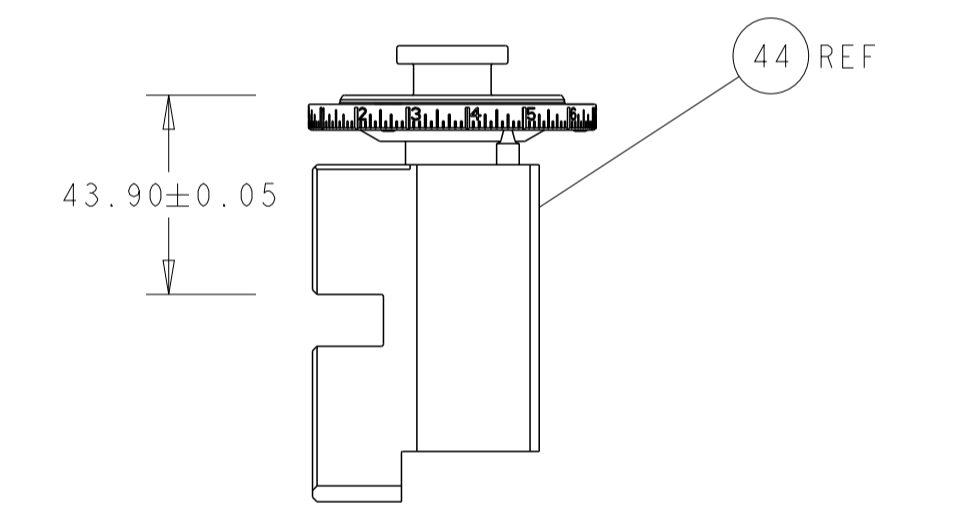
### FEED TYPE PNEUMATIC



SHEAR DEPRESSOR DETAIL

