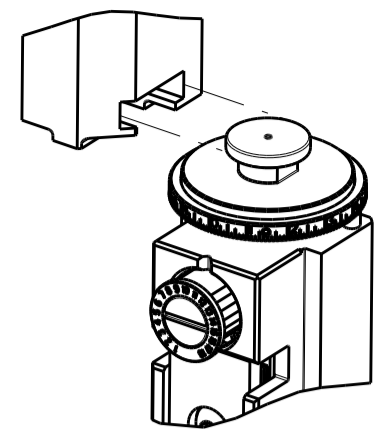


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151161-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151161-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151161-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.05 mm [.081]	F
INSUL	2.80 mm [.110]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6,3 MM POSITIVE LOCK			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.30 mm [.224-.248 IN]		Ø1.40-2.30 mm [.055-.091 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18365-1		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927852-1	927852-4	927852-7	
927852-2	927852-5	927852-8	
927852-3	927852-6	927852-9	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.61 +/- 0.05 [.063 +/- .002]	5.0
0.75mm2	1.52 +/- 0.05 [.060 +/- .002]	5.9
0.50mm2	1.43 +/- 0.05 [.056 +/- .002]	7.0

- 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 ITEMS 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.
  - TERMINAL LUBRICANT IS RECOMMENDED.
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.

**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	REV	DATE	BY	CHKD
		D	ECR-12-021035	06DEC2012	YY SX
		E	ECR-16-008313	08JUN2016	MZ TE
		F	ECR-18-006969	07MAY2018	FL JD
		G	ECR-19-009113	11JUN2019	FJ TE

-	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	
-	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	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	693855-8	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	455888-6	SPACER, CRIMPER	82	
-	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	854769-4	HOLDER, INS	74	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	1	1	1338685-1	PAWL, FEED	56	
-	6	6	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	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	1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	3-2844962-0	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	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	2	1	3-1333204-9	ANVIL, COMBINATION	8
-	1	1	1-240641-3	SPACER	7	
-	-	-	-	-	6	
-	1	1	1-2119780-1	DEPRESSOR, SHEAR	5	
-	1	1	238011-9	BLOCK, CRIMPER SPACER	4	
-	1	2	1	1633963-3	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	2	1	456405-3	CRIMPER, WIRE PREMIUM	1

