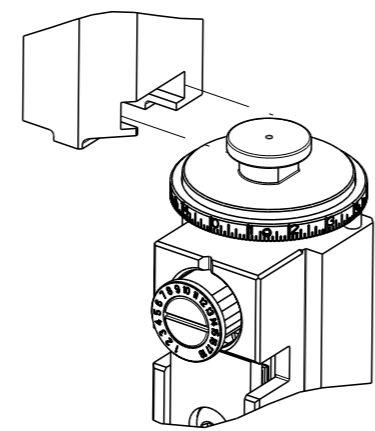


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151608-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151608-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151608-1	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151608-2	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151608-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151608-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151608-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.90 mm [.075]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: MINI SPOX CRIMP RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.60-3.20 mm [.102-.126 IN]		Ø1.15-1.90 mm [.045-.075 IN]	
TERMINAL APPLICATION SPECIFICATION		ATS 63900-4600 Rev C	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572094-1	08-70-0058	1572094-8	08-700-0589
1572094-2	08-70-0056	1572094-9	39-00-0188
1572094-3	39-00-0442	1-1572094-0	39-00-0388
2113948-1	08-70-0102	1-1572094-1	39-00-0387
1572094-5	50802-8000	1-1572094-2	39-00-0389
1572094-6	50802-9001	1-1572094-3	39-00-0390
1572094-7	08-700-0569		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.35mm2	0.845+/-0.025 [.033+/- .001]	7.4
24 AWG OR 0.20mm2	0.775+/-0.025 [.031+/- .001]	8.1
26 AWG OR 0.12mm2	0.725+/-0.025 [.029+/- .001]	8.6
28 AWG OR 0.08mm2	0.685+/-0.025 [.027+/- .001]	9.0

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.

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

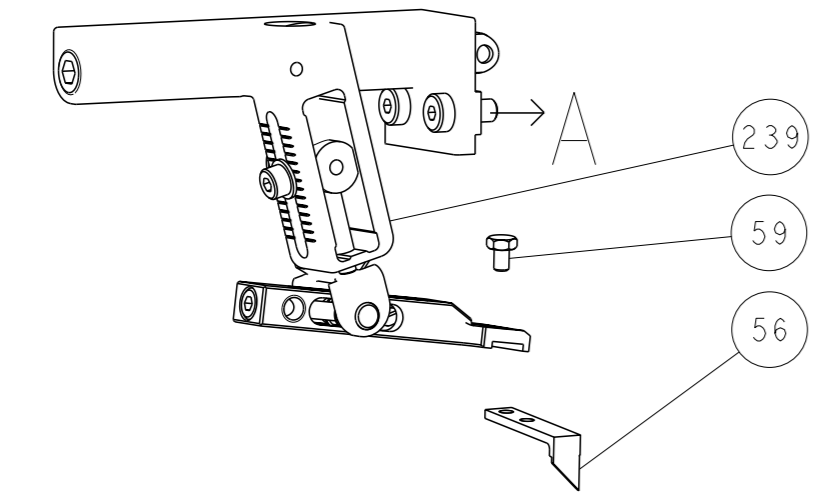
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		B		ECR-13-014078	09SEP2013	KH	TE
		B1		ECR-16-000233	07JAN2016	YY	JD
		C		ECR-16-015093	25OCT2016	MZ	TE
		D		ECR-19-007763	15MAY2019	LG	TE

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-6	STANDOFF, HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	2	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	2-1752356-5	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1633932-3	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1-1633962-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	2	2	1	1	1	1	2-456402-9	CRIMPER, WIRE PREMIUM	1

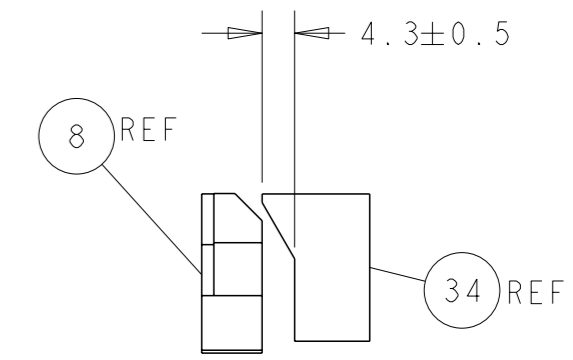
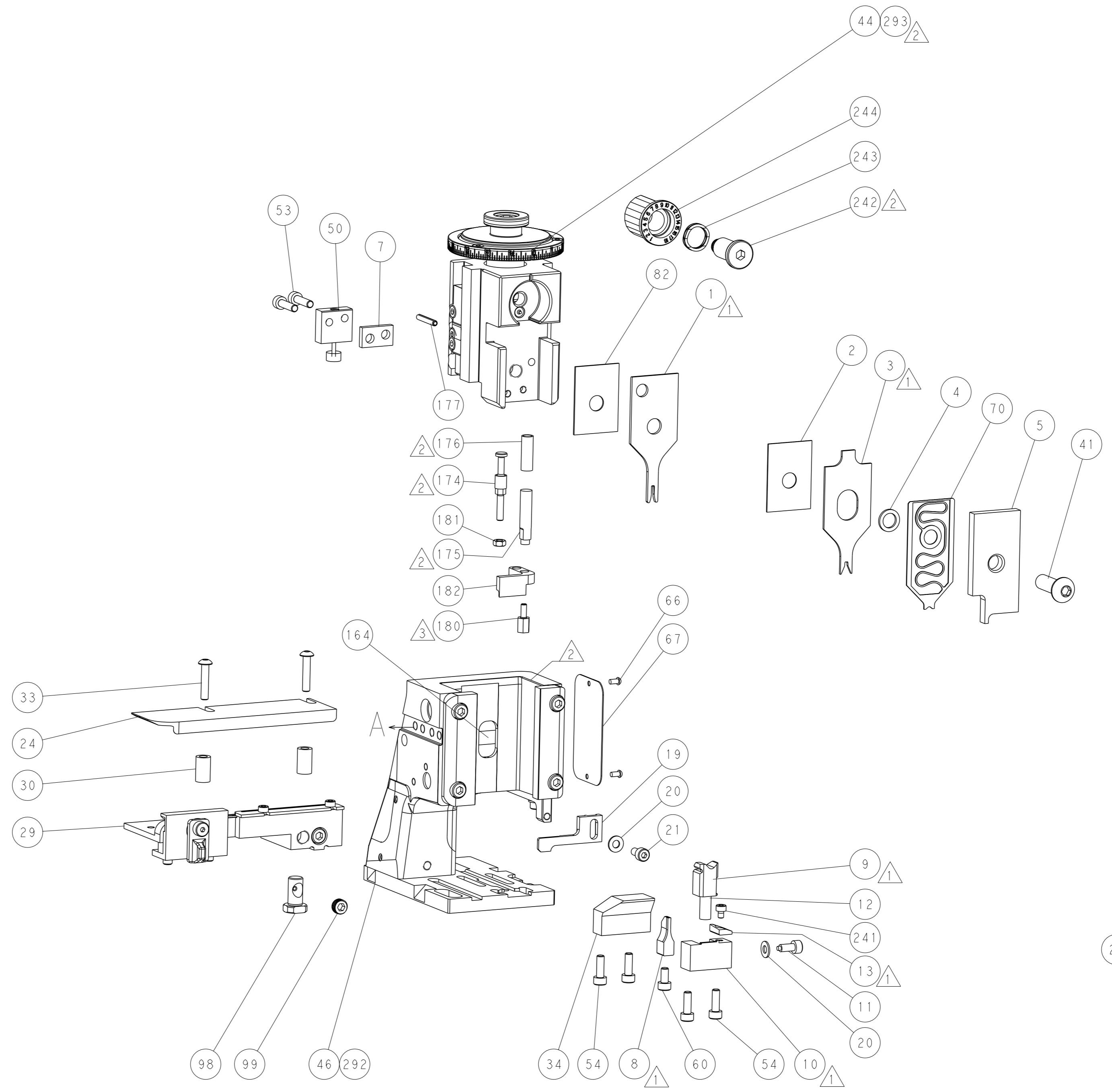
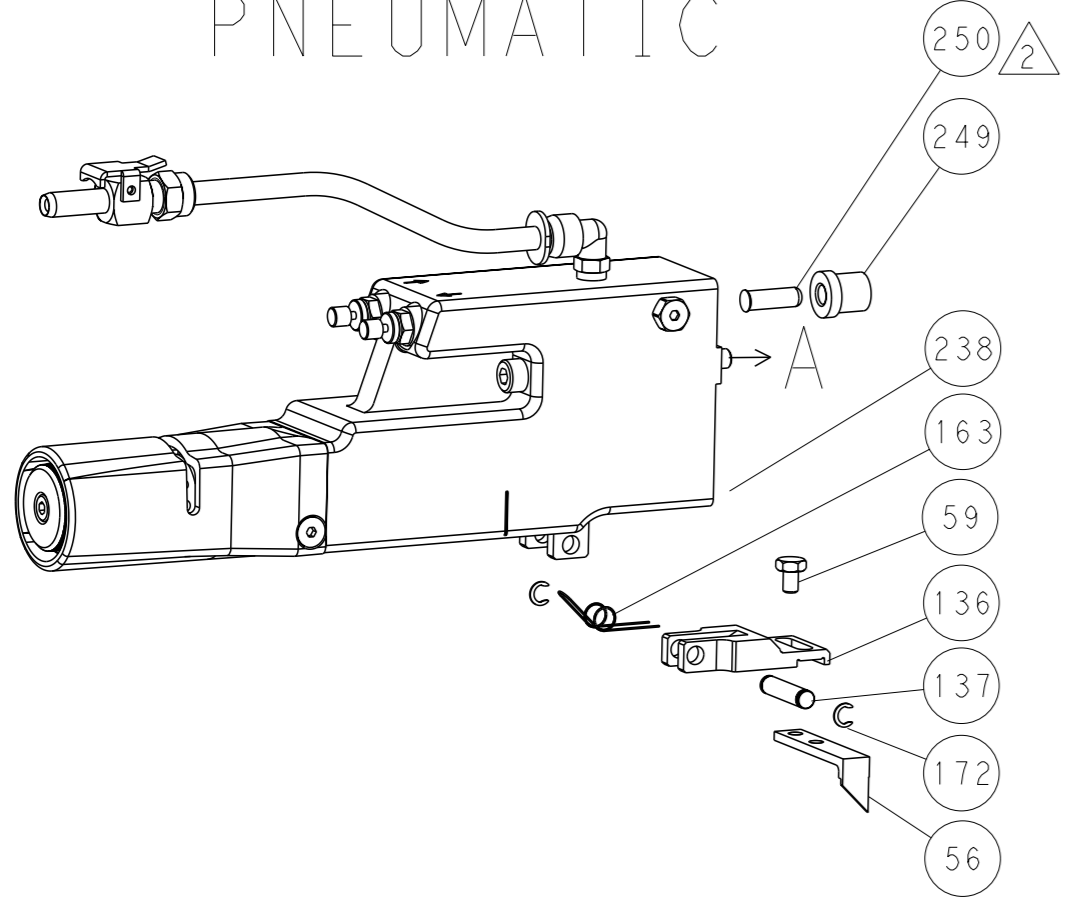
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	3 PLC ±	4 PLC ±	ANGLES ±	T. ELBIN	22FEB2012	Harrisburg, PA 17105-3608	
	FINISH			M. CLIFFORD	22FEB2012	Ocean Side Feed Applicator	
MATERIAL						SIZE	CAGE CODE
						A1	00779
						DRAWING NO	©=2151608
						RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE 1:2 SHEET 1 of 4 REV D