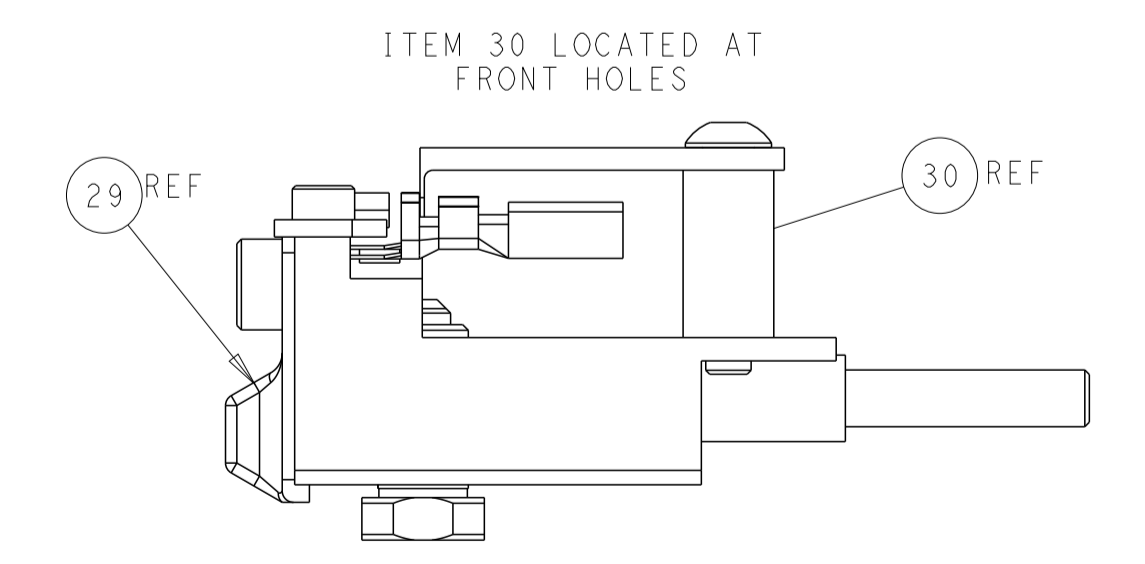
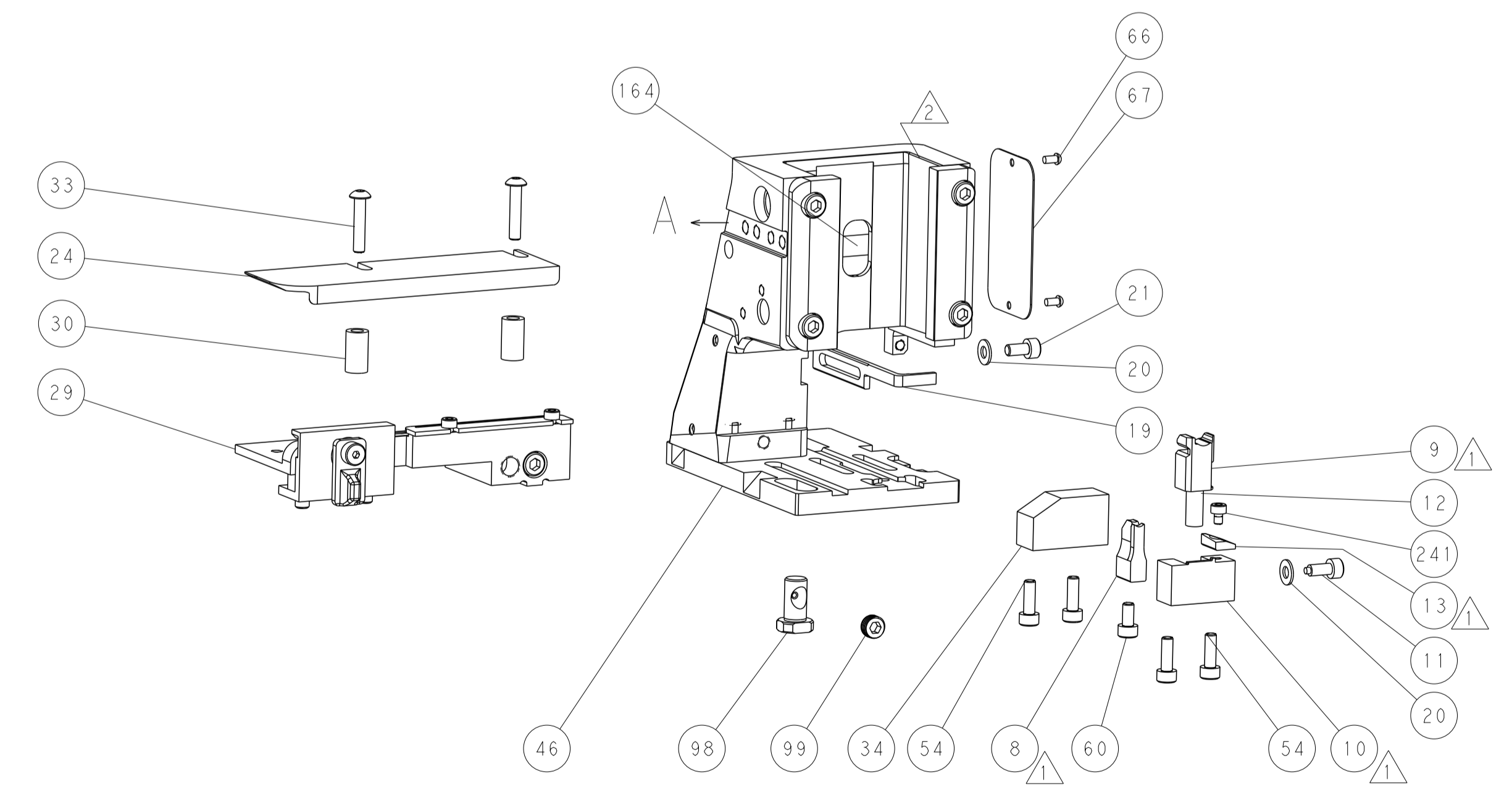
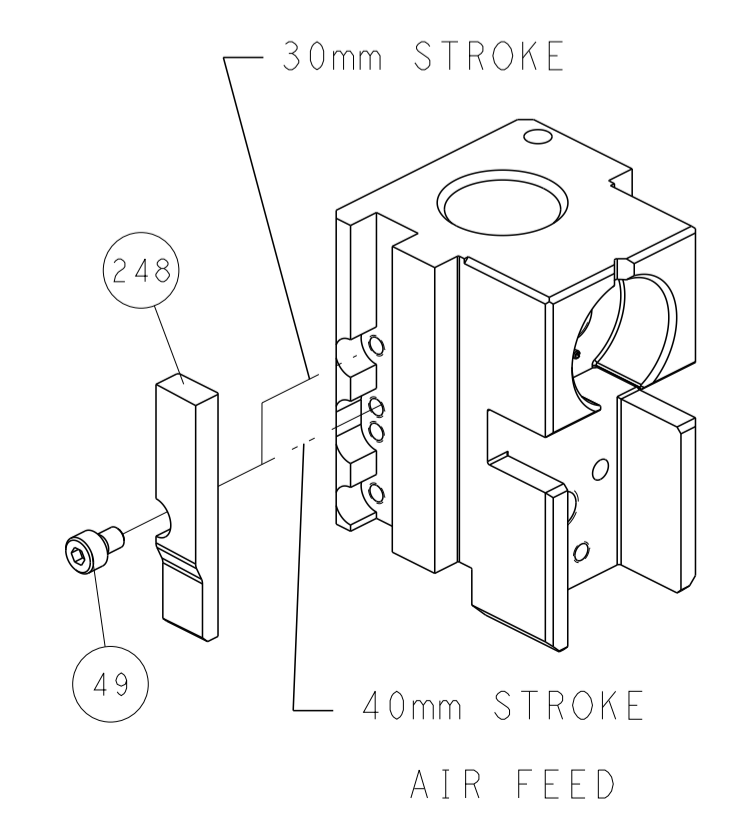


