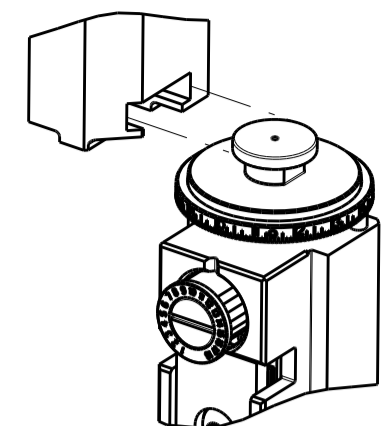


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151214-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151214-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151214-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

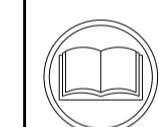


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.57 mm [.180]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.30 mm [.224-.248 IN]		Ø3.30-4.70 mm [.130-.185 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18365	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928958-2	928958-7		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.38+/-0.05 [.094+/- .002]	3.3
3.50mm2	2.27+/-0.05 [.089+/- .002]	4.4
3.00mm2	2.16+/-0.05 [.085+/- .002]	5.8



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

**\*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			
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		A	RELEASED	03SEP2012	KH SX
		B	ECR-20-003744	12MAR2020	FZ TE

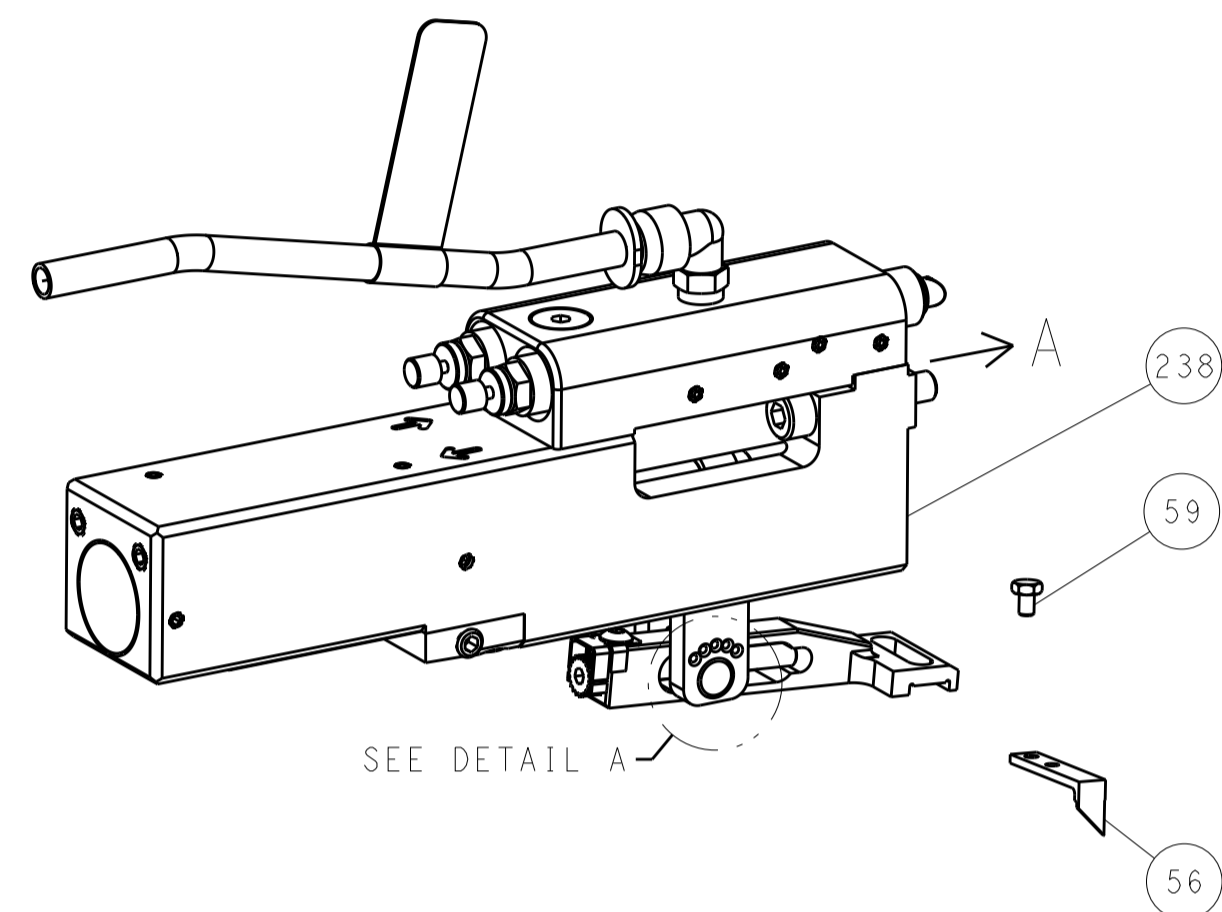
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	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	693855-1	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	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	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
-	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	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-9	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	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	1	1	1-455888-0	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	1320928-2	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	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	454276-5	FLOATING SHEAR, FRONT	9
-	1	2	1-1333209-0	ANVIL, COMBINATION .130	8
-	1	1	240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
-	1	2	1633964-3	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	2	2	455888-2	SPACER, CRIMPER	2
-	1	2	1-1633860-5	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL				WEIGHT		SCALE	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 1 OF 4	