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

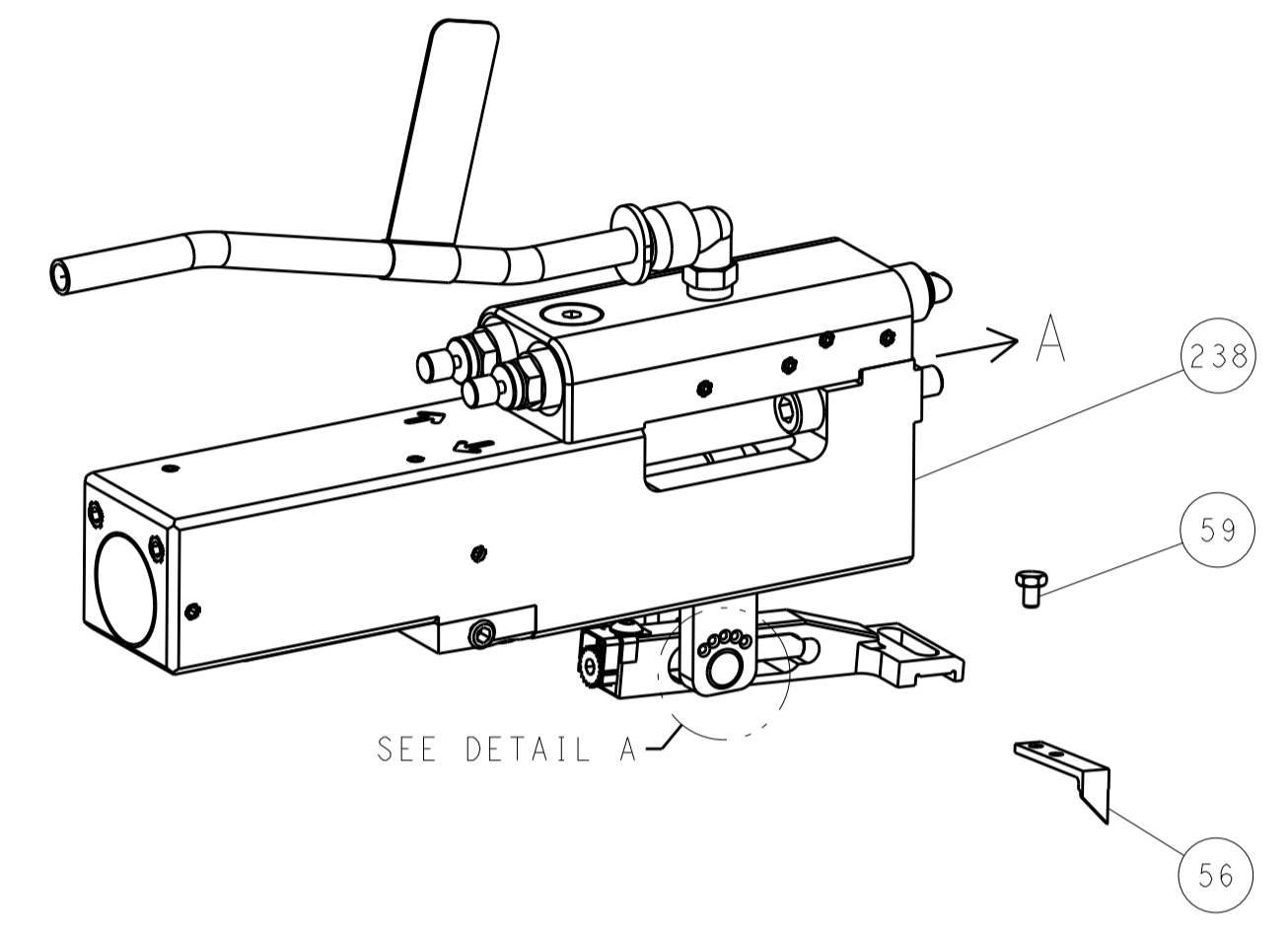
REV	CHK	DATE	NAME
14NOV2011	H. HUANG	14NOV2011	TE Connectivity
14NOV2011	S. XI	14NOV2011	Harrisburg, PA 17105-3608
14NOV2011	I. CRUZ	14NOV2011	

PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
		A1	00779	2151161	

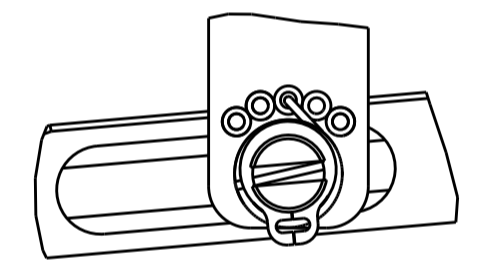
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV G