TERMINAL SUPPORT LOCATION



RAM SET-UP

### CAM POSITIONS



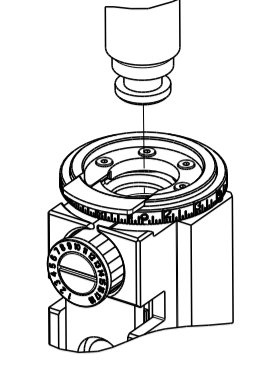
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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:		DWN Y. YIN 16MAY2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean Side Feed Applicator	
ANGLES	FINISH	MATERIAL		WEIGHT		RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2 OF 4	REV H	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151661-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151661-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.19 mm [.165]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: JPT LITEALUM CONTACT, SWS		
WIRE STRIP LENGTH 4.20-4.80 mm [.165-.189 IN]		TERMINAL INSULATION DIAMETER RANGE Ø2.88-3.04 mm [.113-.120 IN]
TERMINAL APPLICATION SPECIFICATION 114-94204	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
2-2208043-1		963292-1		2.0-2.7mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.56+/-0.04 [.0614+/- .0016]	7.5



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

**\*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				

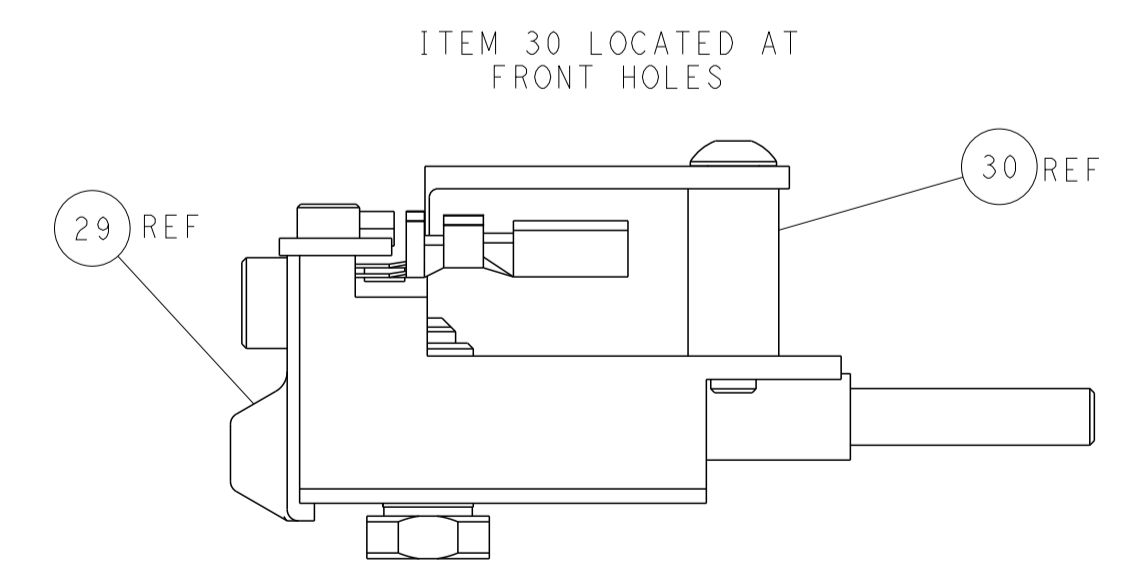
