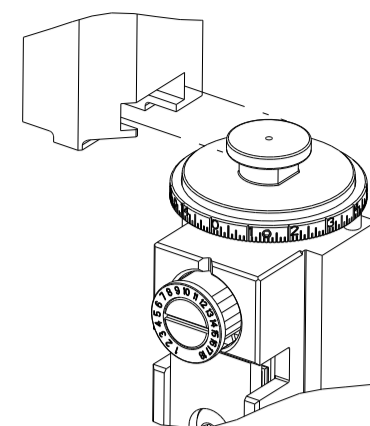


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151487-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151487-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151487-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

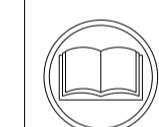


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.33 mm [.210]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH .189-.213 IN [4.80-5.41 mm]		INSULATION DIAMETER RANGE Ø.134-.200 IN [3.40-5.08 mm]	
TERMINAL APPLICATION SPECIFICATION (A) 114-20036 (B) 114-20029			
TERMINALS APPLIED			
TE TERMINAL (A) 790319-3 (A) 790319-4	TE TERMINAL (A) 790319-5 (B) 281829-1	TE TERMINAL (B) 281829-2	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.62 +/- 0.05 [1.03 +/- .002]	3.7
4.00mm2	2.16 +/- 0.05 [1.085 +/- .002]	8.9



- 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.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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	OWN	APVD
		C		REVISED ECR-13-014573	17SEP2013	CC	TE
		C1		ECR-14-004964	08APR2014	YY	TE
		D		ECR-20-000951	19JAN2020	FZ	TE
		E		ECR-23-166439	15FEB2023	FZ	GB

-	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	18023-1	SCR, SKT HD CAP M3 X 5.0	241
-	1	1	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	455888-4	SPACER, CRIMPER	120
-	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	693855-8	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	455888-5	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	6-1752356-3	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	2844992-3	ASSEMBLY, 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	133211-1	ANVIL, COMBINATION .150-.300	8
-	1	1	1-240641-1	SPACER	7
-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	2	1-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	456414-9	CRIMPER, WIRE	1

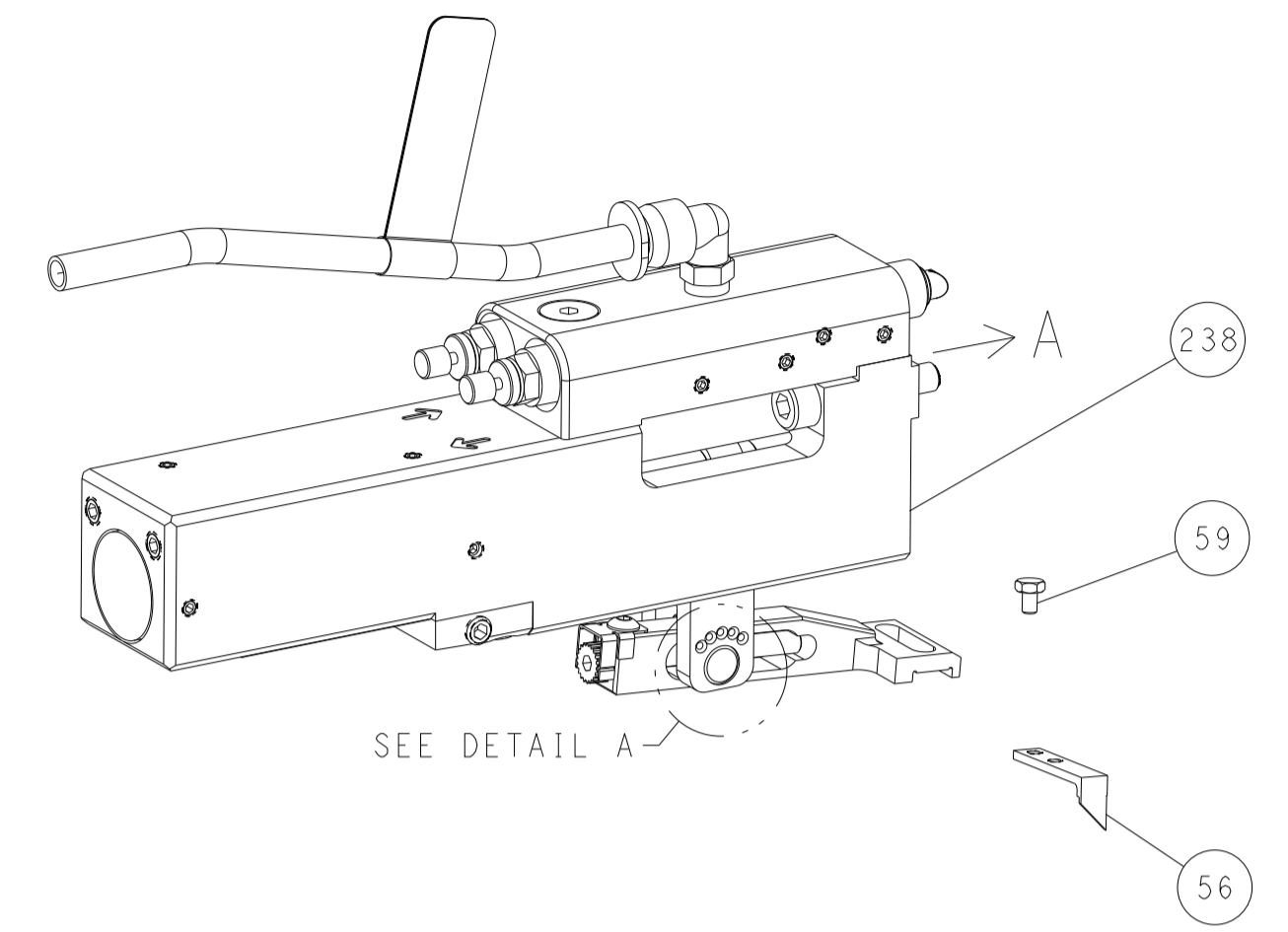
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL				WEIGHT	SCALE	SHEET	REV