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

### FEED TYPE PNEUMATIC

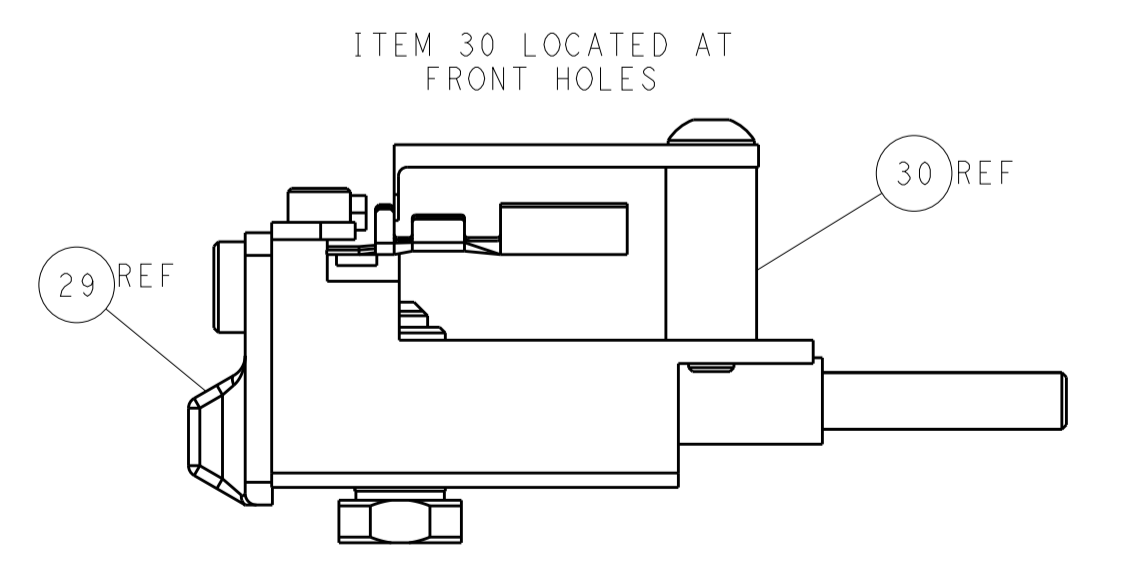
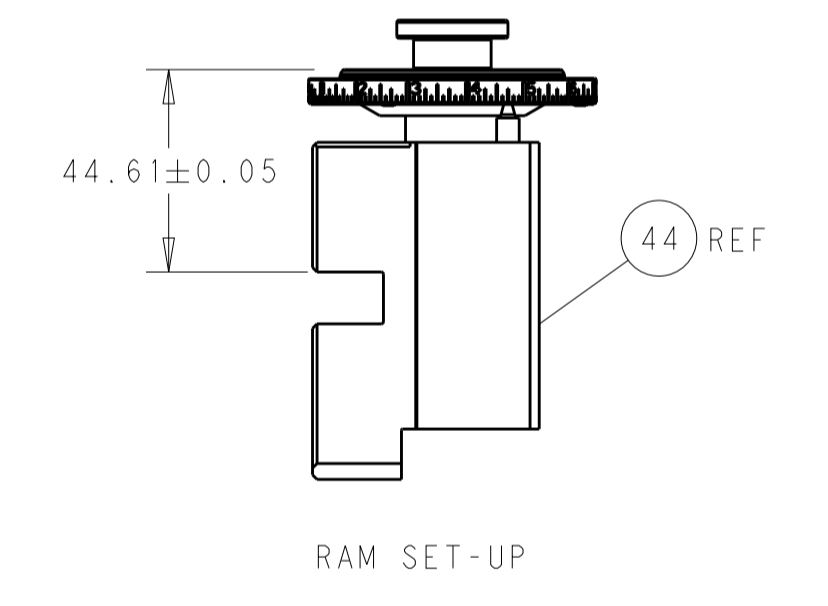