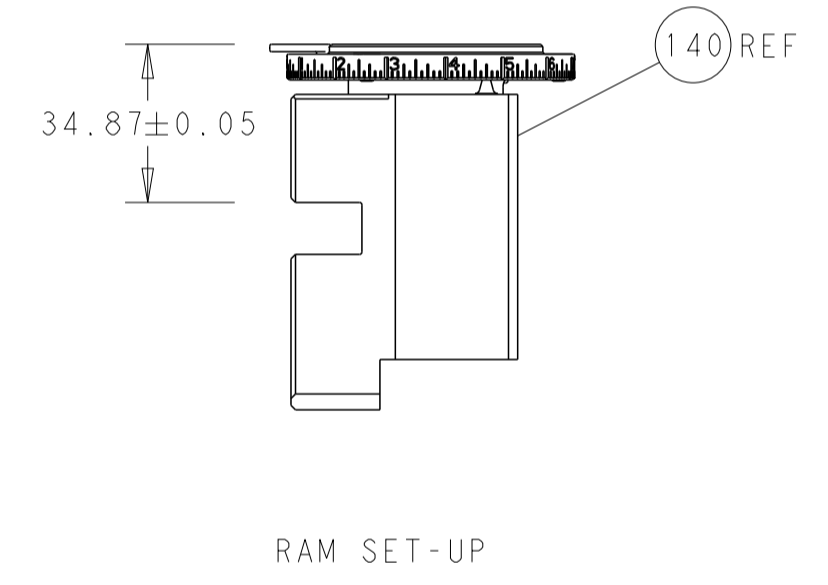
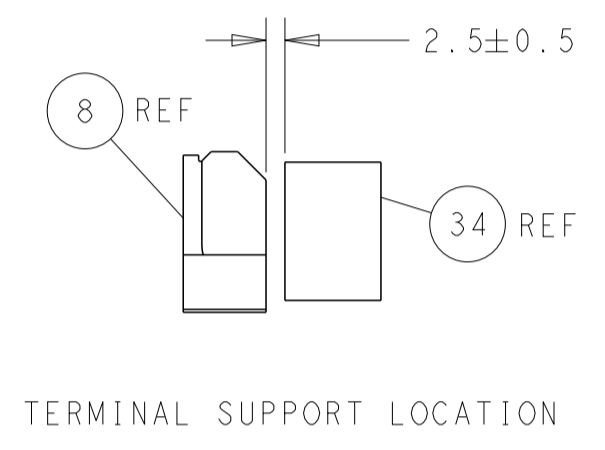
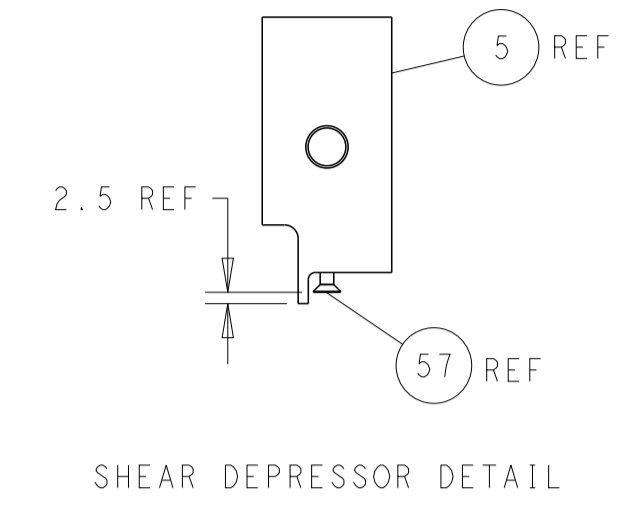
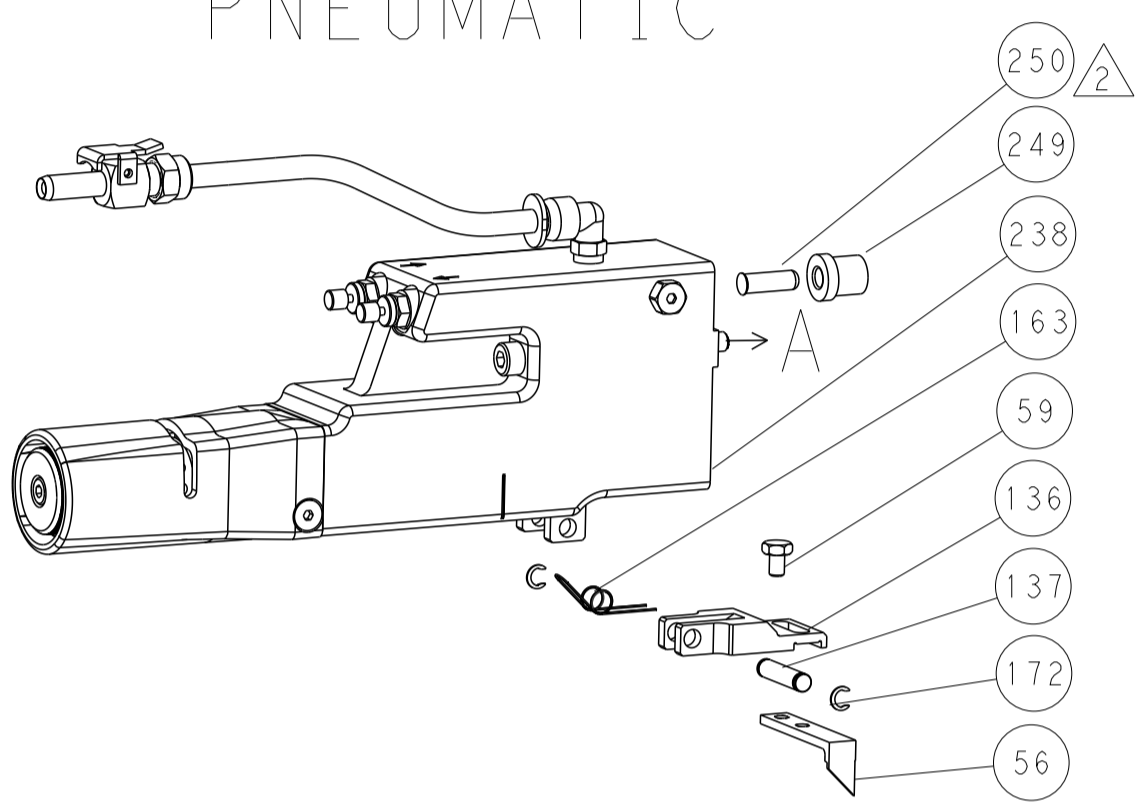
REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV		
-	1			2119640-1				PUSH ROD, AIR FEED	250
-	1			1803259-1				BUSHING, FLANGED	249
-	1			2119082-7				CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1			2079764-1				WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-			2119083-1				RETAINER, INSULATION DIAL	242
-	1			7-18023-7				SCR, SKT HD CAP M3 X 4.0	241
-	1			2063440-1				AIR FEED MODULE	238
-	2			21045-3				RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF			994970-2				COUNTER, MAGNETIC	164
-	1			240638-1				SPRING, FEED FINGER	163
-	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			2-1803583-4				APPLICATOR BASIC ASSEMBLY, SF	141
-	1			1803516-1				RAM ASSEMBLY, SF PACIFIC	140
-	1			3-23627-7				PIN, RETAIN, GRVD, 3/16 X .854	137
-	1			2119799-1				HOLDER, FEED FINGER, AF	136
-	1			2844908-1				SCREW, LOCKING	99
-	1			2844907-1				POST, LOCKING	98
-	1			455888-2				SPACER, CRIMPER	82
-	1			1803607-1				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