OWN	CHK	APVD	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Y. YIN	G. BAILEY	S. XI	Ocean Side Feed Applicator	A1	00779	2151487	E

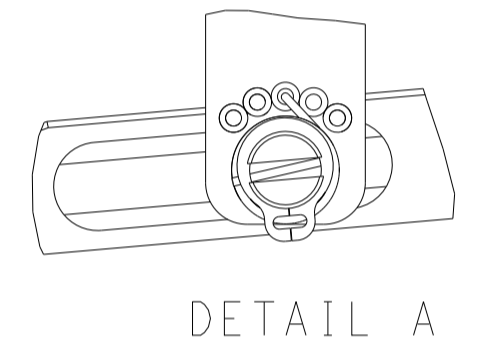
Customer Accessible Production Drawing

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

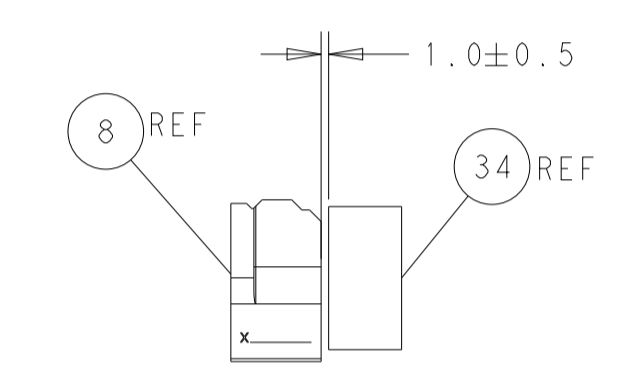
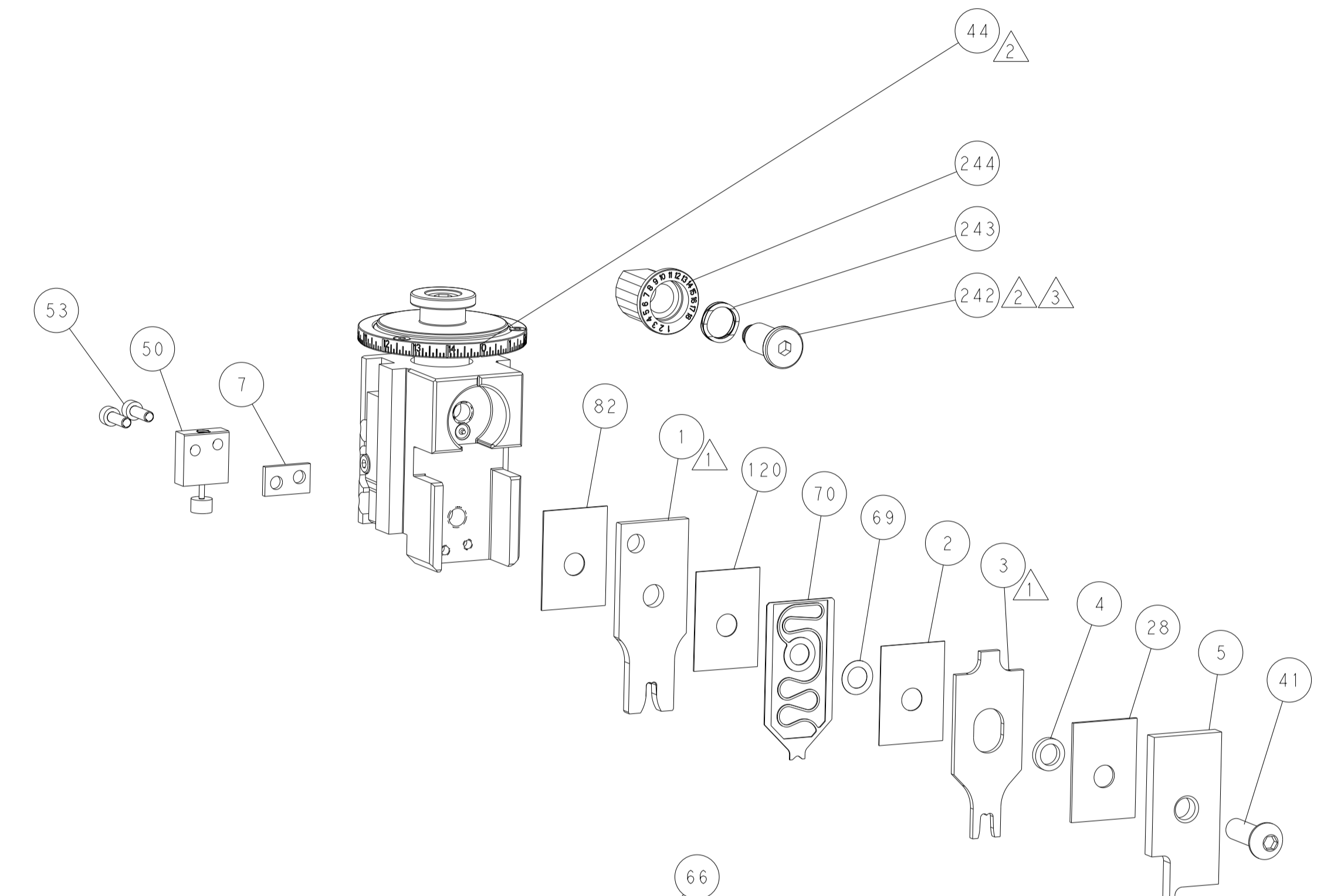
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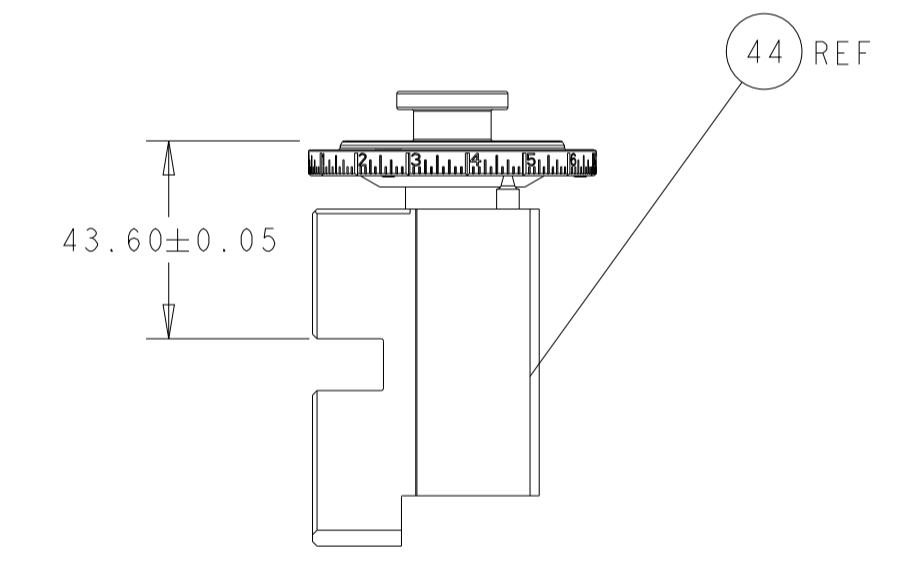
FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