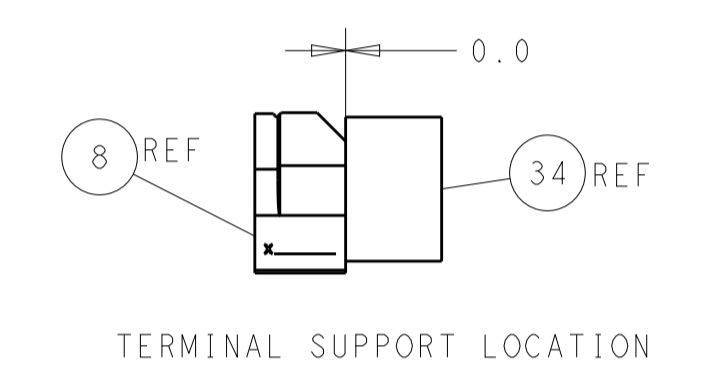
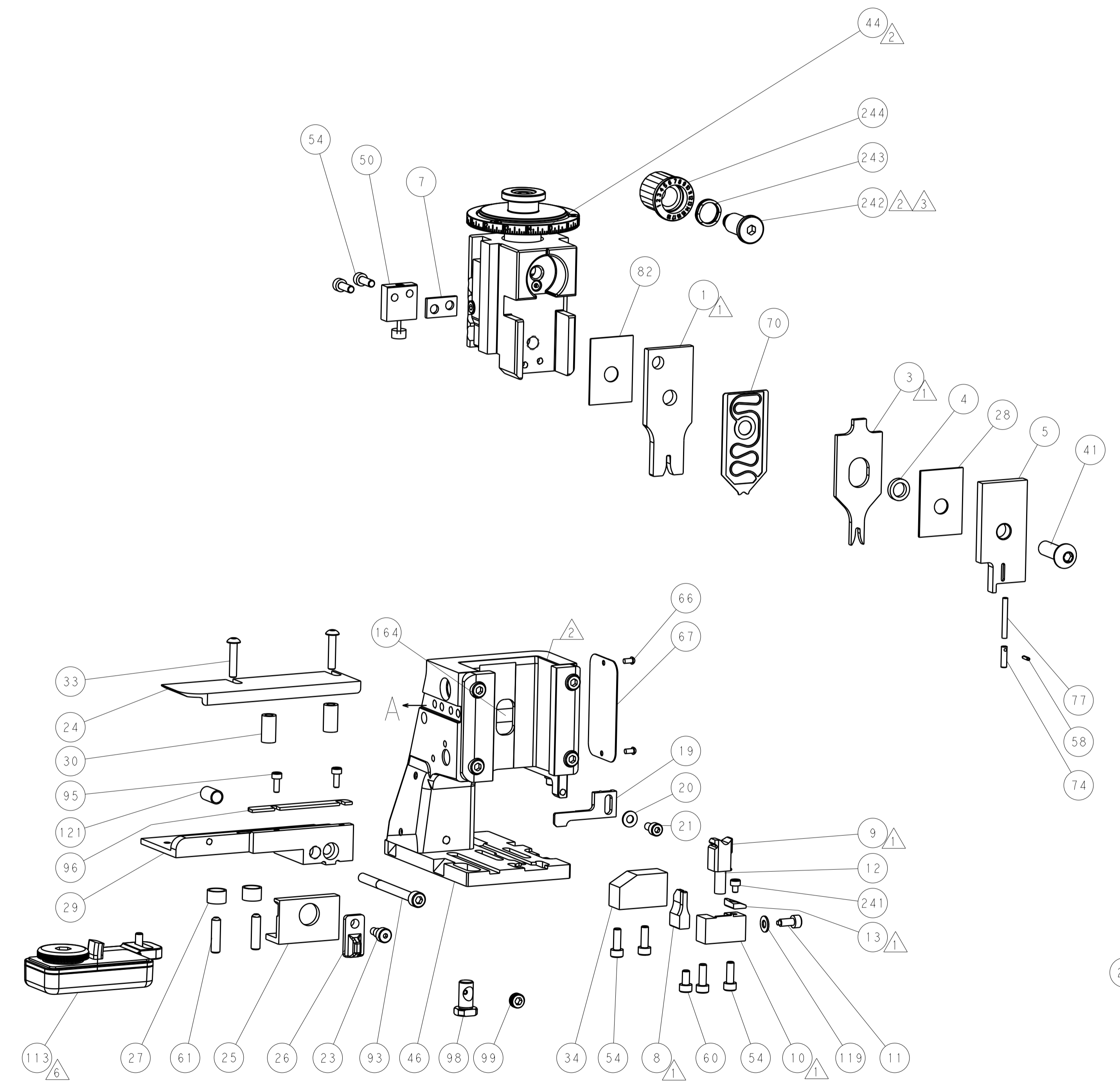
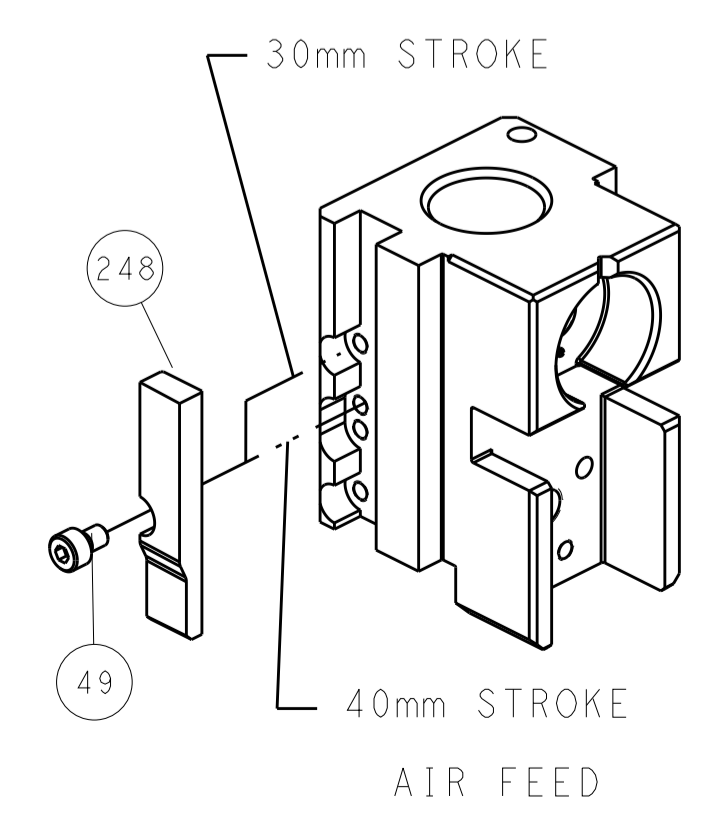


