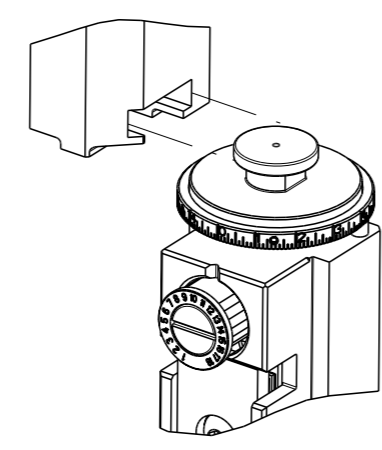


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151859-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151859-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151859-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151859-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151859-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR  
 INTERFACE ADAPTER



LOC	DIST	REVISIONS					
A	66	REV	LYR	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	27FEB2013	L.Z	U.G
		B		ECR-19-006947	01MAY2019	LG	TE

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.33 mm [.092]	F
INSUL	3.05 mm [.120]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: 090 TERMINAL MALE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.50-5.50 mm [.177-.217 IN]	Ø1.60-2.20 mm [.063-.087 IN]		
TERMINAL APPLICATION SPECIFICATION	T-001-0		
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
1642170-1	8230-4282		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: 090 TERMINAL FEMALE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.50-5.50 mm [.177-.217 IN]	Ø1.60-2.20 mm [.063-.087 IN]		
TERMINAL APPLICATION SPECIFICATION	T-001-0		
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
1832246-1	8240-4422		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.45+/-0.05 [.057+/-0.002]	3.7
0.85mm2	1.35+/-0.05 [.053+/-0.002]	4.7
0.50mm2	1.25+/-0.05 [.049+/-0.002]	5.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.30+/-0.05 [.051+/-0.002]	5.3
0.85mm2	1.20+/-0.05 [.047+/-0.002]	6.3
0.50mm2	1.10+/-0.05 [.043+/-0.002]	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. 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.

-	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	1	1	2119082-7	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	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	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	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-8	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	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	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	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	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	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-4	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	2-1633932-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1-1633961-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2	
-	1	2	2	1	1	1673600-2	CRIMPER, WIRE	1
-	77	72	71	-2	-1	PART NO	ITEM NO	

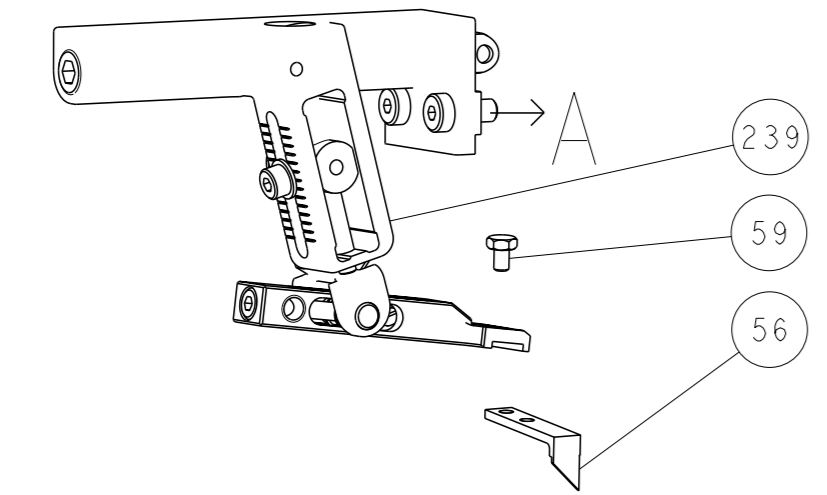
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	CHK	DATE	TE Connectivity
mm	0 PLC ±	L. ZHANG	L. ZHANG	25JAN2013	Harrisburg, PA 17105-3608
	1 PLC ±	L. ZHANG	L. ZHANG	25JAN2013	
	2 PLC ±	APVD		25JAN2013	
	3 PLC ±	PRODUCT SPEC			
	4 PLC ±	APPLICATION SPEC			
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV
			1:2	1 of 4	B