6	-			985575-3				SCR, FLT SKT HD CAP M3 X 10.0	57
-	1			1338685-1				PAWL, FEED	56
-	2			1-2168083-0				SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1			1803382-7				HOLD DOWN, SPRING LOADED	50
-	1			18023-9				SCR, SKT HD CAP M4 X 6.0	49
-	1			1803602-1				SCR, BHSC, RoHS (M8 X 25)	41
-	1			1752356-4				SUPPORT, TERMINAL	34
-	2			2079383-5				SCR, BHSC, RoHS (M4 X 20)	33
-	2			2-2844962-8				SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1			2844992-1				ASSEMBLY, STRIP GUIDE	29
-	1			455888-3				SPACER, CRIMPER	28
-	1			1320928-2				STRIP GUIDE	24
-	1			2168083-2				SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2			1-18028-2				WASHER, FLAT, REG M4	20
-	1			690472-2				STRIPPER	19
-	1			2119806-1				INSERT, SHEAR	13
-	1			3-22280-3				SPRING, COMPRESSION	12
-	1			1-356885-4				STOP, SHEAR	11
-	1			2119805-1				SHEAR HOLDER, FRONT	10
-	1			318707-1				FLOATING SHEAR, FRONT	9
1	1			1803318-1				ANVIL, COMBINATION	8
-	-			-				-	7
-	-			-				-	6
-	1			2119781-5				DEPRESSOR, SHEAR	5
-	1			238011-4				BLOCK, CRIMPER SPACER	4
1	1			1633996-3				CRIMPER, INSULATION SPECIAL	3
-	1			1-455888-0				SPACER, CRIMPER	2
1	1			456407-5				CRIMPER, WIRE PREMIUM	1