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

### CAM POSITION



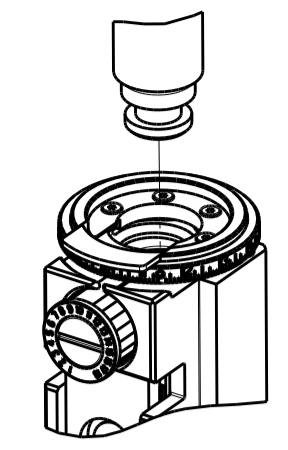
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. HUANG 14NOV2011 CHK: S. XI 14NOV2011 APVD: J. CRUZ 14NOV2011	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: 2151161	RESTRICTED TO: SCALE: 1:2 SHEET: 2 OF 4 REV: G
MATERIAL: FINISH:		WEIGHT: Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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 COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151161-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151161-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.05 mm [.081]	F
INSUL	2.80 mm [.110]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.70-6.30 mm [.224-.248 IN]	∅1.40-2.30 mm [.055-.091 IN]

TERMINAL APPLICATION SPECIFICATION	
114-18365-1	-

TERMINALS APPLIED 5 6

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927852-1	927852-4	927852-7	
927852-2	927852-5	927852-8	
927852-3	927852-6	927852-9	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm <sup>2</sup>	1.61 +/- 0.05 [.063 +/- .002]	5.0
0.75mm <sup>2</sup>	1.52 +/- 0.05 [.060 +/- .002]	5.9
0.50mm <sup>2</sup>	1.43 +/- 0.05 [.056 +/- .002]	7.0



- △ 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 ITEMS 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.
- △ TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

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	F	LYN	DESCRIPTION	DATE	OWN	APVD		
				SEE SHEET 1					

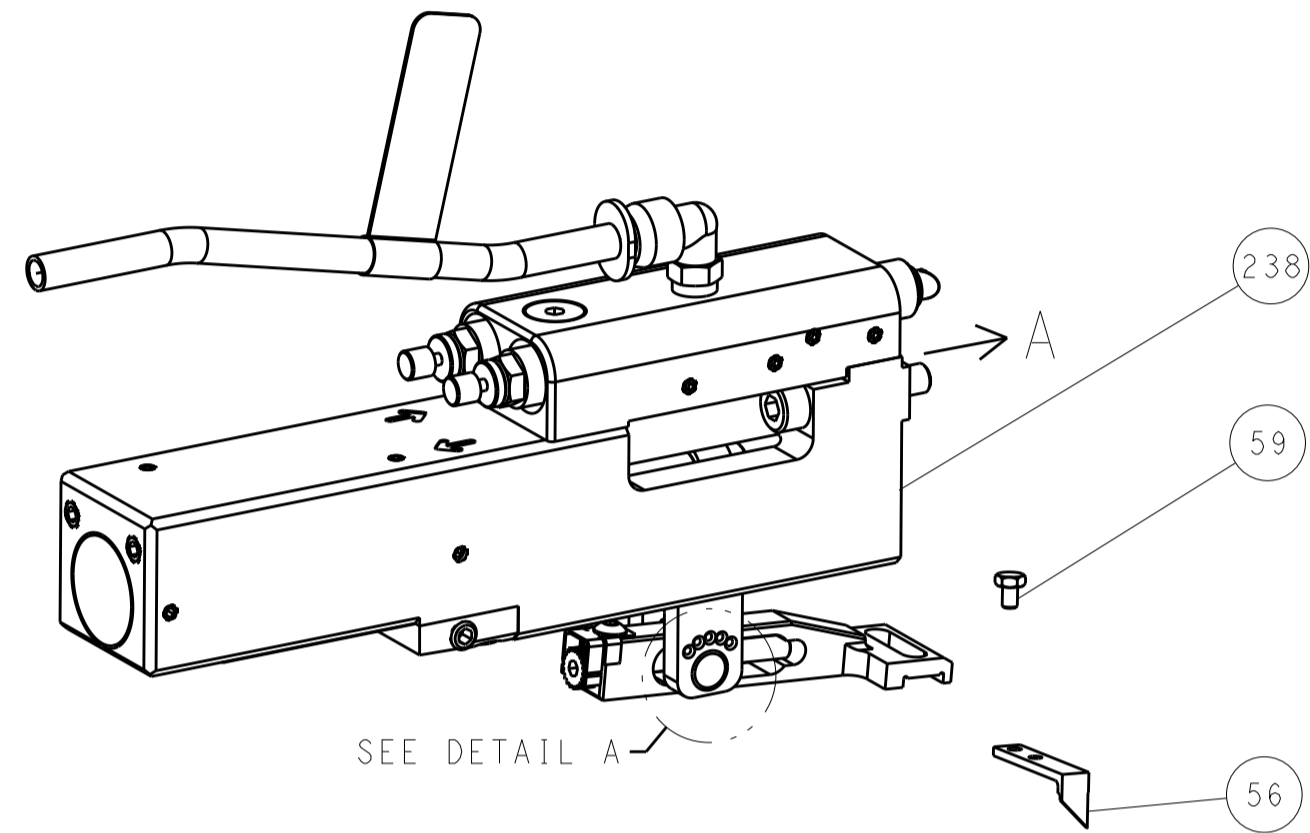
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-2	AIR FEED MODULE	238
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	693855-8	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 6.5	93
-	1	455888-6	SPACER, CRIMPER	82
-	1	5-547505-2	SPRING, COMPRESSION	77
-	1	854769-4	HOLDER, INS	74
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119791-9	DEPRESSOR, WIRE	70
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1338685-1	PAWL, FEED	56
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-0	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	3-1333204-9	ANVIL, COMBINATION	8
-	1	1-240641-3	SPACER	7
-	-	-	-	6
-	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1633963-3	CRIMPER, INSULATION OVERLAP PREMIUM	3
1	1	456405-3	CRIMPER, WIRE PREMIUM	1
-77	-22	PART NO	DESCRIPTION	ITEM NO