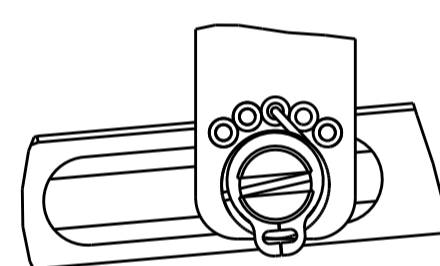
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

# FEED TYPE

## PNEUMATIC

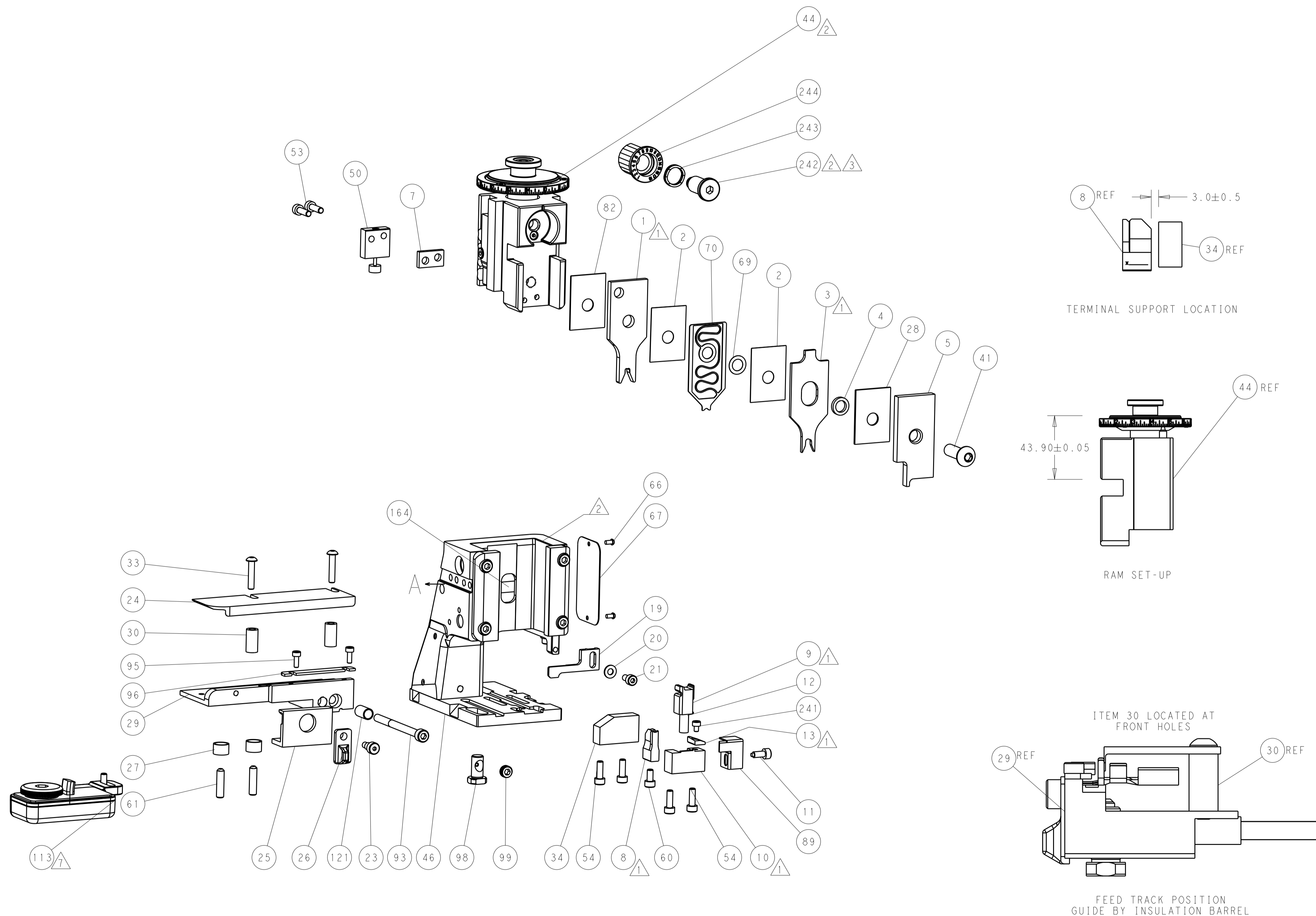
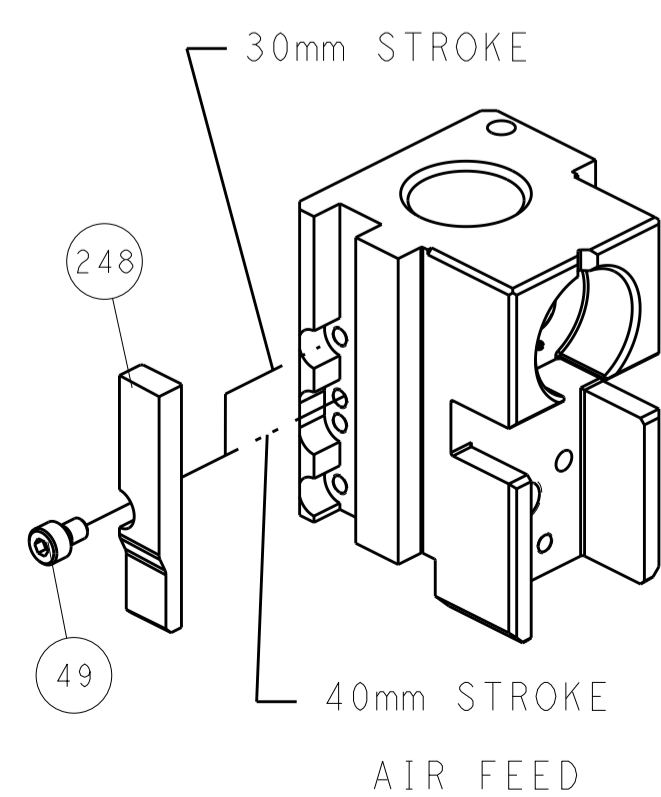


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

## CAM POSITION

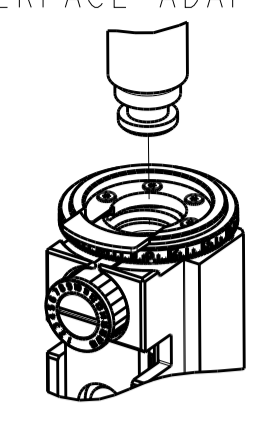


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: H. HUANG 18MAY2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: S. XI 18MAY2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		WEIGHT:		NAME: Ocean Side Feed Applicator	
				SCALE: 1:2		SIZE: A1	
				CAGE CODE: 00779		DRAWING NO: 2151214	
				SHEET: 2 OF 4		REV: B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151214-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151214-7	A	CRIMP TOOLING KIT	-

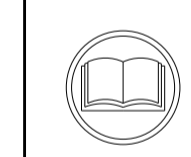
PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [ .130 ]	F
INSUL	4.57 mm [ .180 ]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.70-6.30 mm [ .224-.248 IN ]	∅3.30-4.70 mm [ .130-.185 IN ]		
TERMINAL APPLICATION SPECIFICATION	114-18365		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928958-2	928958-7		

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.38+/-0.05 [ .094+/- .002 ]	3.3
3.50mm2	2.27+/-0.05 [ .089+/- .002 ]	4.4
3.00mm2	2.16+/-0.05 [ .085+/- .002 ]	5.8