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

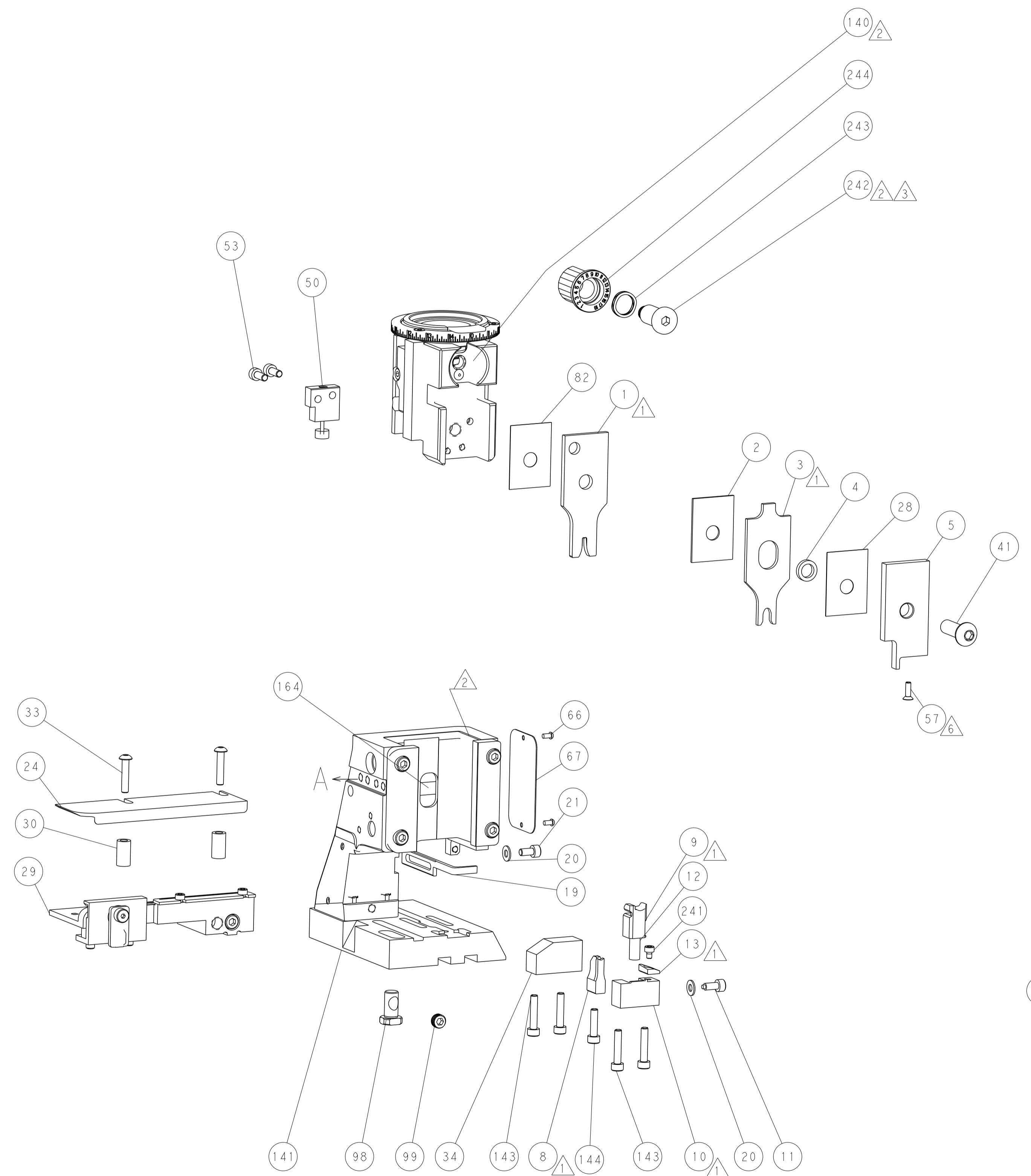
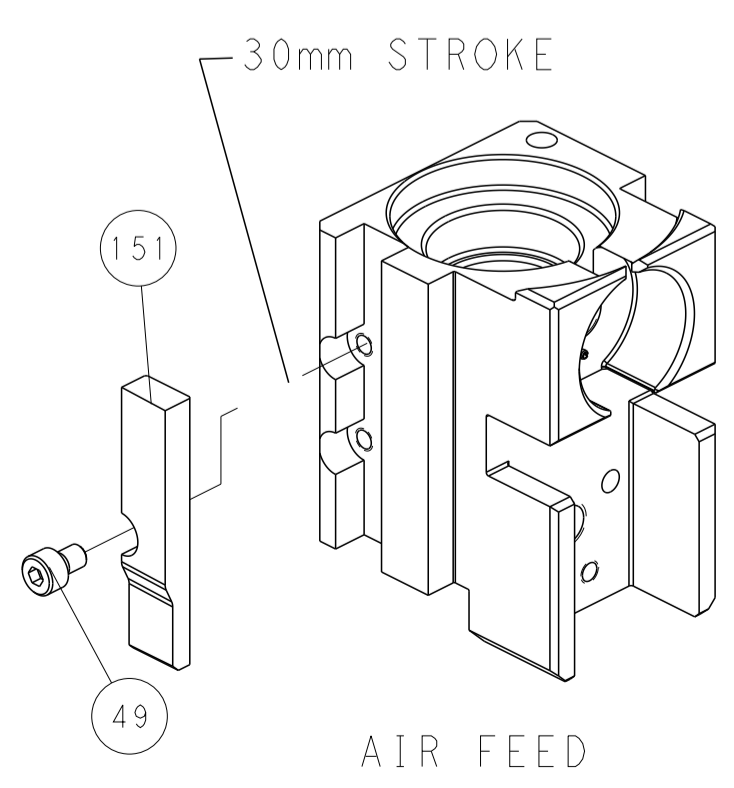
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	DATE	NAME	DESCRIPTION	ITEM NO
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	Y. YIN	16MAY2012	G. BAILEY	TE Connectivity Harrisburg, PA 17105-3608	
		S. XI	16MAY2012		Ocean Side Feed Applicator	
MATERIAL	FINISH	APVD		SCALE	1:2	SHEET 3 OF 4
		WEIGHT		Customer Accessible Production Drawing		REV H

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

### FEED TYPE PNEUMATIC



### CAM POSITIONS



**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. ALL RIGHTS RESERVED. © 2000 BY TYCO ELECTRONICS CORPORATION. THIS IS THE PROPERTY OF COMPANY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM TYCO ELECTRONICS CORPORATION.</small>		DWN Y. YIN 16MAY2012	NAME Ocean Side Feed Applicator
DIMENSIONS: mm 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 ±	CHK G. BAILEY 16MAY2012
MATERIAL: .		APVD S. XI 16MAY2012	RESTRICTED TO SCALE 1:2
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		WEIGHT .	SHEET 4 OF 4