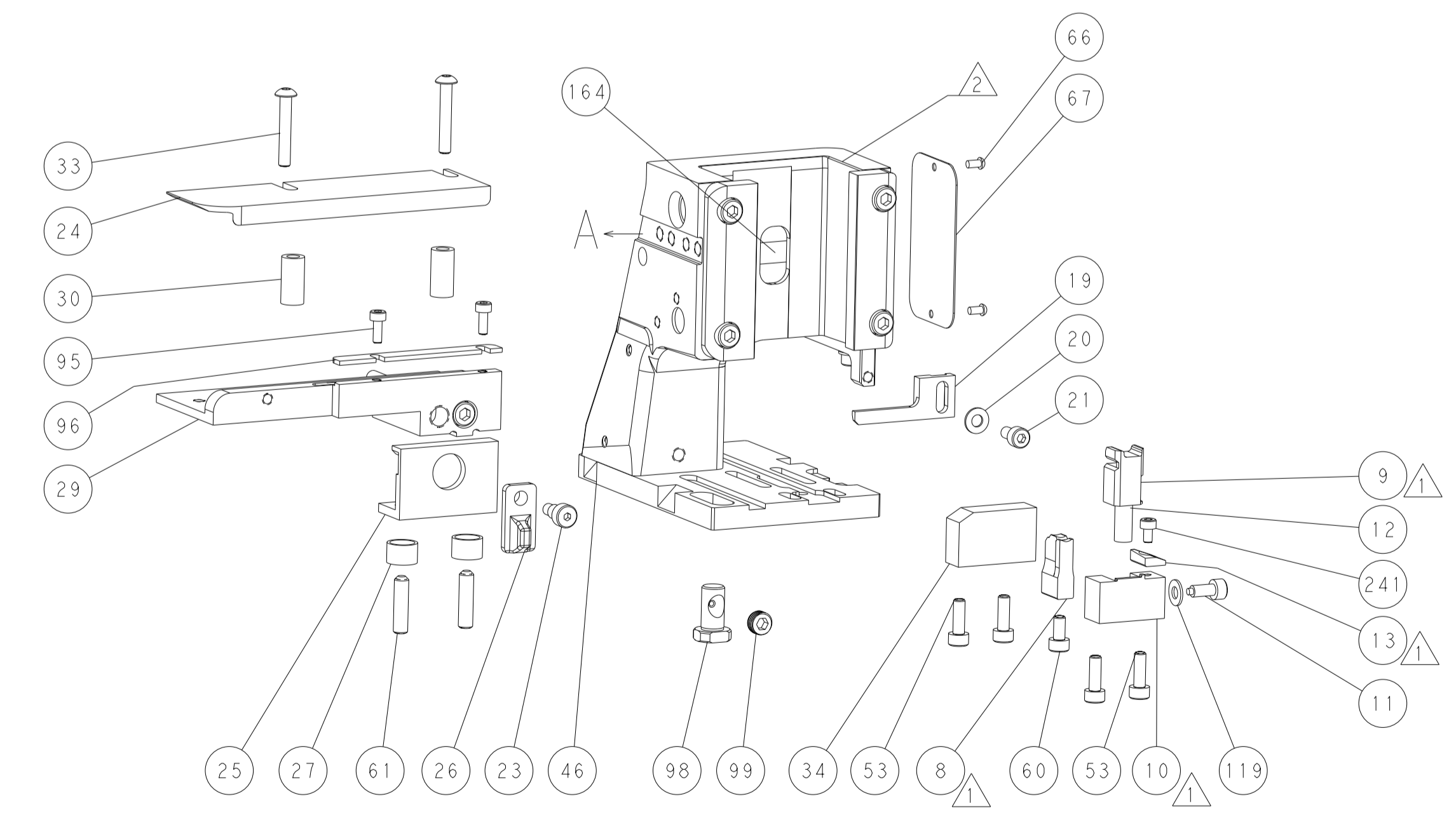
DETAIL A



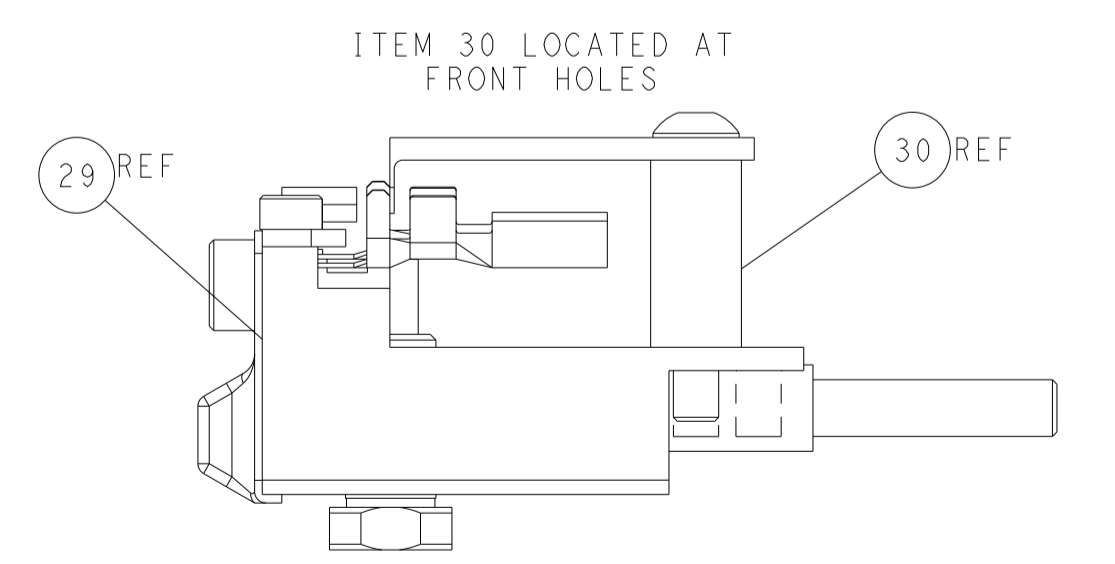
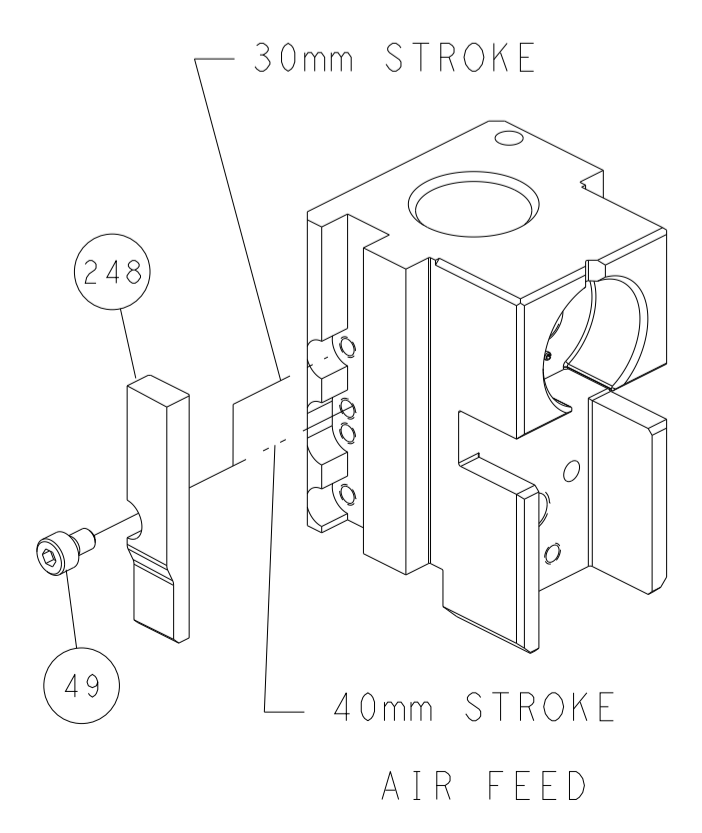
TERMINAL SUPPORT LOCATION



RAM SET-UP



# CAM POSITION



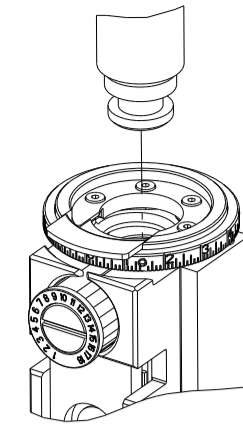
FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