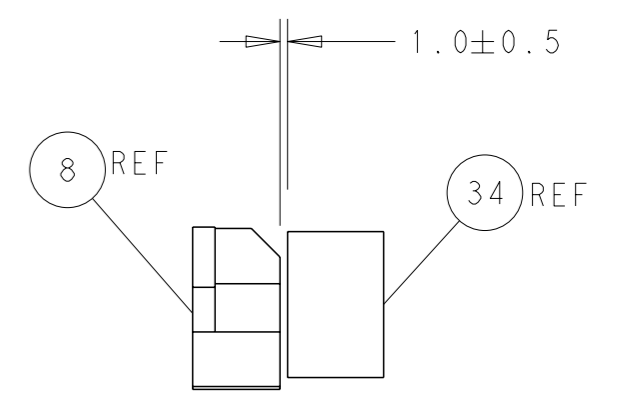
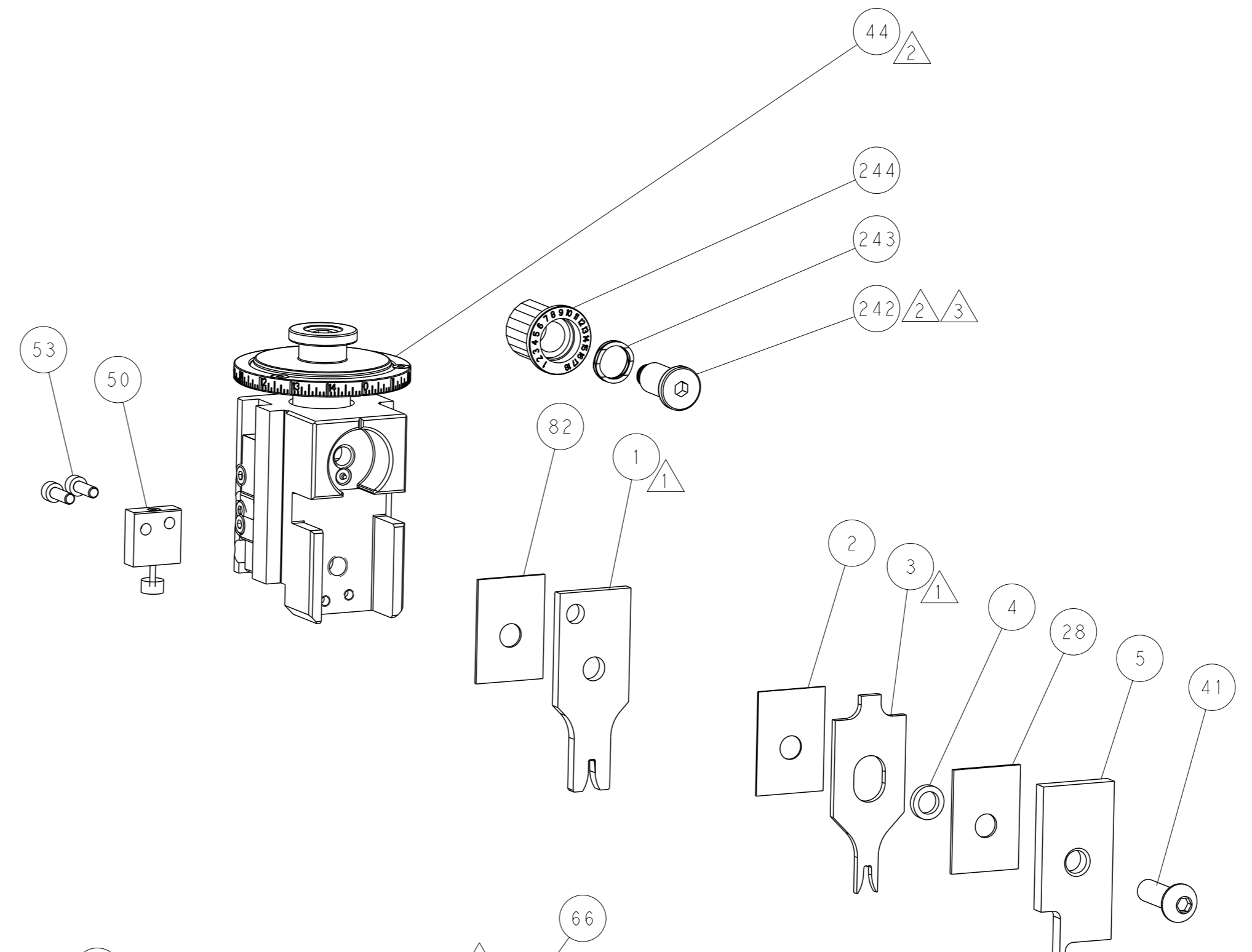
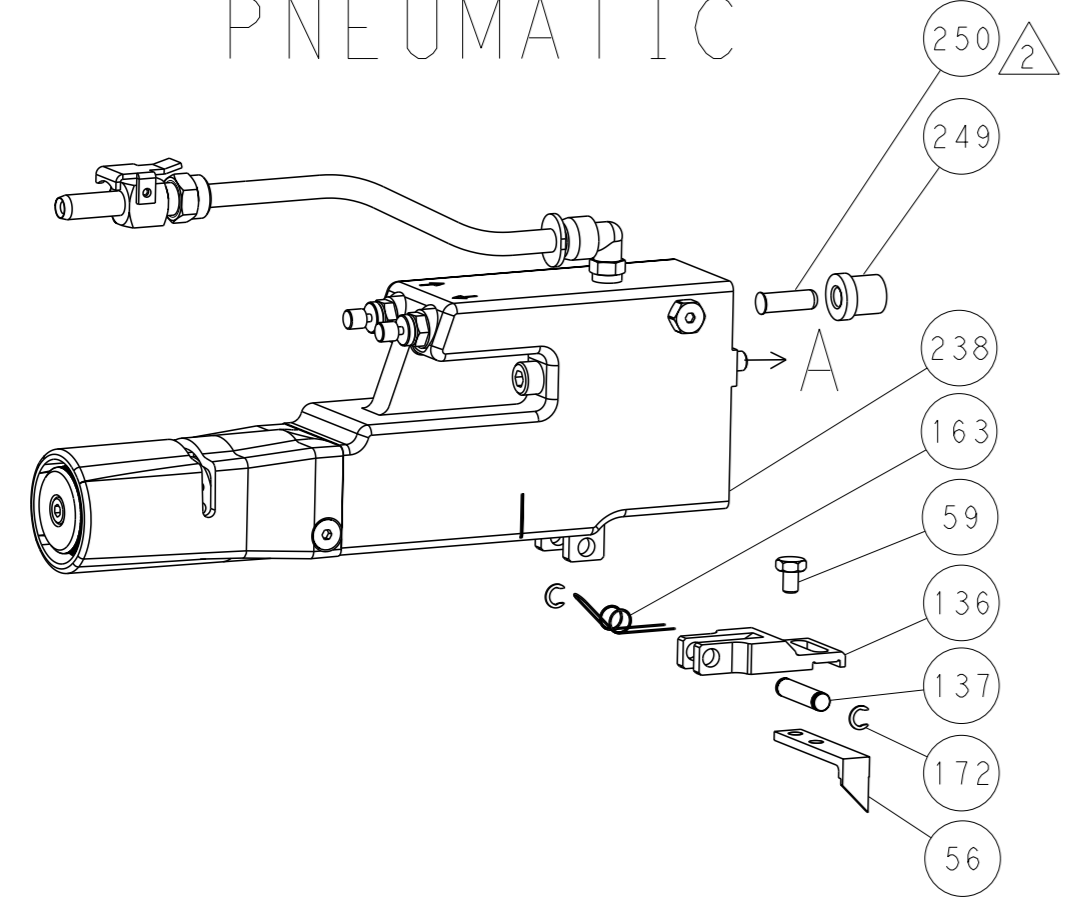
Customer Accessible Production Drawing