- 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 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

**\*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				

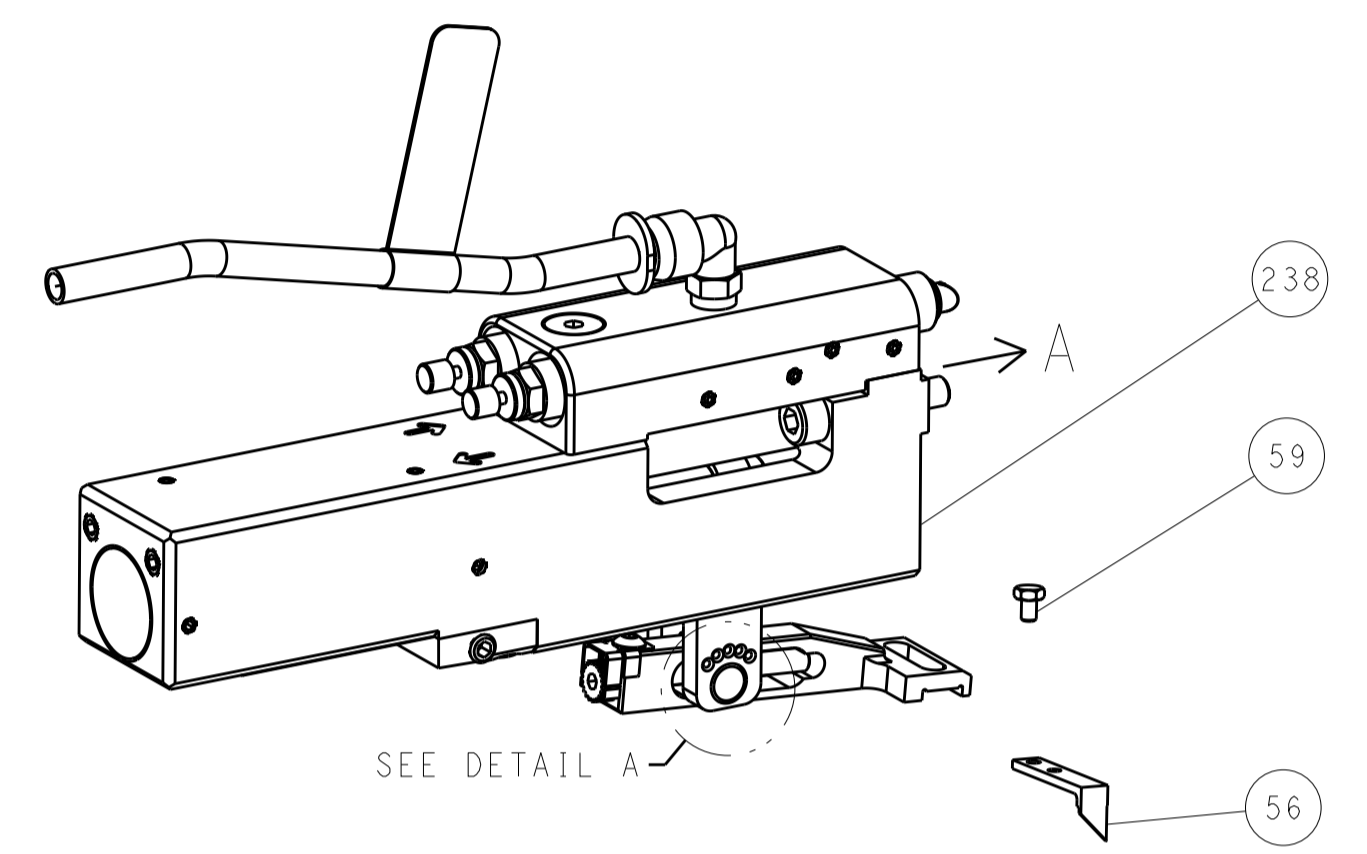
REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	1	2844940-2	AIR FEED MODULE		238
-	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	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC		140
-	1	1-22281-8	SPRING, COMPRESSION		121
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	2844908-1	SCREW, LOCKING		99
-	1	2844907-1	POST, LOCKING		98
-	1	693855-1	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	455888-6	SPACER, CRIMPER		82
-	1	1803607-3	DOCUMENTATION PACKAGE		71
-	1	2119791-5	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
-	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	1338685-1	PAWL, FEED		56
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14		53
-	1	1803382-6	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	1-1752356-3	SUPPORT, TERMINAL		34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	2844938-1	PLATE, STRIP GUIDE		29
-	1	1-455888-0	SPACER, CRIMPER		28
-	2	22283-1	SPRING, COMPRESSION		27
-	1	356835-1	LEVER, DRAG RELEASE		26
-	1	240792-1	DRAG, TERMINAL		25
-	1	1320928-2	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	1-356885-4	STOP, SHEAR		11
-	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	454276-5	FLOATING SHEAR, FRONT		9
-	1	1-1333209-0	ANVIL, COMBINATION .130		8
-	1	240641-5	SPACER		7
-	-	-	-		6
-	1	1-2119757-0	DEPRESSOR, SHEAR		5
-	1	1-238011-0	BLOCK, CRIMPER SPACER		4
-	1	1633964-3	CRIMPER, INSULATION OVERLAP PREMIUM		3
-	2	455888-2	SPACER, CRIMPER		2
-	1	1-1633860-5	CRIMPER, WIRE		1
-77	-22	PART NO	DESCRIPTION	ITEM NO	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK	
mm	0 PLC ±	1 PLC ±	2 PLC ±	18MAY2012	H. HUANG		
	3 PLC ±	4 PLC ±	ANGLES ±	18MAY2012	S. XI		
MATERIAL	FINISH	WEIGHT	SCALE	PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE DRAWING NO
			1:2			A1	00779 C=2151214
Customer Accessible Production Drawing				SHEET	3	OF	4