**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 12AUG2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
	ANGLES ±	FINISH		CHK G. BAILEY 12AUG2011		NAME	
MATERIAL				S. XI 12AUG2011		Ocean Side Feed Applicator	
				APVD		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				PRODUCT SPEC		A1 00779 ©=2151487	
				APPLICATION SPEC		Customer Accessible Production Drawing	
				WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV E	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151487-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151487-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.33 mm [.210]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH .189-.213 IN [4.80-5.41 mm]		INSULATION DIAMETER RANGE Ø.134-.200 IN [3.40-5.08 mm]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-20036	-	-
	(B) 114-20029	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 790319-3	(A) 790319-5	(B) 281829-2	
(A) 790319-4	(B) 281829-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.62+/-0.05 [1.03+/-0.02]	3.7
4.00mm2	2.16+/-0.05 [0.85+/-0.02]	8.9

- 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.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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	APPD
A	66				

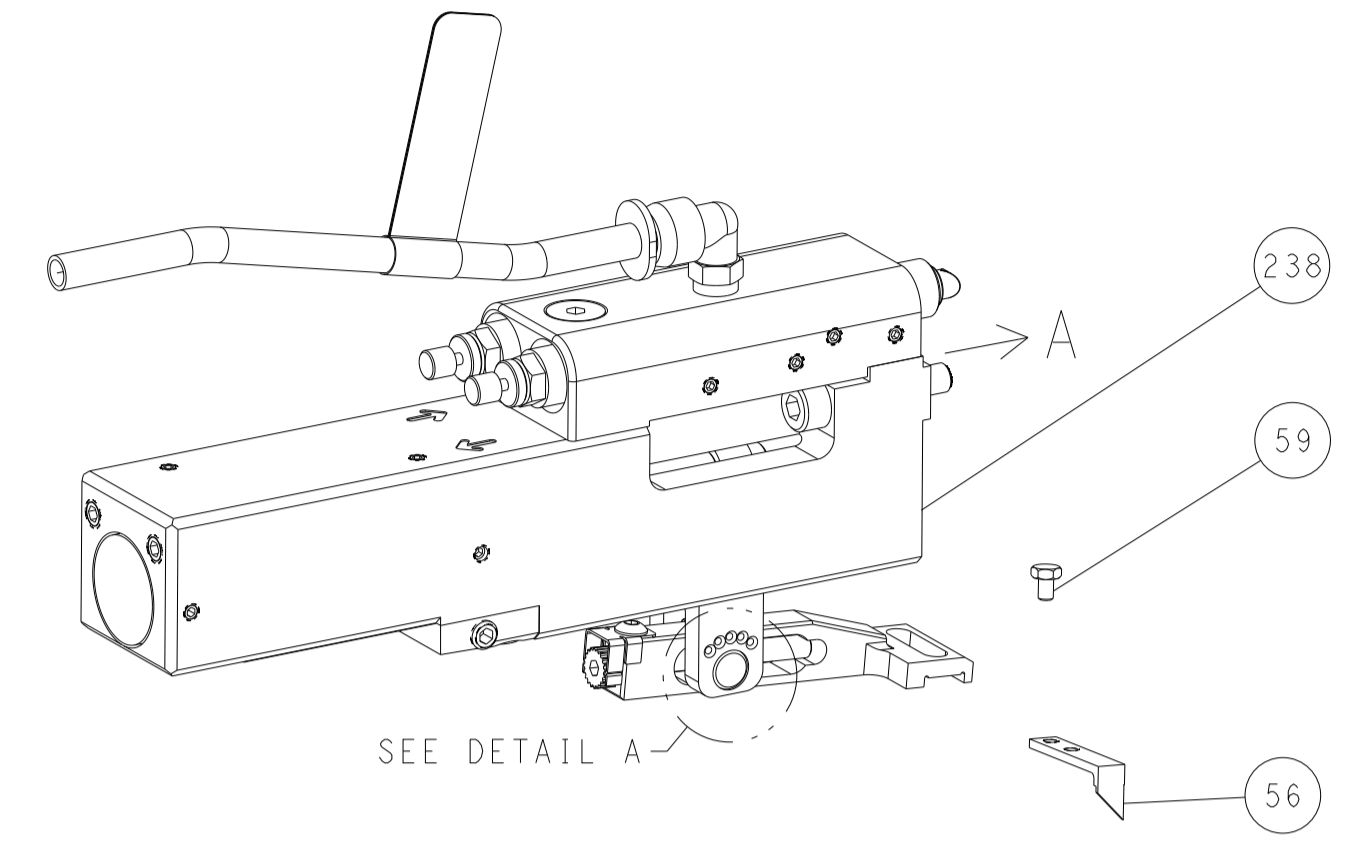
REV	DATE	DESCRIPTION	ITEM NO
-	1	2119082-9 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1 RETAINER, INSULATION DIAL	242
-	1	18023-1 SCR, SKT HD CAP M3 X 5.0	241
-	1	2844940-2 AIR FEED MODULE	238
-	REF	994970-2 COUNTER, MAGNETIC	164
-	1	2119641-2 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	455888-4 SPACER, CRIMPER	120
-	1	1-18028-2 WASHER, FLAT, REG M4	119
-	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	455888-5 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	2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0	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	6-1752356-3 SUPPORT, TERMINAL	34
-	2	1-2079383-3 SCR, BHSC, RoHS (M4 X 25)	33
-	2	3-2844962-5 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-3 ASSEMBLY, 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	1333211-1 ANVIL, COMBINATION .150-.300	8
-	1	1-240641-1 SPACER	7
-	1	1-2119757-0 DEPRESSOR, SHEAR	5
-	1	1-238011-7 BLOCK, CRIMPER SPACER	4
1	1	1-1633961-6 CRIMPER, INSULATION F PREMIUM	3
-	1	455888-3 SPACER, CRIMPER	2
1	1	456414-9 CRIMPER, WIRE	1
-77	-22	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG Y. YIN 12AUG2011		CHK G. BAILEY 12AUG2011		APVD S. XI 12AUG2011		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	Customer Accessible Production Drawing		SCALE 1:2	SHEET 3 OF 4
MATERIAL		WEIGHT		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
				A1		00779		©=2151487		REV E	

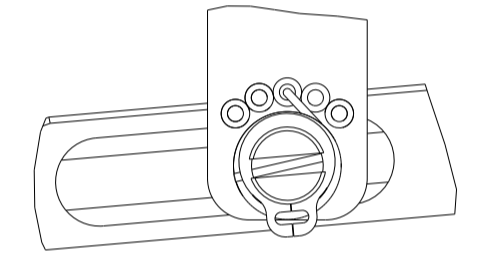
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

# FEED TYPE

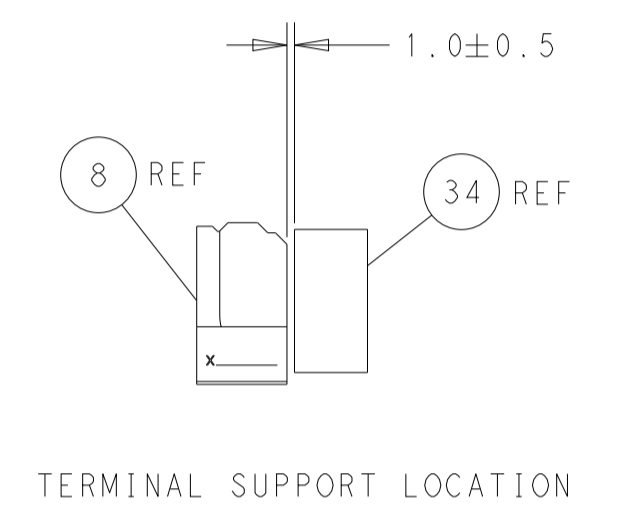
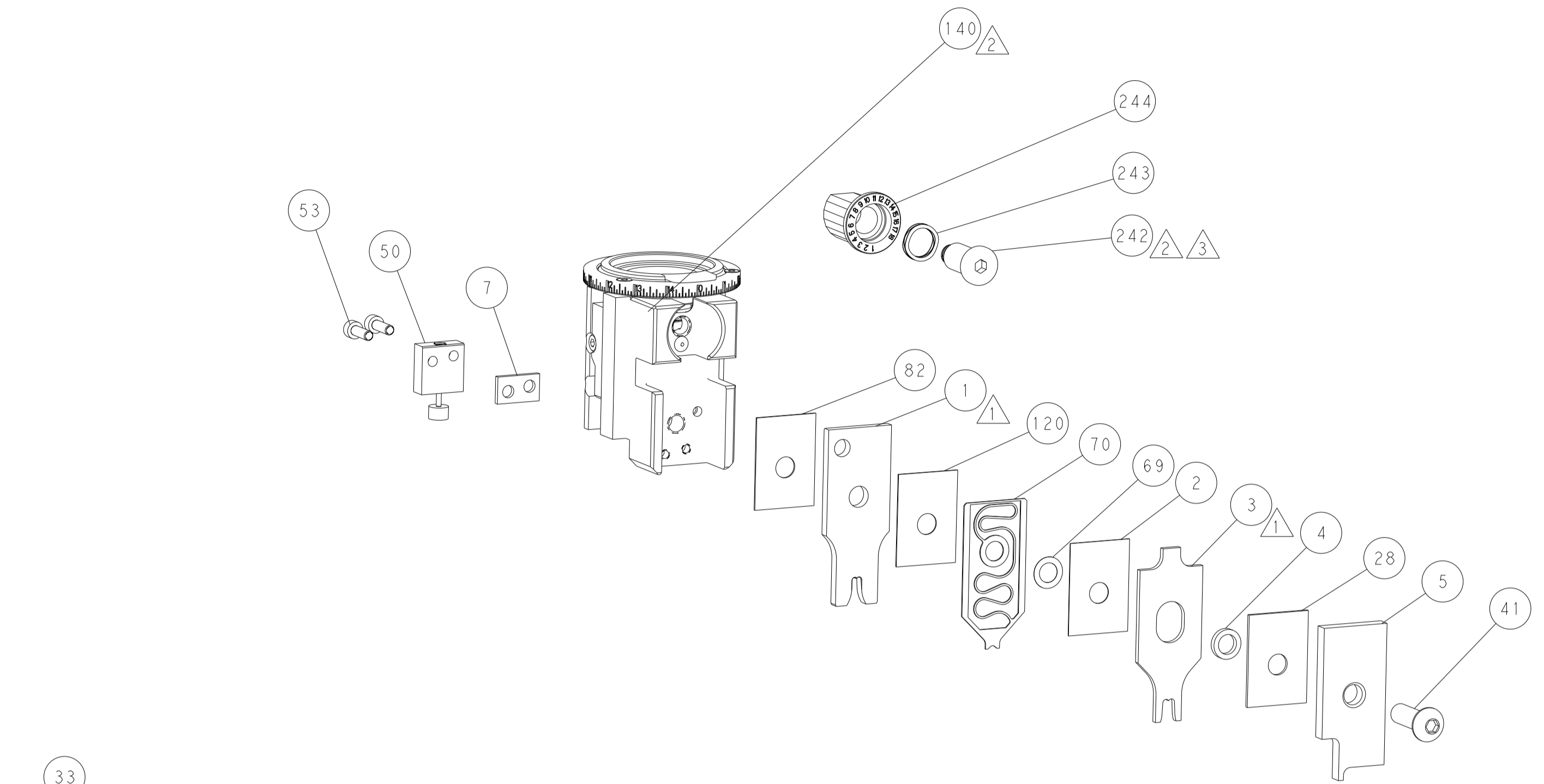
## PNEUMATIC



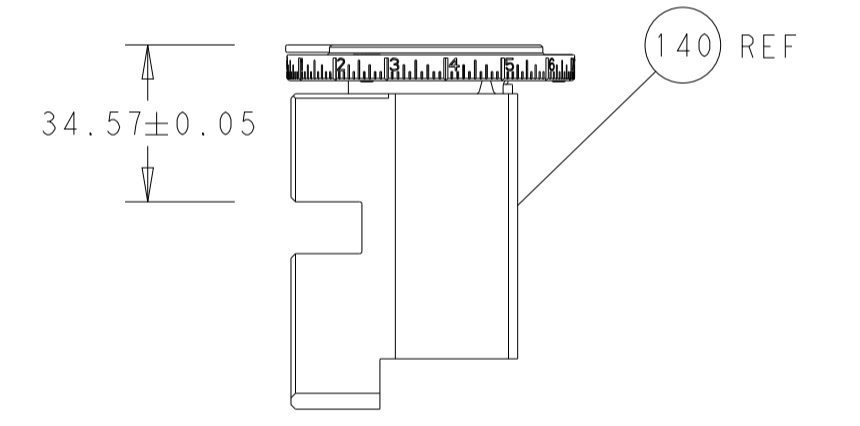
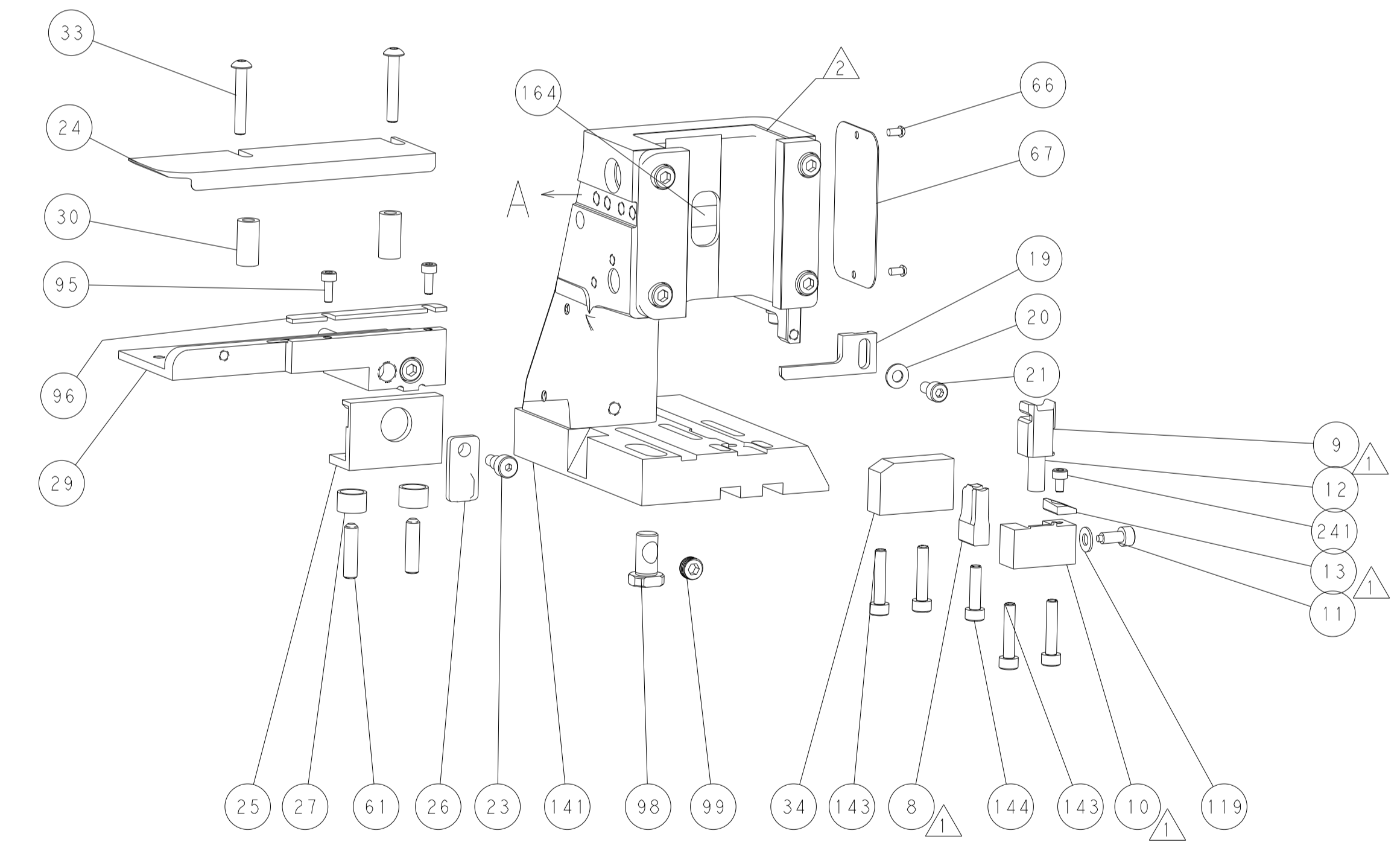
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