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

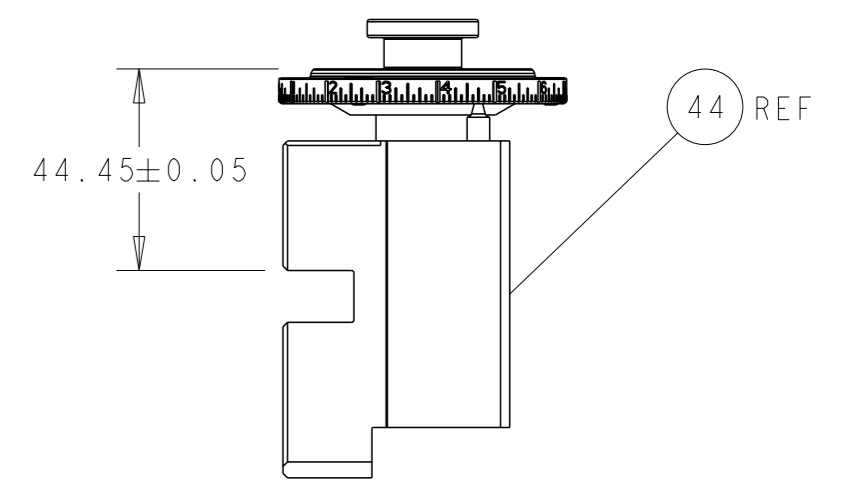
# FEED TYPE MECHANICAL



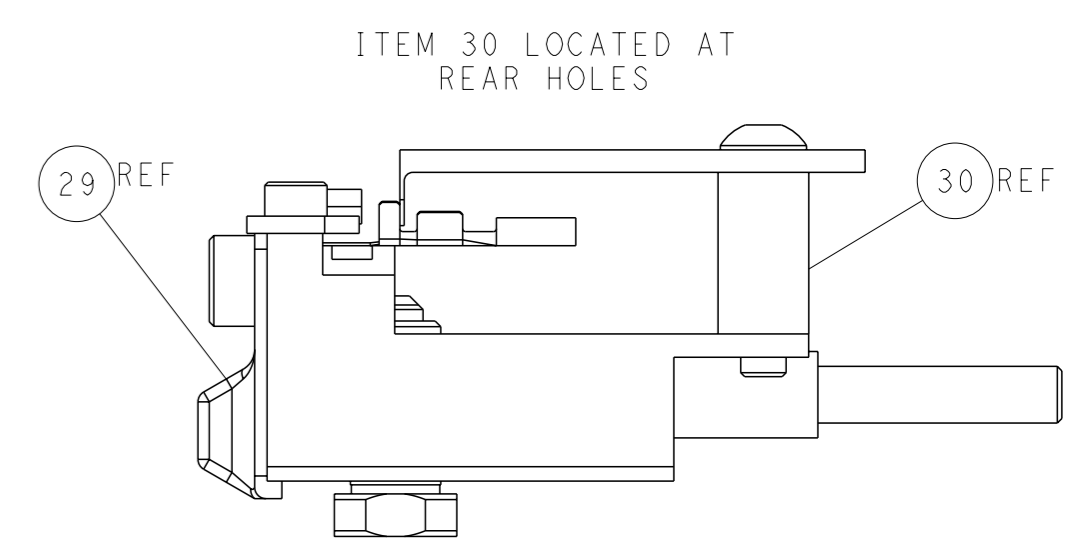