LOC	DIST	REV	DATE	BY	APPD
A	66				

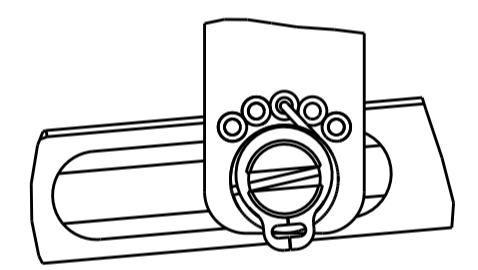
# FEED TYPE

## PNEUMATIC



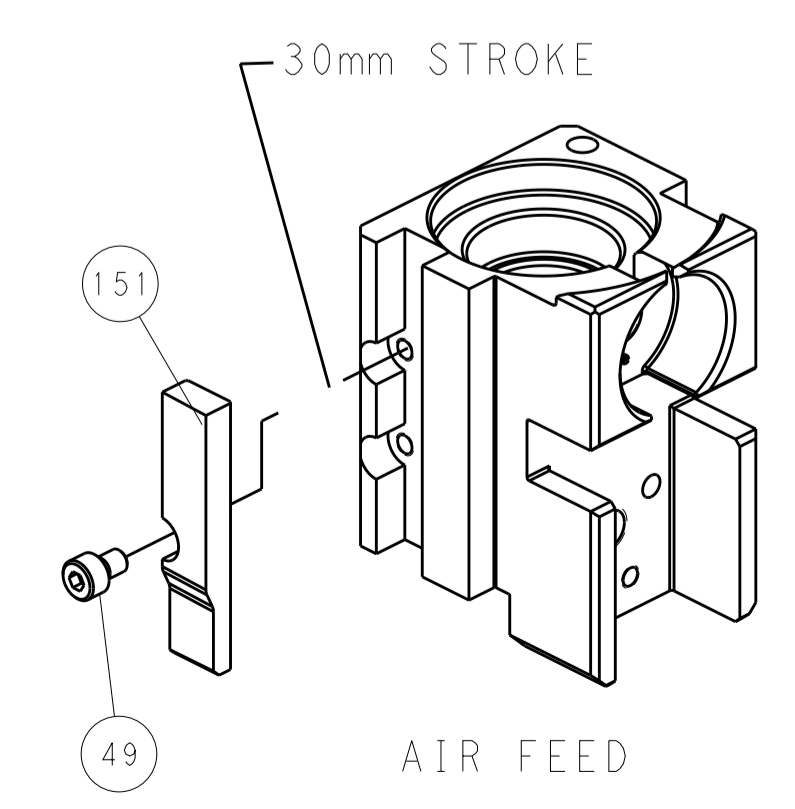