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

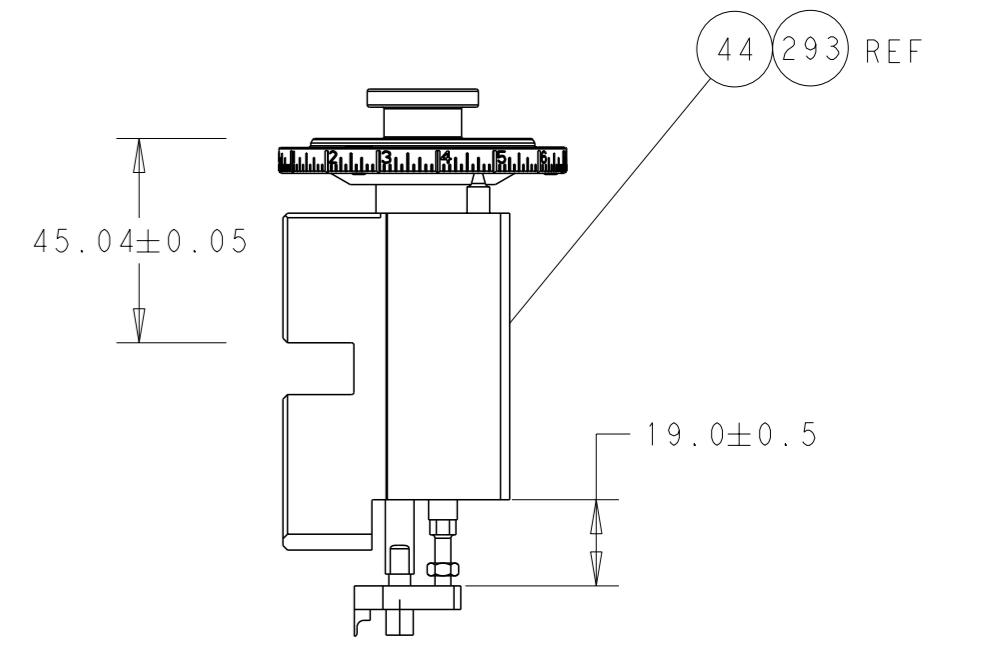
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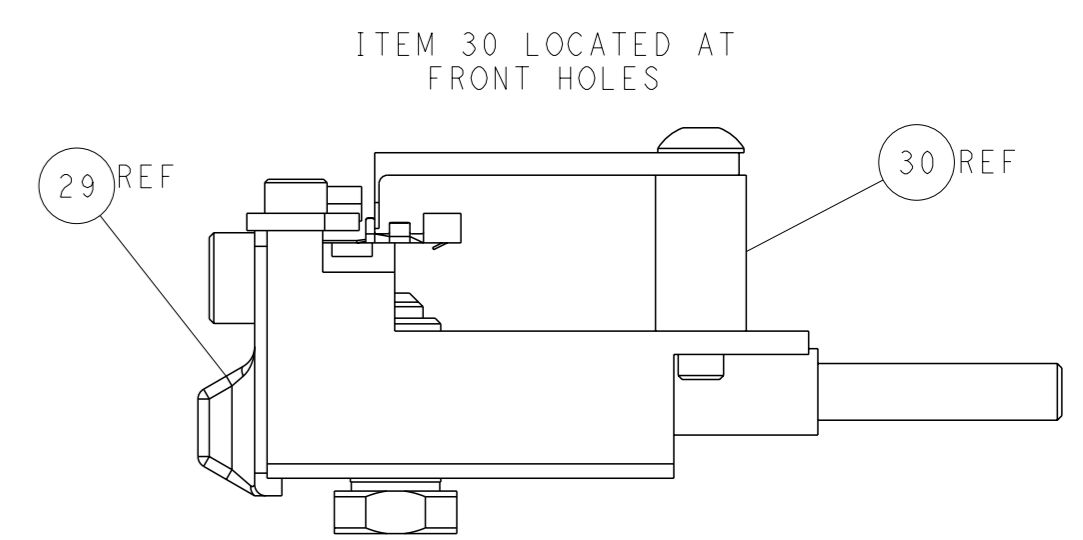
PNEUMATIC



TERMINAL SUPPORT LOCATION

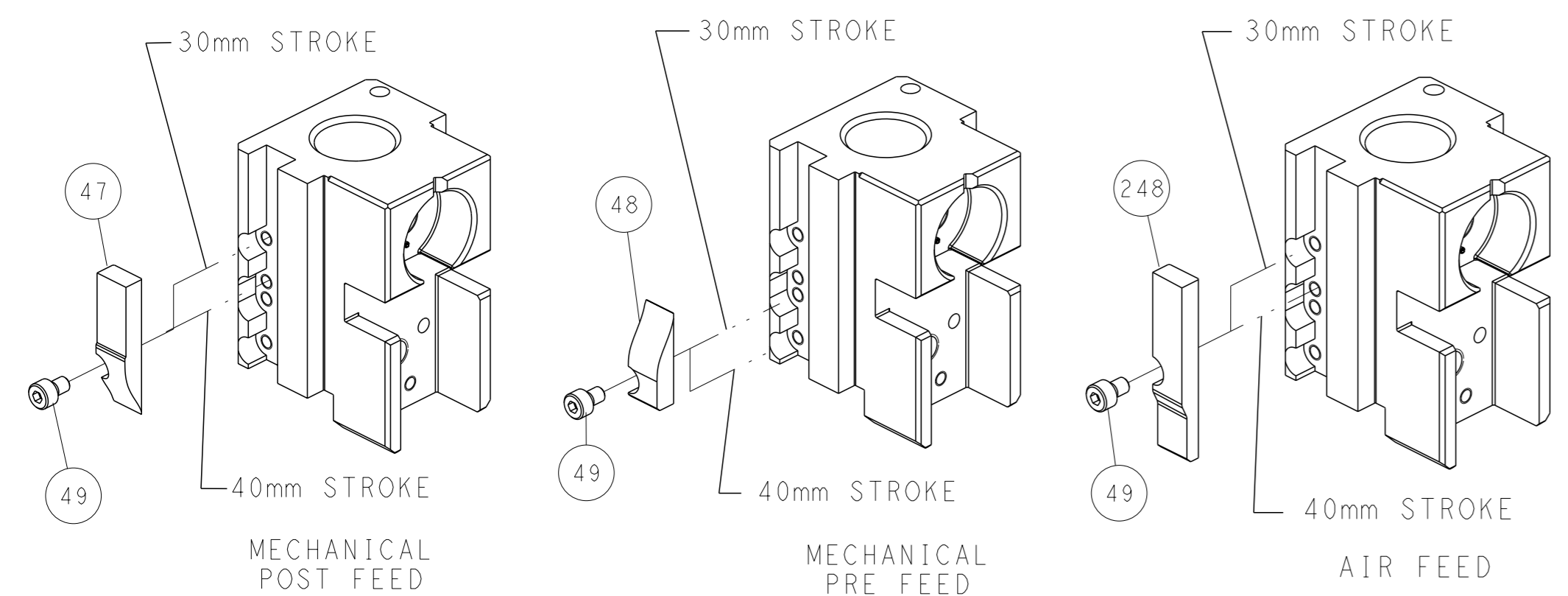


RAM & HOLD DOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

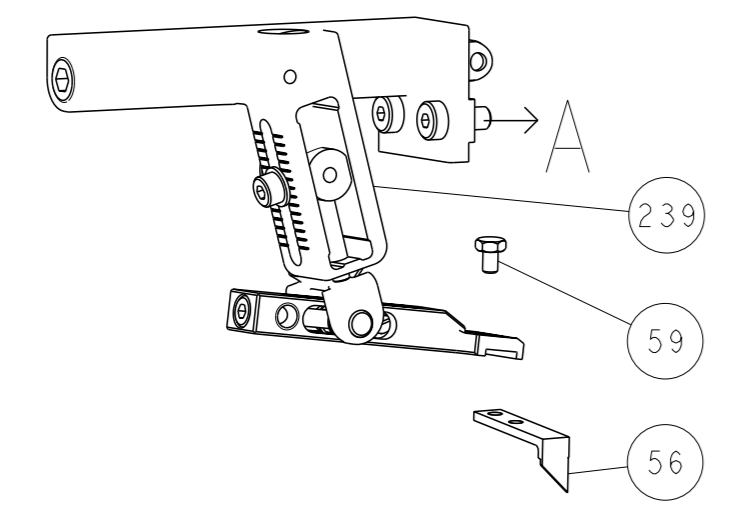


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

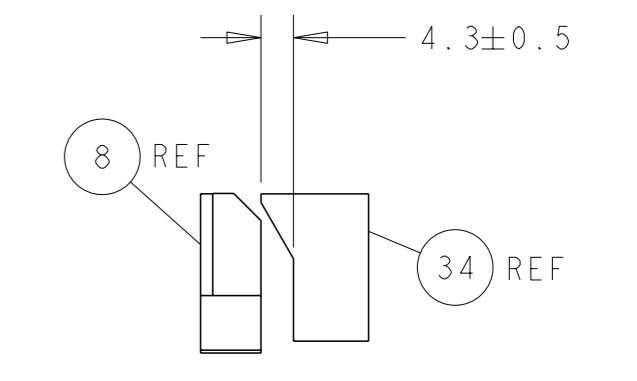
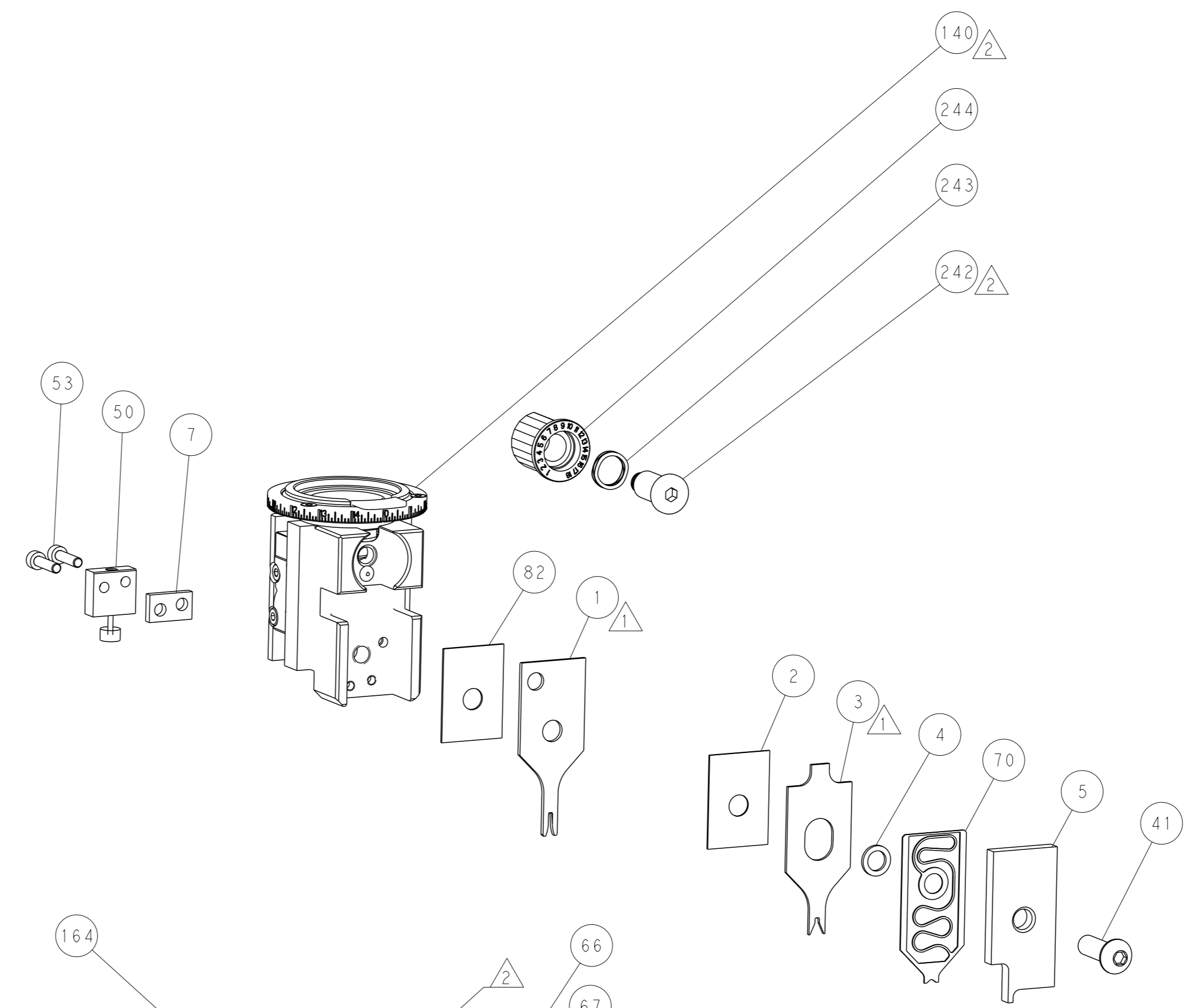
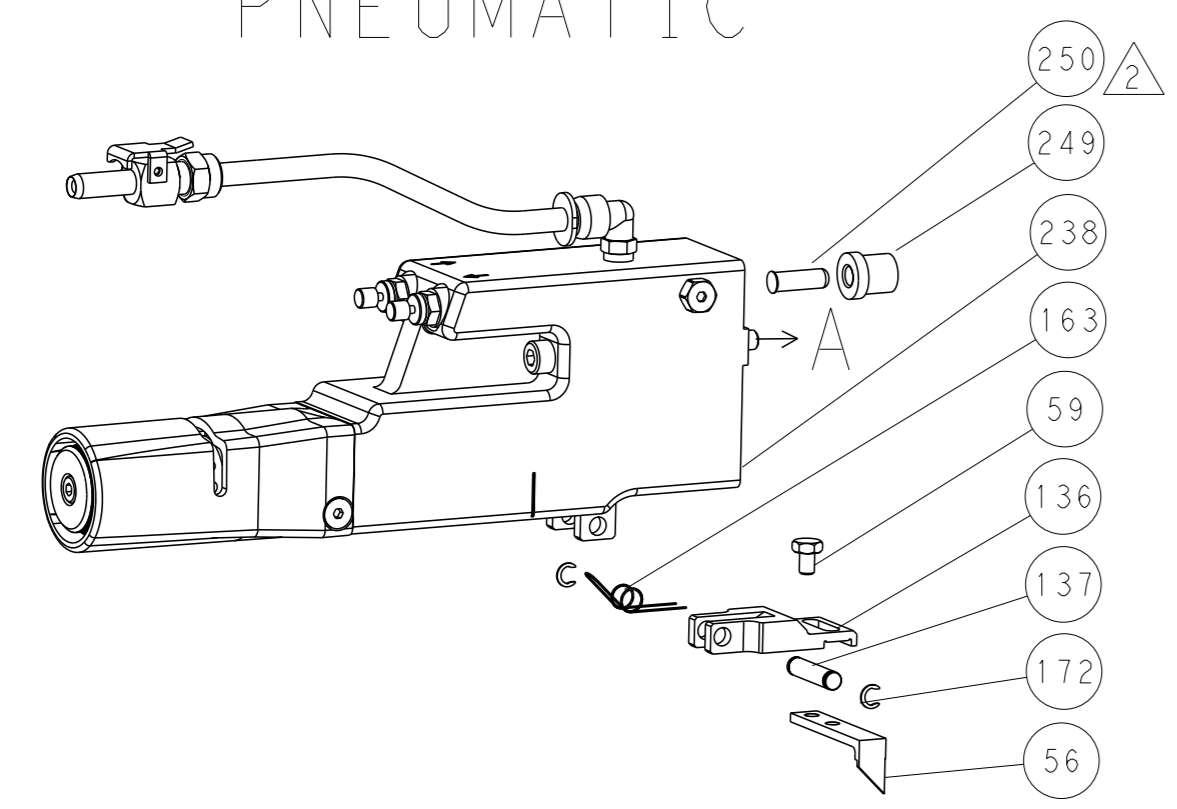
<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: BOB HIGMAN 22FEB2012 CHK: T. ELBIN 22FEB2012 APVD: M. CLIFFORD 22FEB2012	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151608	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: - SCALE: 1:2 SHEET: 2 of 4 REV: D	RESTRICTED TO: -	Customer Accessible Production Drawing	

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

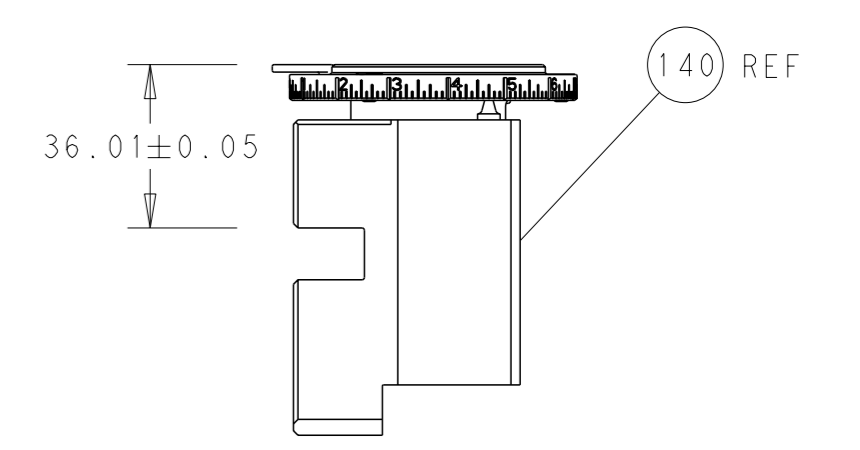
FEED TYPE MECHANICAL



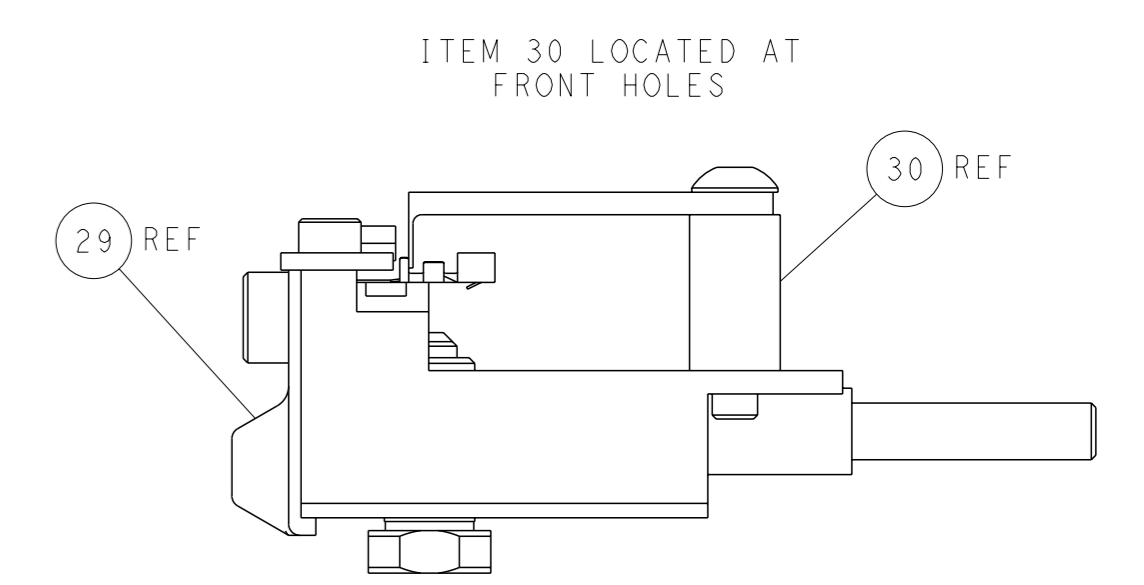
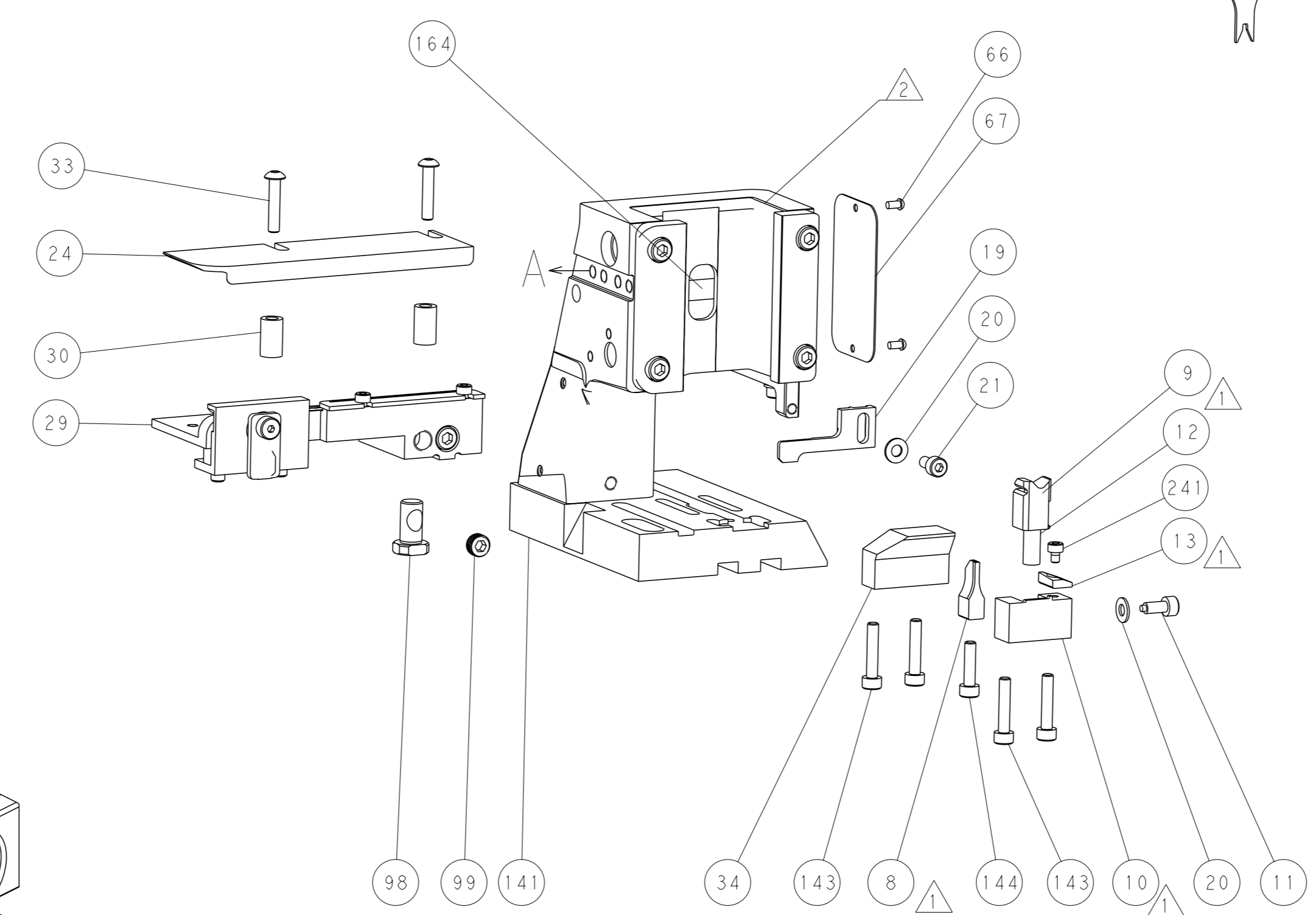
PNEUMATIC



TERMINAL SUPPORT LOCATION

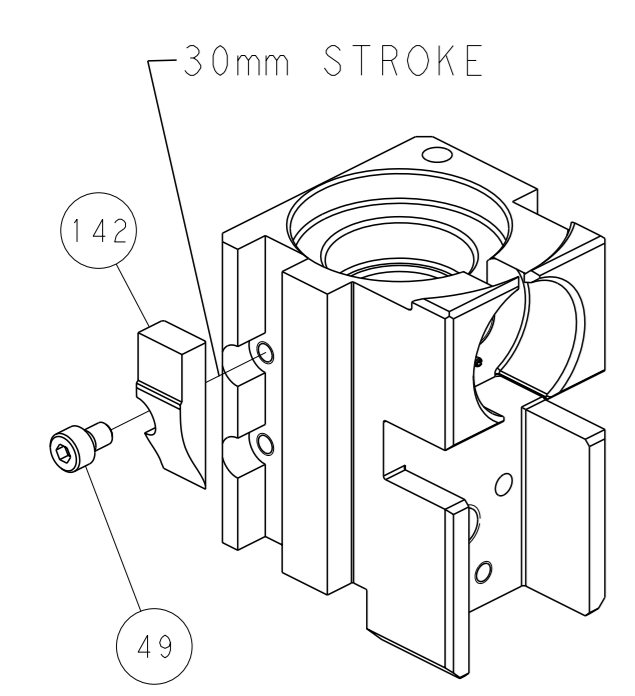


RAM SET-UP

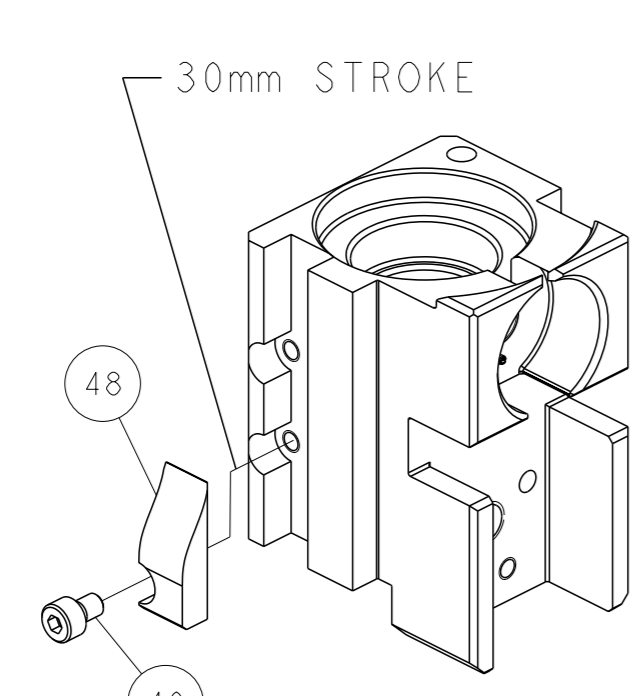


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

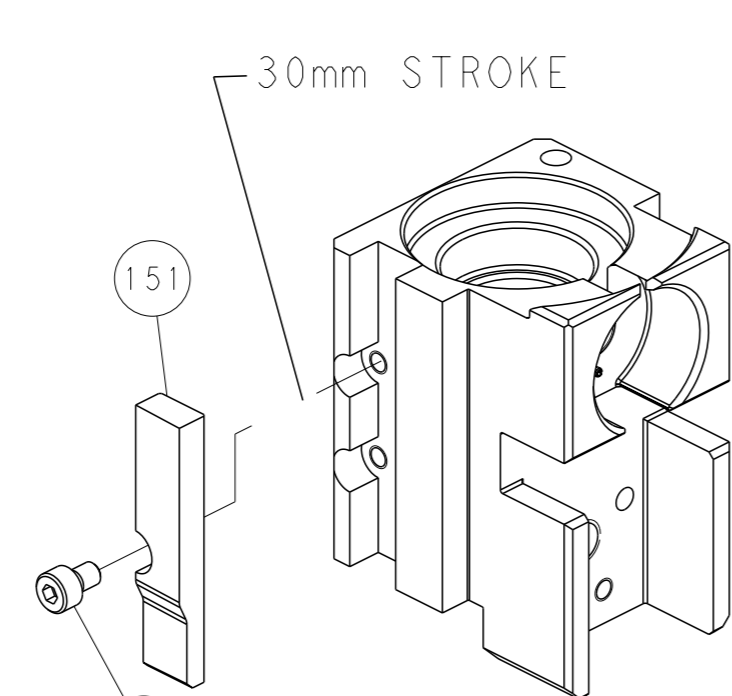
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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 USER MUST CONTACT THE ORGANIZATION WHOSE BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: BOB HIGMAN 22FEB2012 CHK: T. ELBIN 22FEB2012 APVD: M. CLIFFORD 22FEB2012 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151608 SCALE: 1:2 SHEET: 1 of 4 REV: D	TE Connectivity Harrisburg, PA 17105-3608
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