# PNEUMATIC



TERMINAL SUPPORT LOCATION

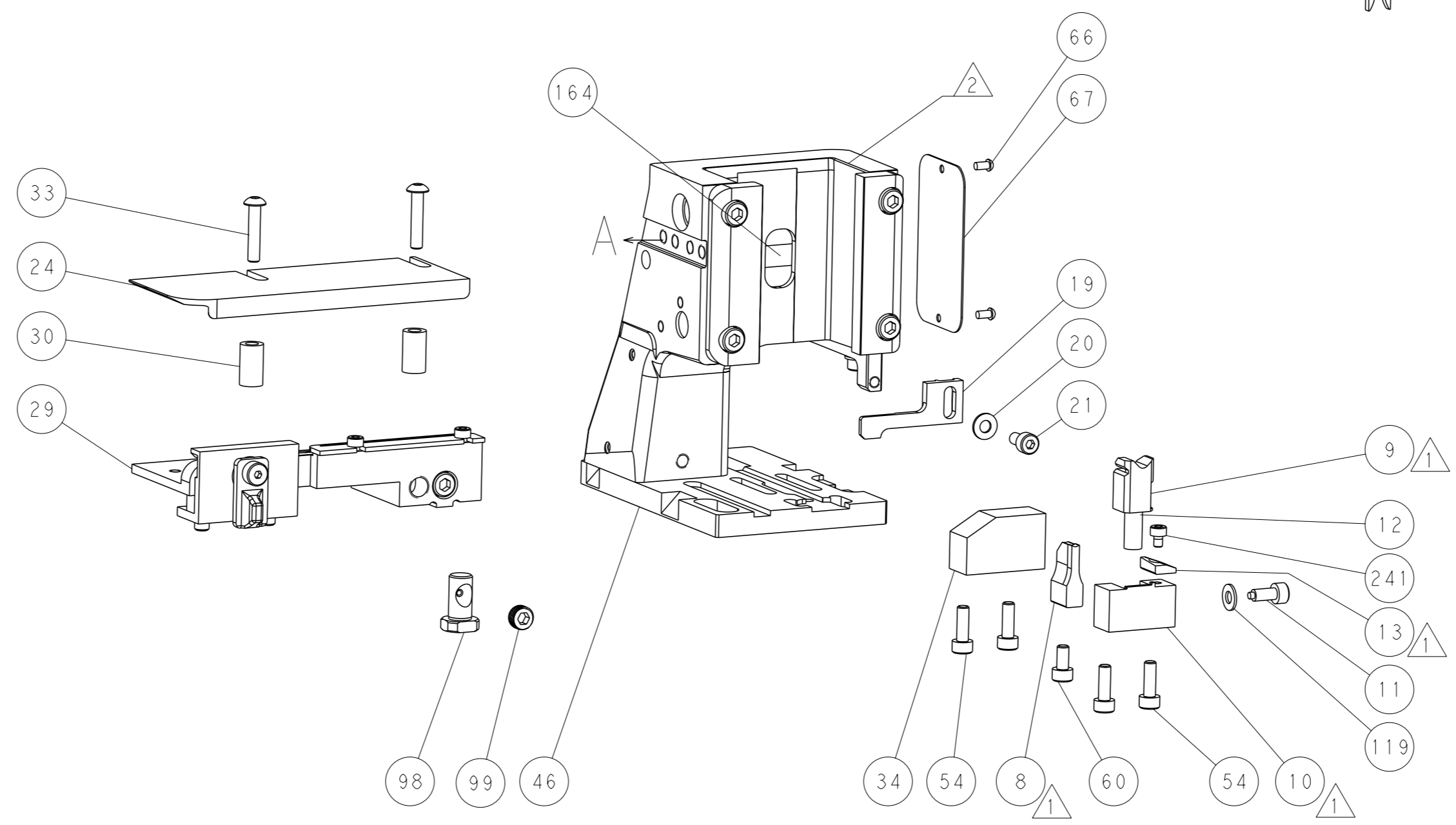
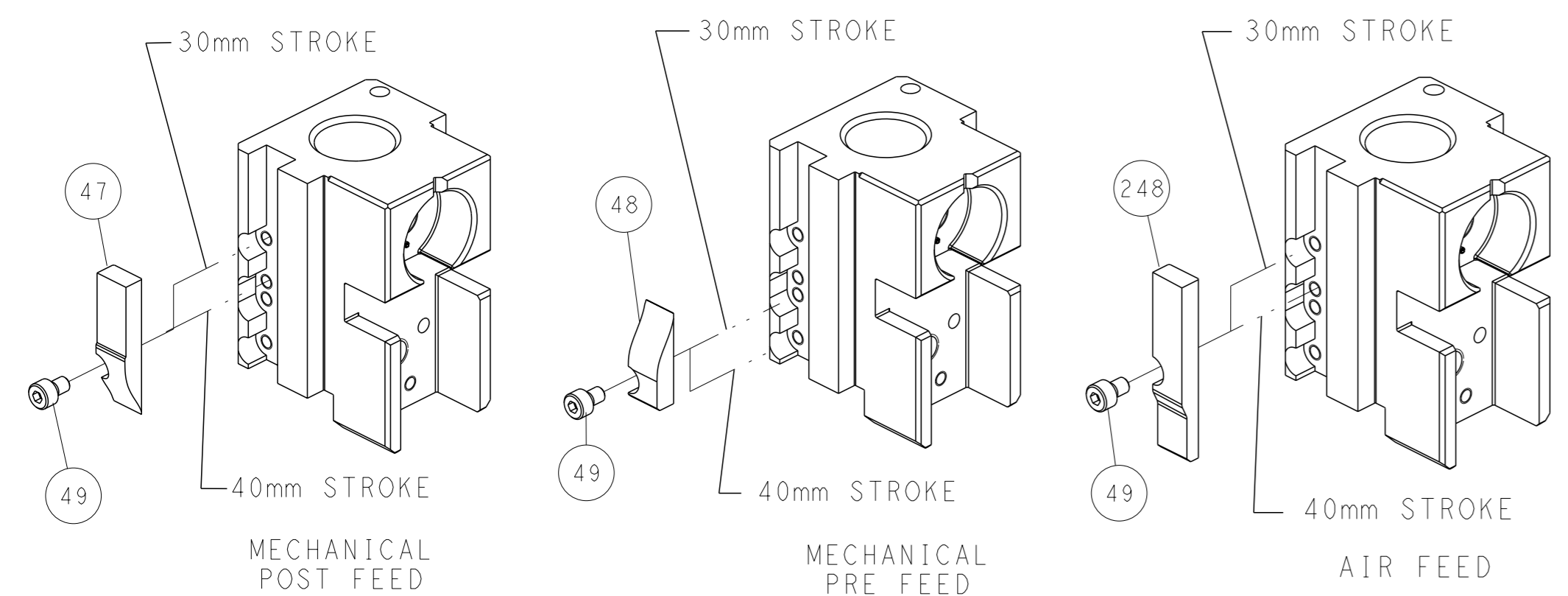


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

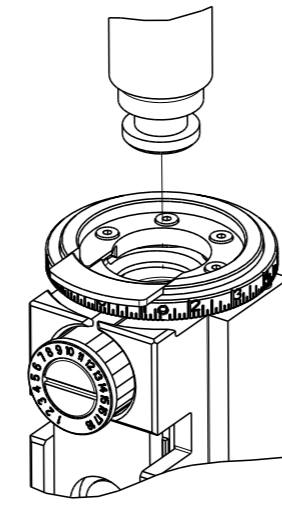


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		DWN L. ZHANG 25JAN2013 CHK L. ZHANG 25JAN2013 APVD S. XI 25JAN2013 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean Side Feed Applicator SIZE A1 CAGE CODE 00779 DRAWING NO. ©=2151859 SCALE 1:2 SHEET 2 of 4 REV B		RESTRICTED TO	
--------------------	--	--	--	--	--	--	--	---------------	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151859-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151859-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151859-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.33 mm [.092]	F
INSUL	3.05 mm [.120]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: 090 TERMINAL MALE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.50-5.50 mm [.177-.217 IN]	Ø1.60-2.20 mm [.063-.087 IN]		
TERMINAL APPLICATION SPECIFICATION	T-001-0	-	-
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
1642170-1	8230-4282		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: 090 TERMINAL FEMALE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.50-5.50 mm [.177-.217 IN]	Ø1.60-2.20 mm [.063-.087 IN]		
TERMINAL APPLICATION SPECIFICATION	T-001-0	-	-
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
1832246-1	8240-4422		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.45+/-0.05 [.057+/-0.002]	3.7
0.85mm2	1.35+/-0.05 [.053+/-0.002]	4.7
0.50mm2	1.25+/-0.05 [.049+/-0.002]	5.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.30+/-0.05 [.051+/-0.002]	5.3
0.85mm2	1.20+/-0.05 [.047+/-0.002]	6.3
0.50mm2	1.10+/-0.05 [.043+/-0.002]	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. 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.

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

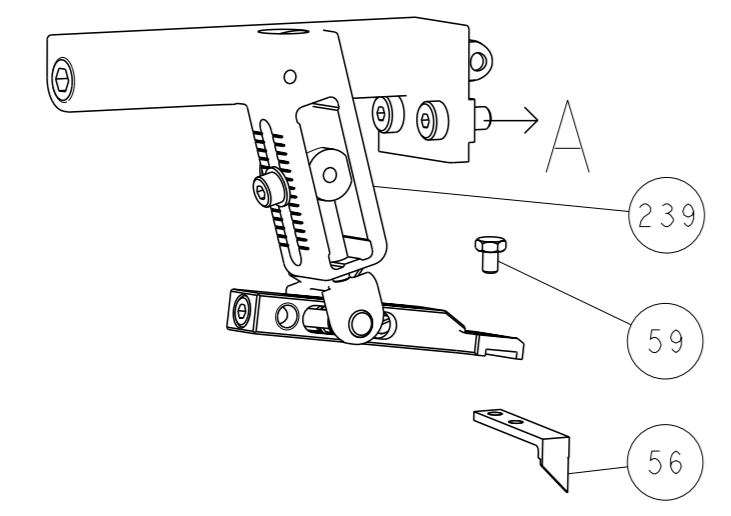
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	ITEM NO		
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-8	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-4	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	1-1633932-4	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1-1633961-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	1673600-2	CRIMPER, WIRE	1
-	77	22	21	PART NO	
-				DESCRIPTION	
-				ITEM NO	

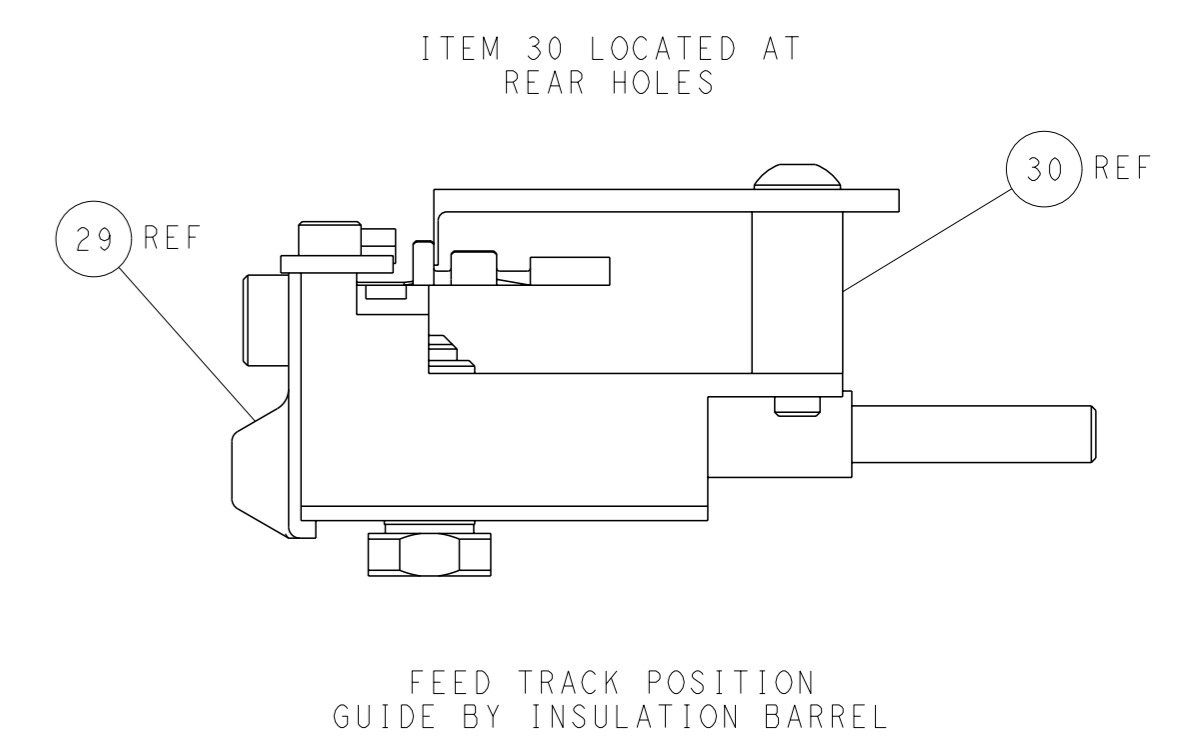
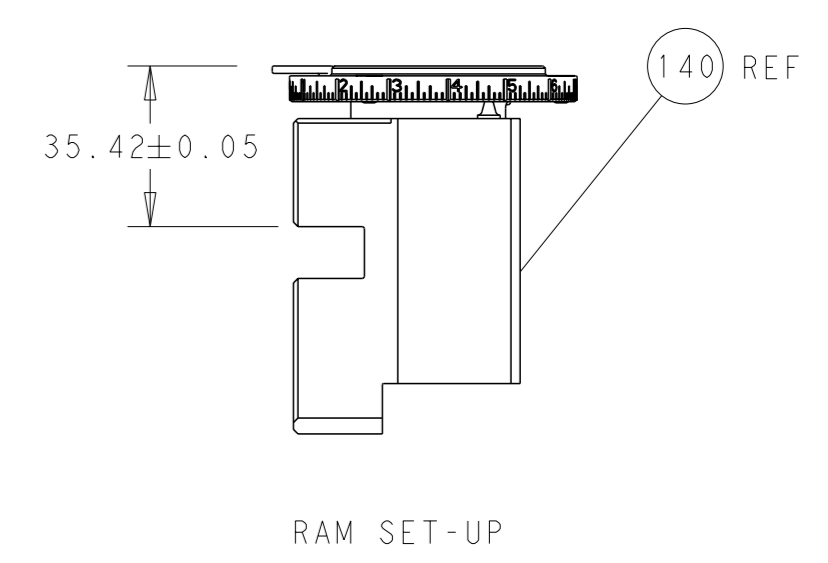
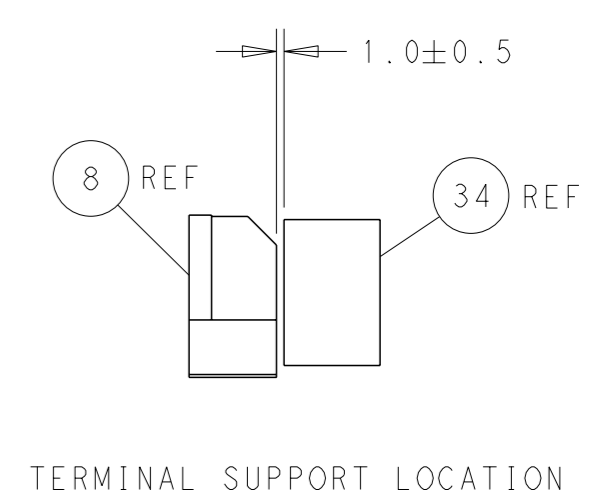
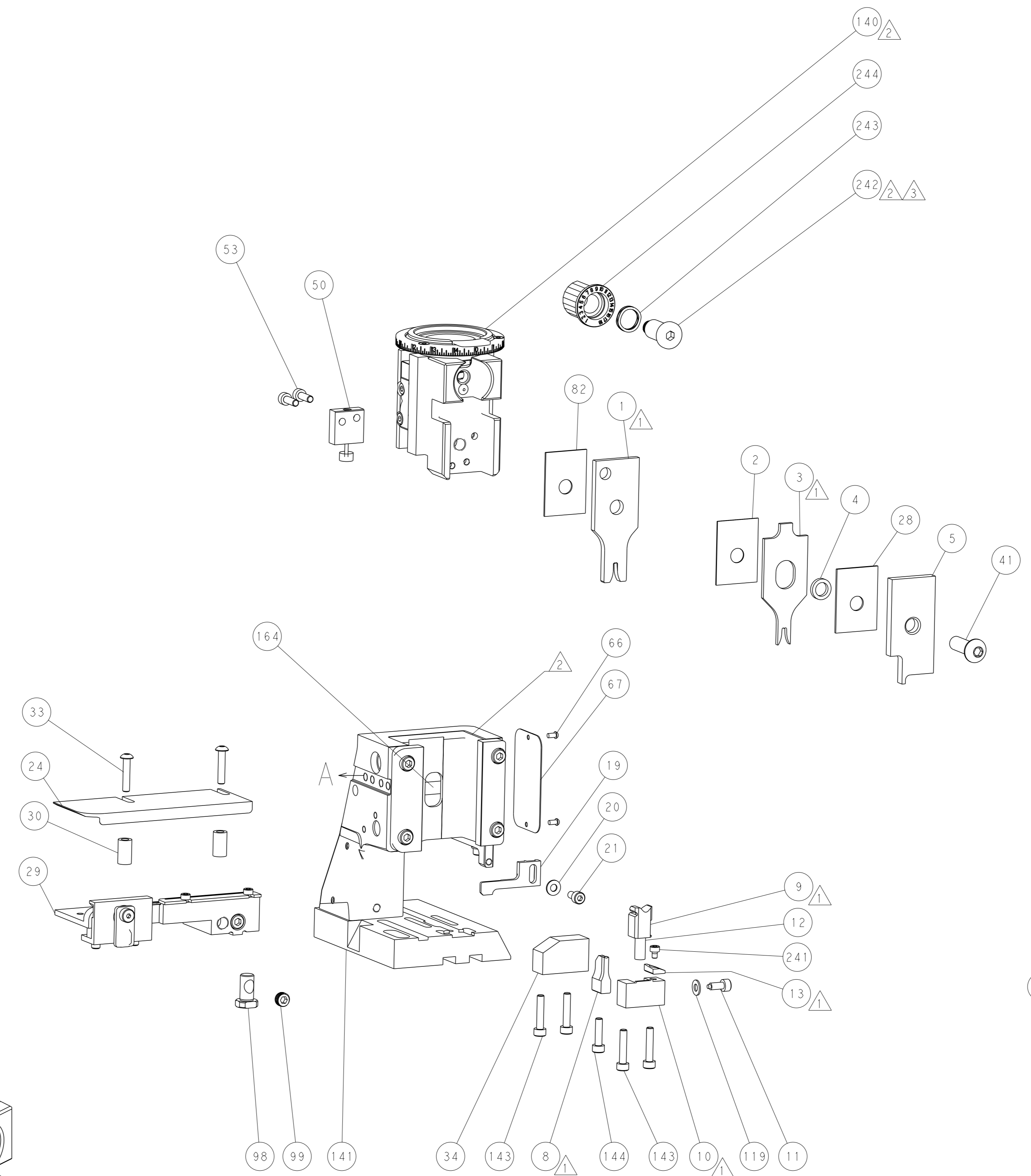
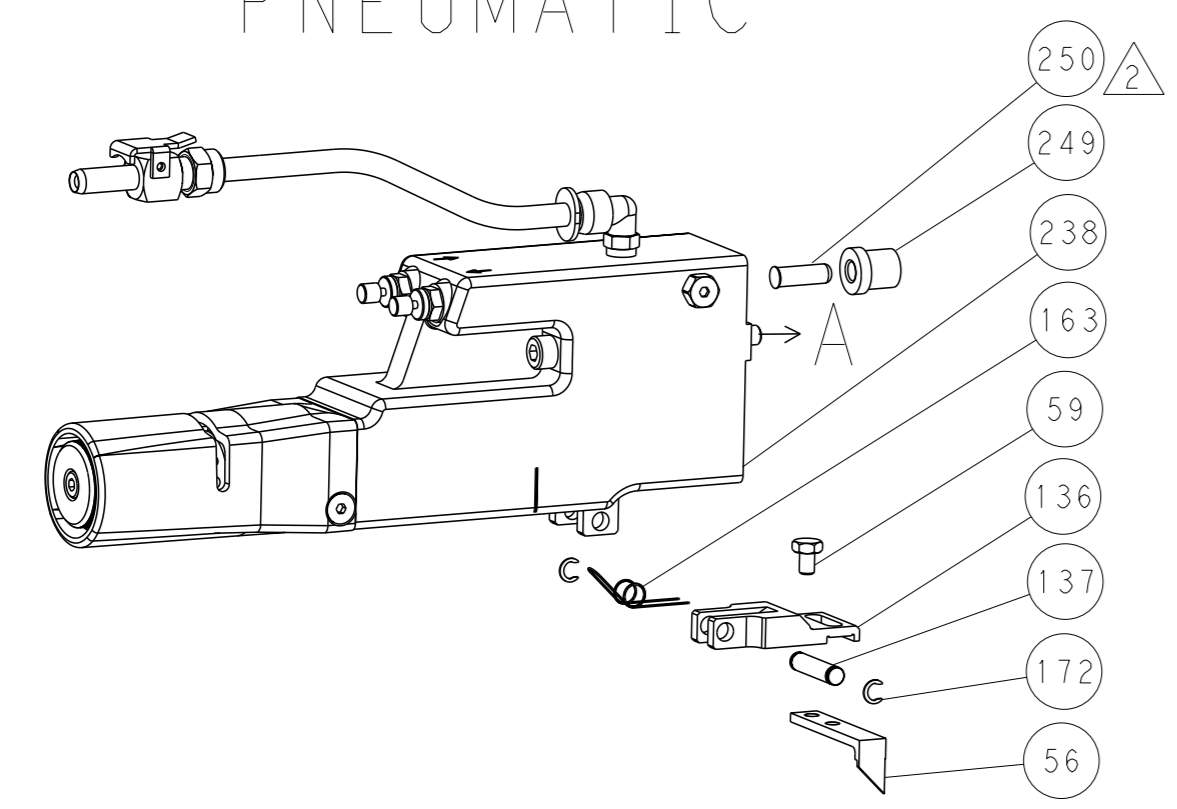
<small>THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE DRAWINGING INFORMATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: L. ZHANG 25JAN2013 CHK: L. ZHANG 25JAN2013 APVD: S. XI 25JAN2013	<b>STE</b> TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS 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: 2151859 SCALE: 1:2 SHEET: 3 of 4 REV: B	RESTRICTED TO: - Customer Accessible Production Drawing

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

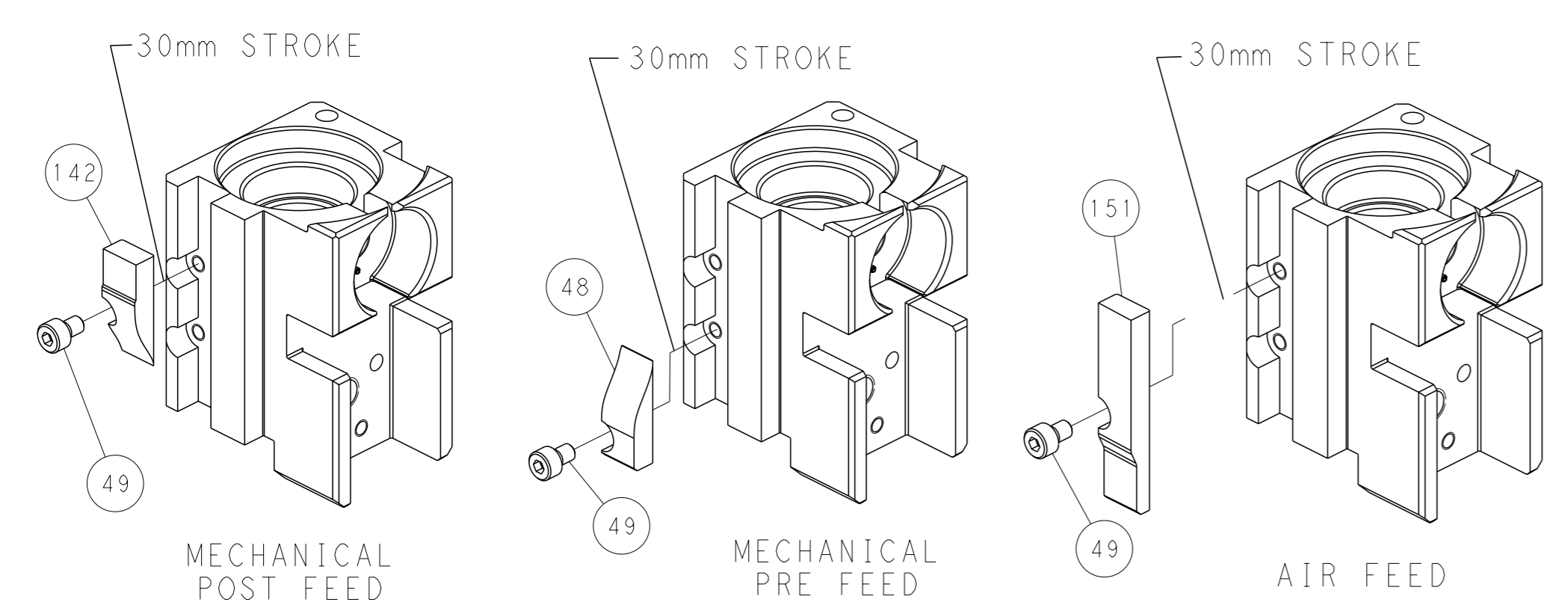
# FEED TYPE MECHANICAL



# 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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: L. ZHANG CHK: L. ZHANG APVD: S. XI PRODUCT SPEC APPLICATION SPEC MATERIAL: - FINISH: -	DATE: 25JAN2013 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151859 SCALE: 1:2 SHEET: 4 of 4 REV: B	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	RESTRICTED TO: -	