SEE DETAIL A

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

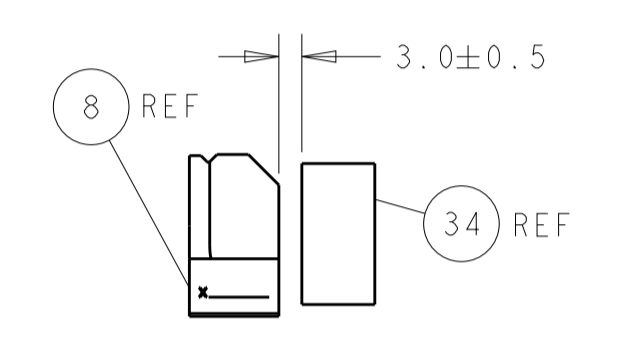
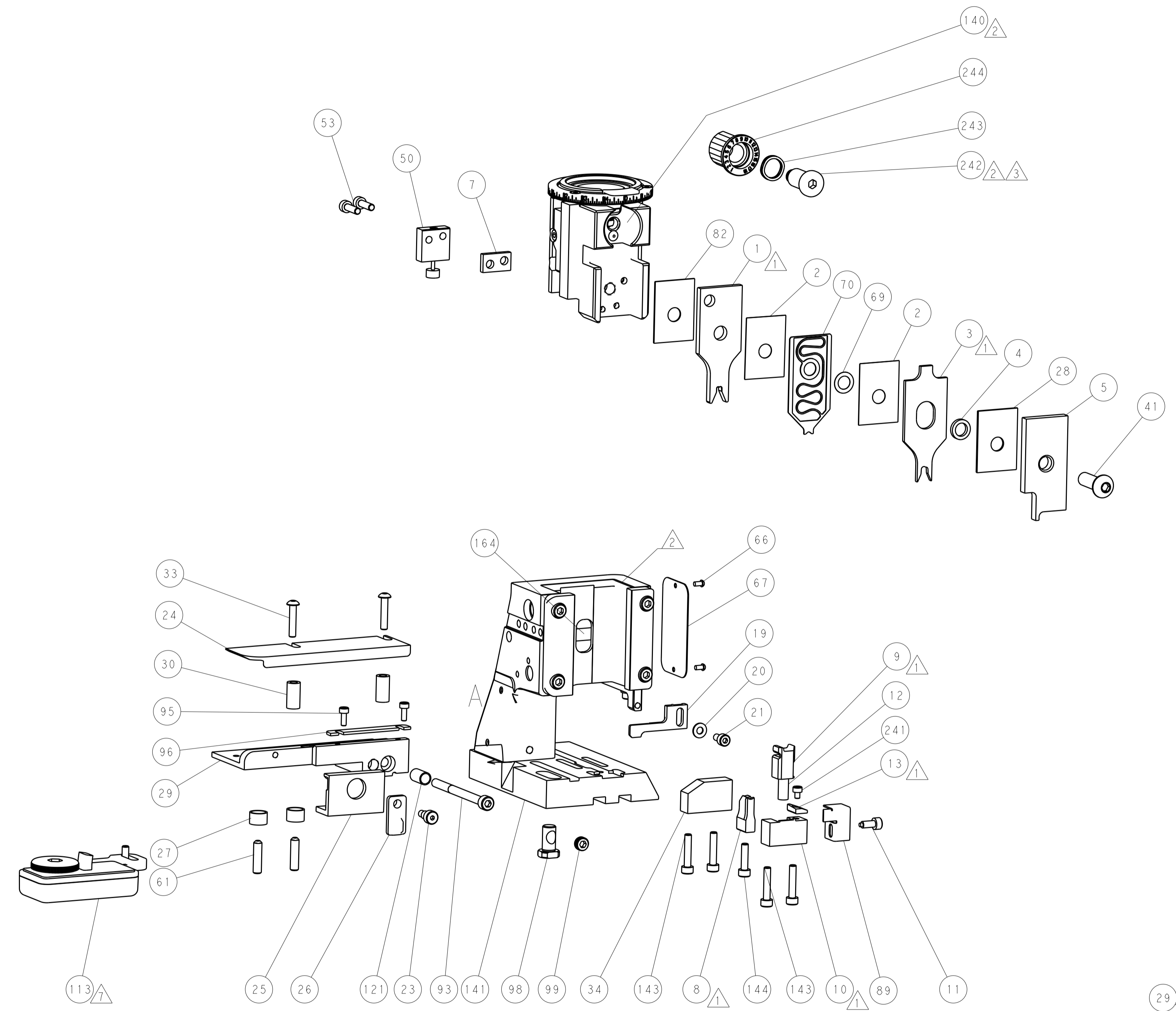