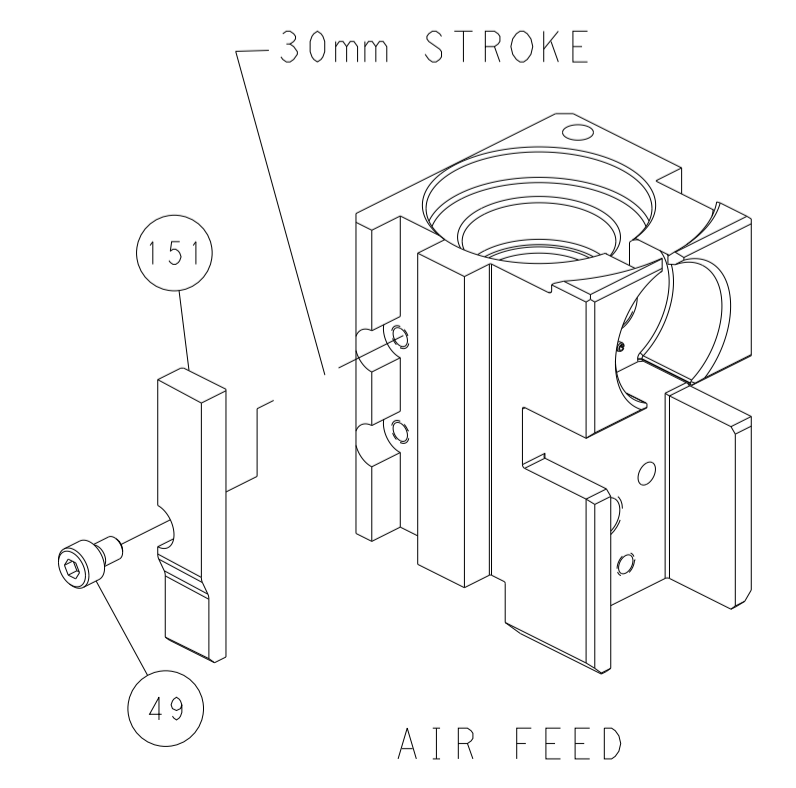


TERMINAL SUPPORT LOCATION

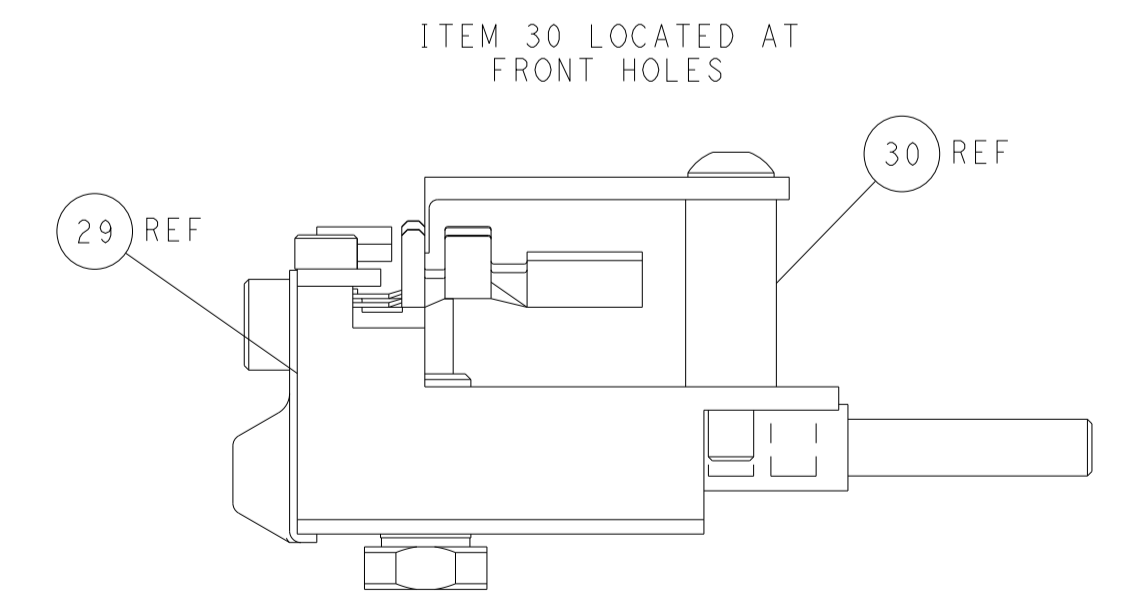


RAM SET-UP

## CAM POSITION



AIR FEED



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 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN Y. YIN 12AUG2011 CHK G. BAILEY 12AUG2011 APVD S. XI 12AUG2011	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 -		NAME PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO A1 00779 ©=2151487 RESTRICTED TO SHEET 4 OF 4 REV E
Customer Accessible Production Drawing		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	