<p>THE DRAWING IS CONTROLLED DOCUMENT AND THE LATEST REVISED VERSION OF THIS DRAWING IS THE ONLY ONE TO BE USED. THE USER SHALL BE RESPONSIBLE FOR IDENTIFYING THE LATEST REVISED DRAWING WHICH BE CONTACTED FOR THE LATEST VERSION.</p>		DWN CK S.XI APVD I. CRUZ	14NOV2011 14NOV2011 14NOV2011 14NOV2011	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	PRODUCT SPEC APPLICATION SPEC			SIZE A1	CAGE CODE 00779
MATERIAL: .		WEIGHT: .		Customer Accessible Production Drawing	SCALE: 1:2	SHEET: 3 OF 4	REV: G

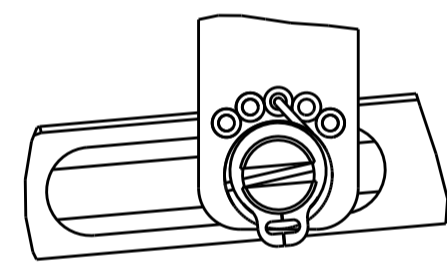
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

### FEED TYPE PNEUMATIC

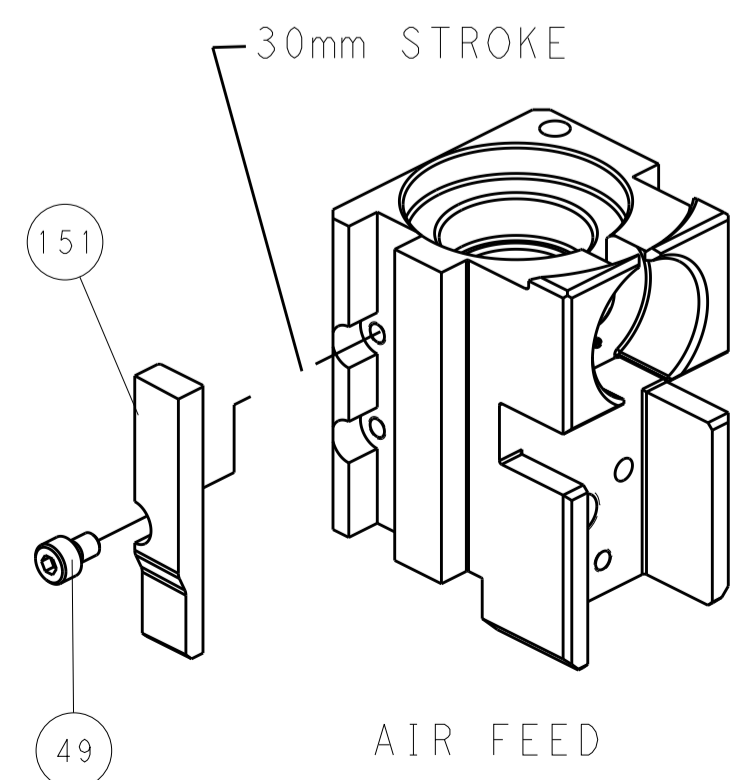


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

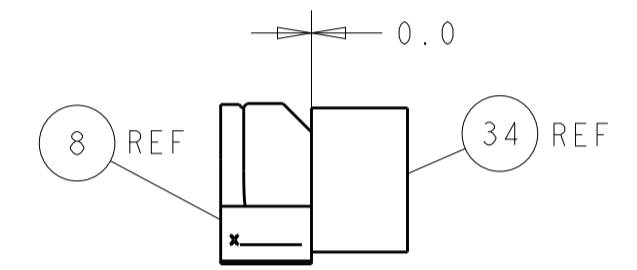
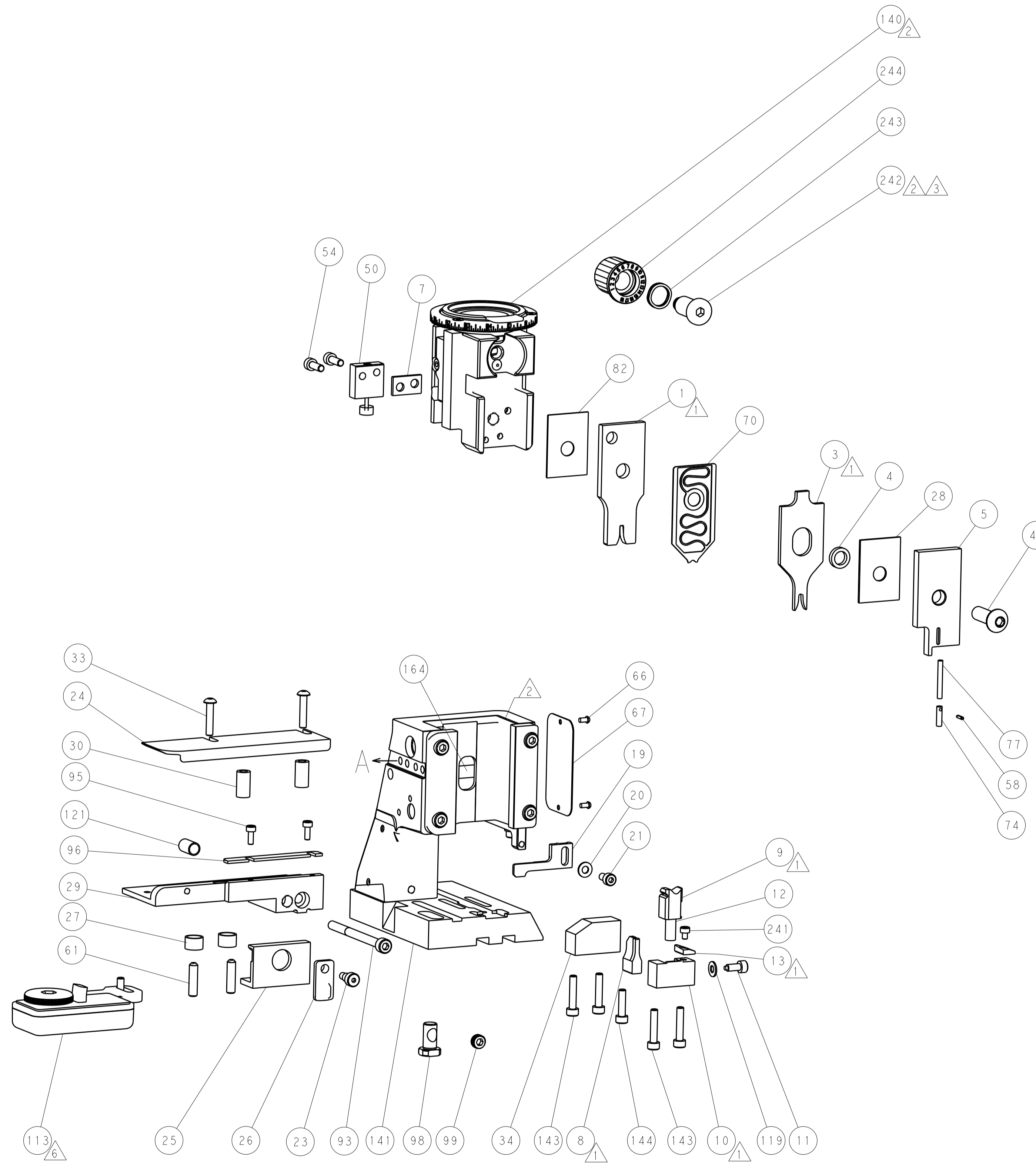


DETAIL A

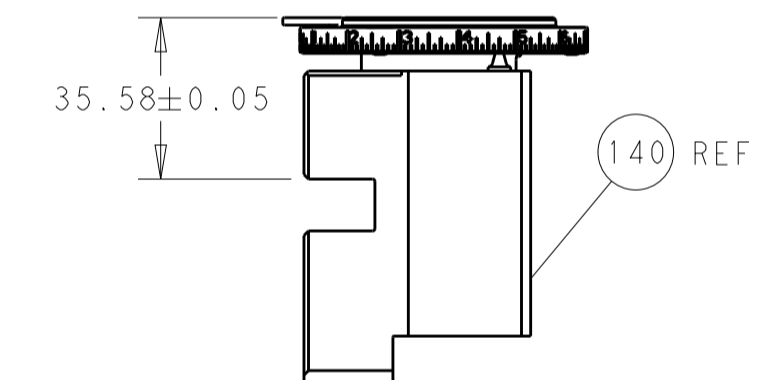
### CAM POSITION



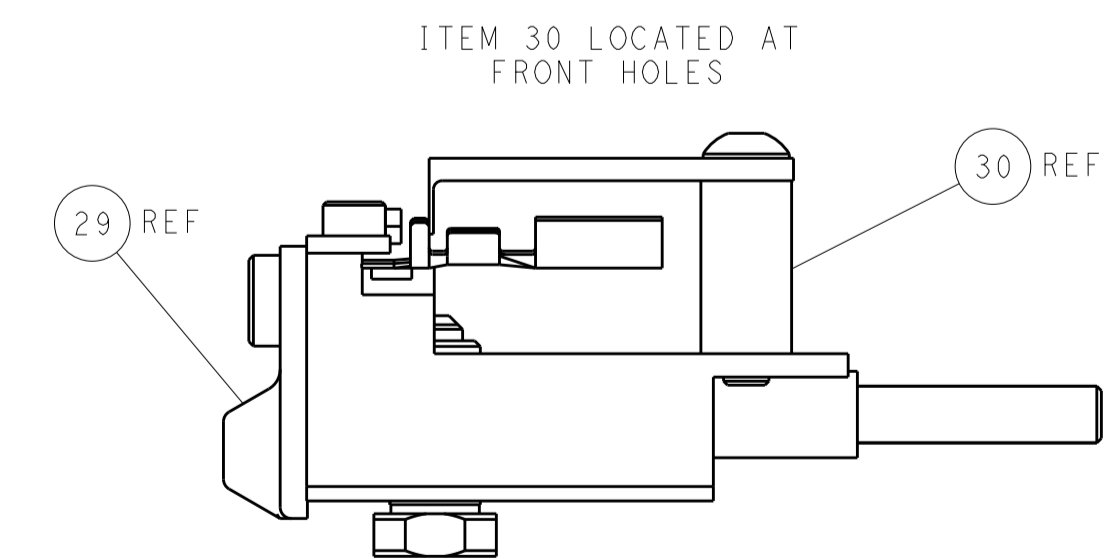
AIR FEED



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: H. HUANG 14NOV2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: S. XI 14NOV2011		NAME: Ocean Side Feed Applicator	
				APVD: J. CRUZ 14NOV2011		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2151161	
				WEIGHT:		SCALE: 1:2	
				Customer Accessible Production Drawing		SHEET 4 OF 4 REV G	