DETAIL A

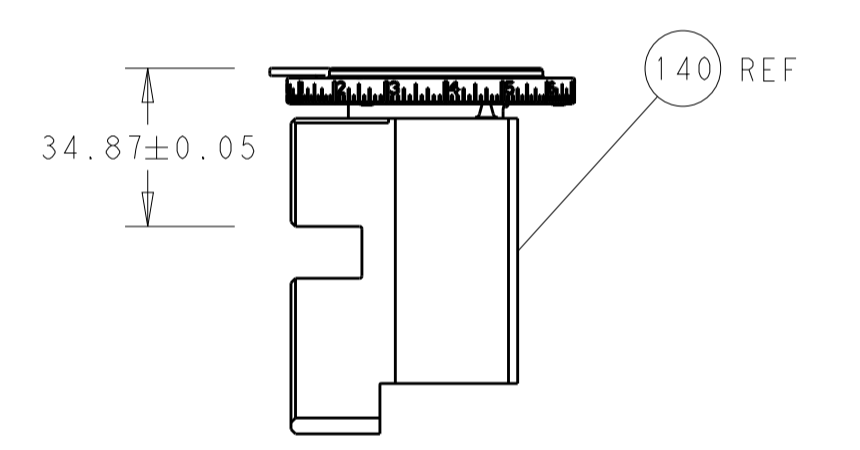
## CAM POSITION



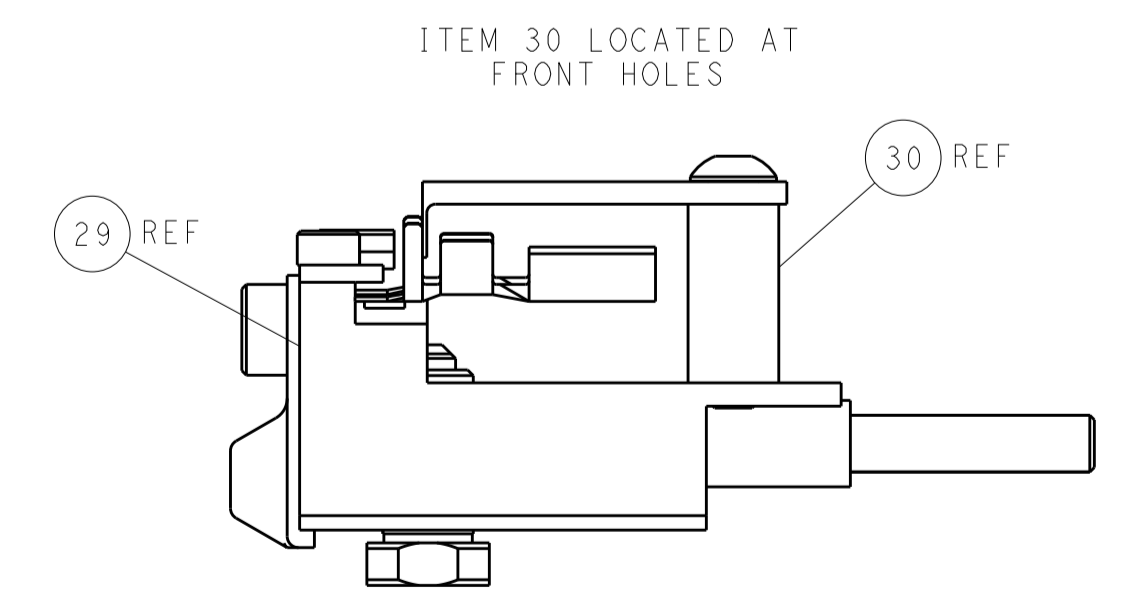
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND LIMITATIONS SPECIFIED HEREIN. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON REQUEST.</small>		DWN: R. HUANG 18MAY2012 CHK: - APVD: S. XI 18MAY2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151214	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: B
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION