

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151654-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151654-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151654-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151654-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151654-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: POWER TERMINAL UNI F630 WITH CLIP			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.10-5.90 mm [.201-.232 IN]	Ø2.20-3.20 mm [.087-.126 IN]		
TERMINAL APPLICATION SPECIFICATION	B0-018.003A		
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
1949167-1	17.07920/10	1949167-2	17.07900/20

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.65+/-0.05 [.065+/- .002]	2.5
1.00mm2	1.55+/-0.05 [.061+/- .002]	3.6
0.75mm2	1.45+/-0.05 [.057+/- .002]	4.9
0.50mm2	1.35+/-0.05 [.053+/- .002]	6.1

- 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.

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

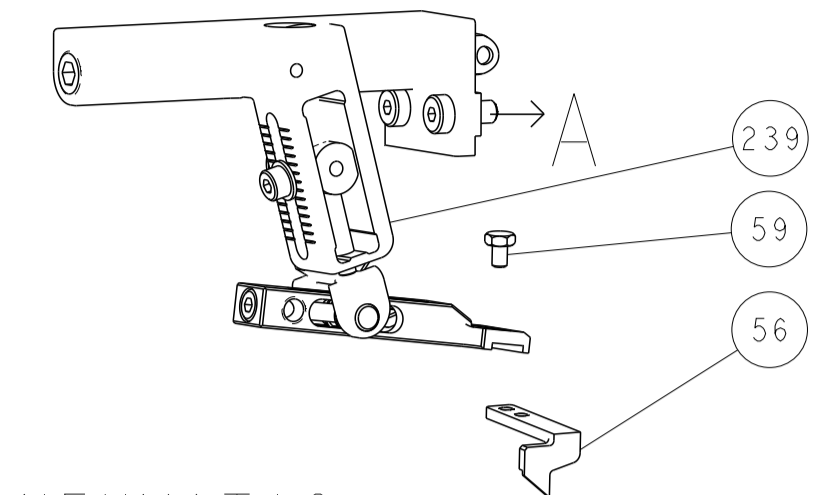
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		B		ECR-17-009911	07JUL2017	TB	GB
		C		ECR-20-013872	29SEP2020	FZ	GB
		D		ECR-22-145209	06JUL2022	ROY	GEB

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	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	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	82
-	1	1	1	1	2-455888-4	SPACER, CRIMPER	81
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1	1633782-3	FENCE	78
-	1	1	1	1	455888-1	SPACER, CRIMPER	75
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	1803611-1	PAWL, FEED (SPECIAL)	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1803382-2	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	3-22280-5	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-4	SHEAR HOLDER, FRONT	10
-	1	1	1	1	3-454276-8	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1633932-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	5-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2
-	1	2	2	1	2-456407-0	CRIMPER, WIRE PREMIUM	1

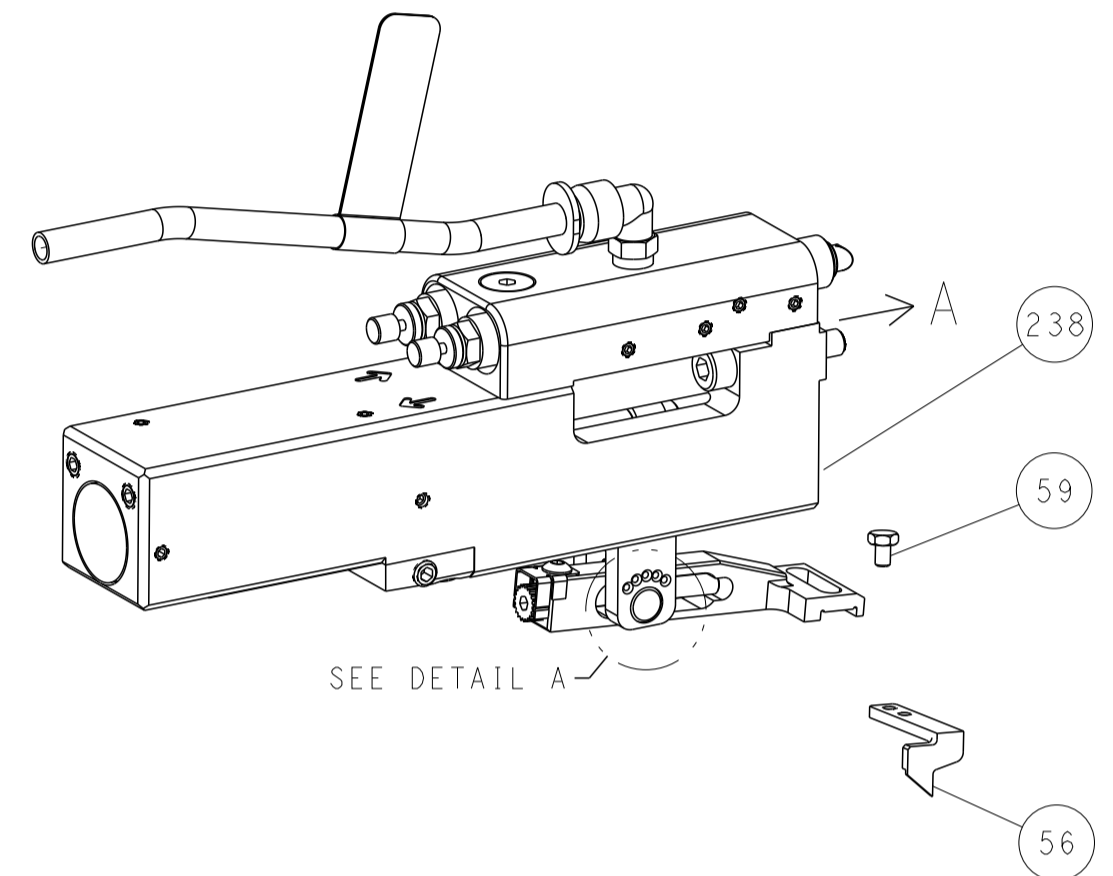
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2151654	1	4	D

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

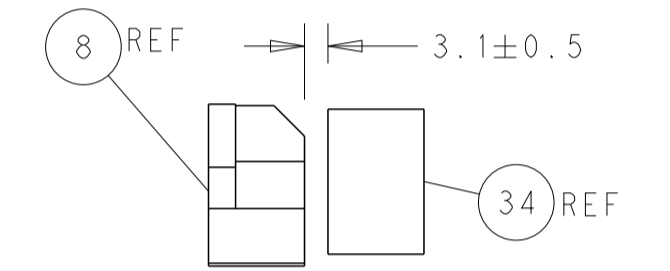
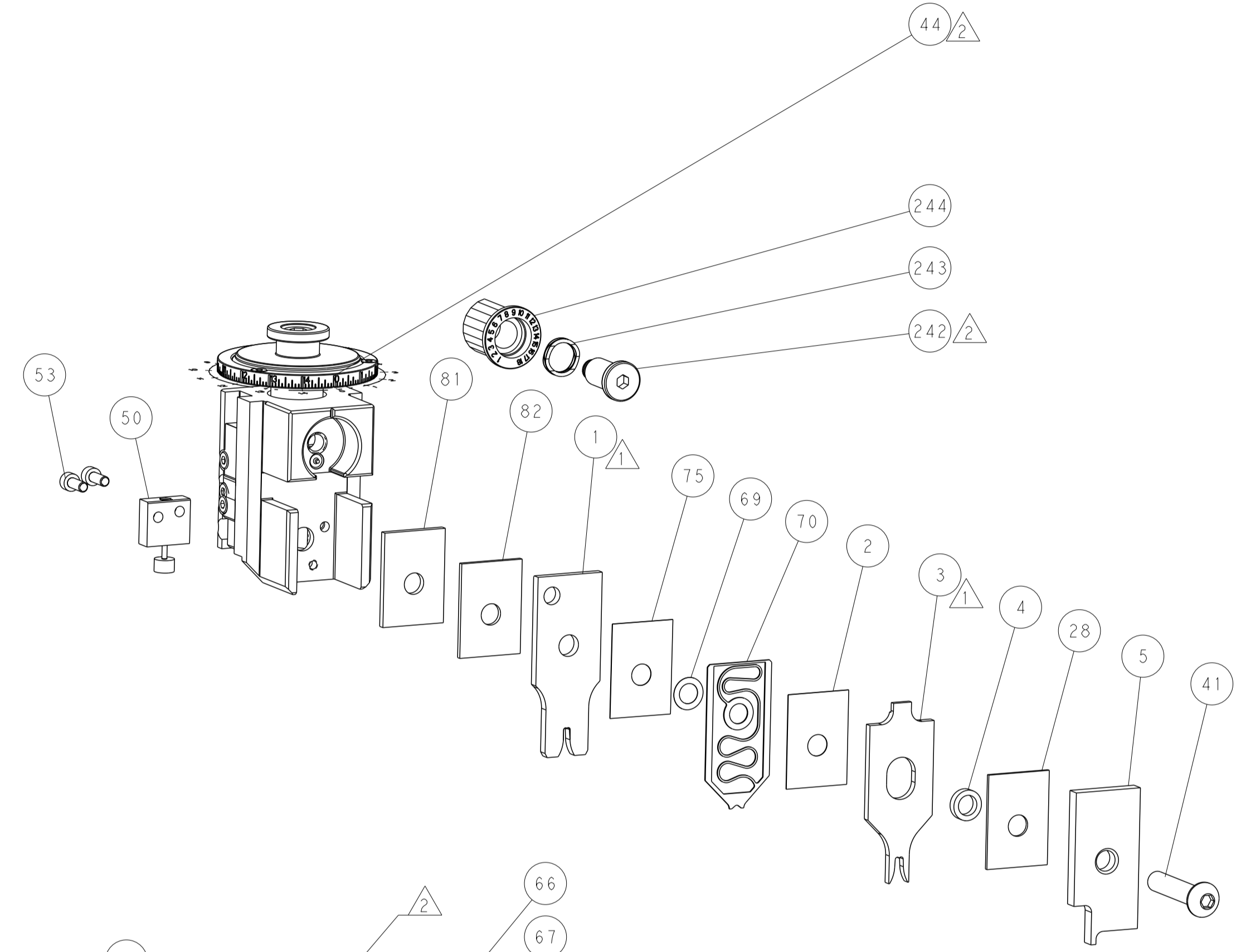
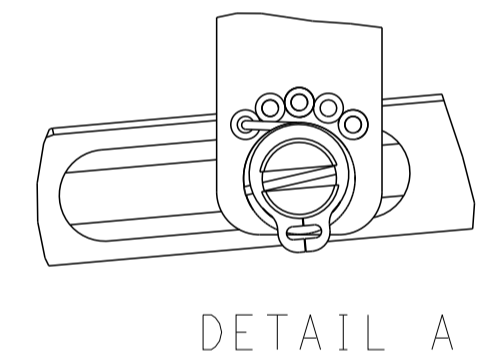
# FEED TYPE MECHANICAL



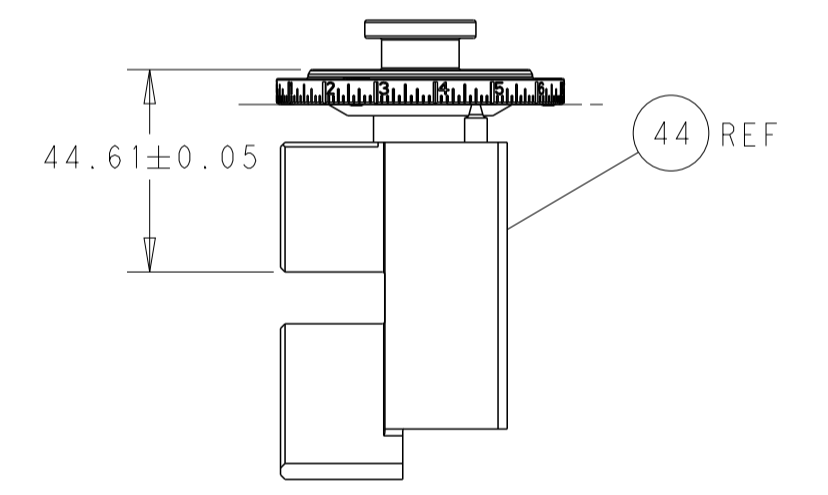
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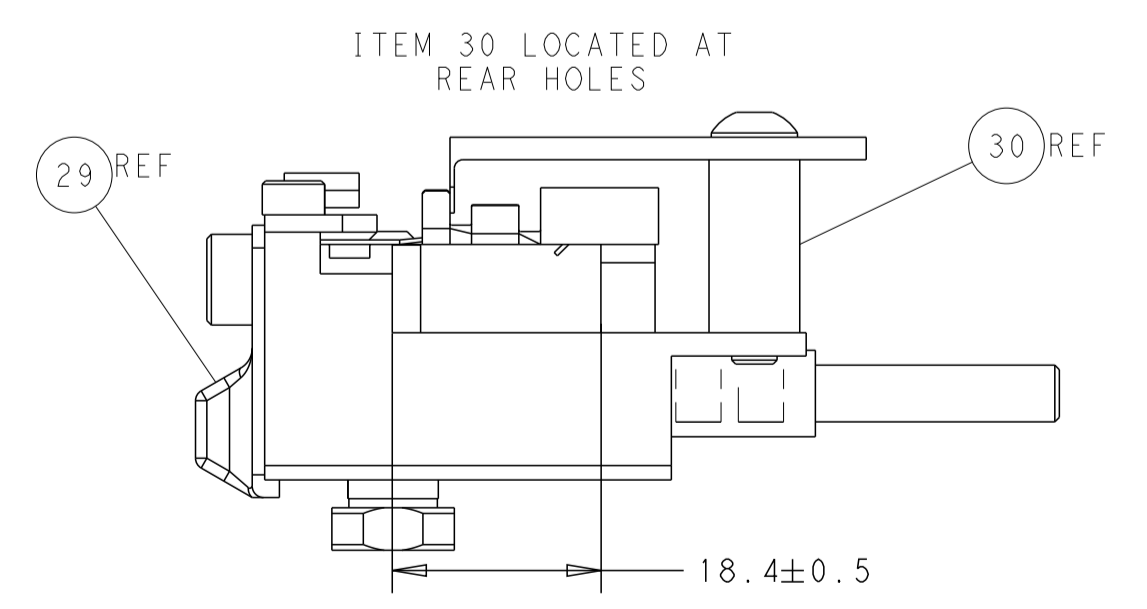
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

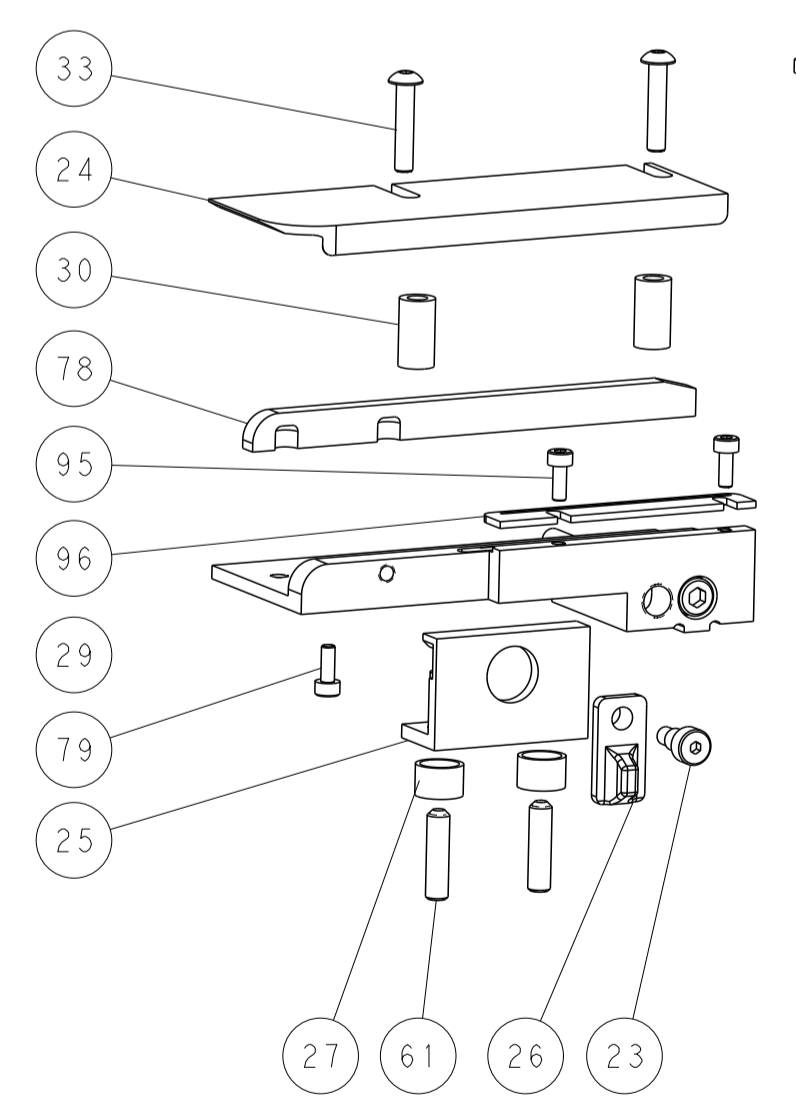
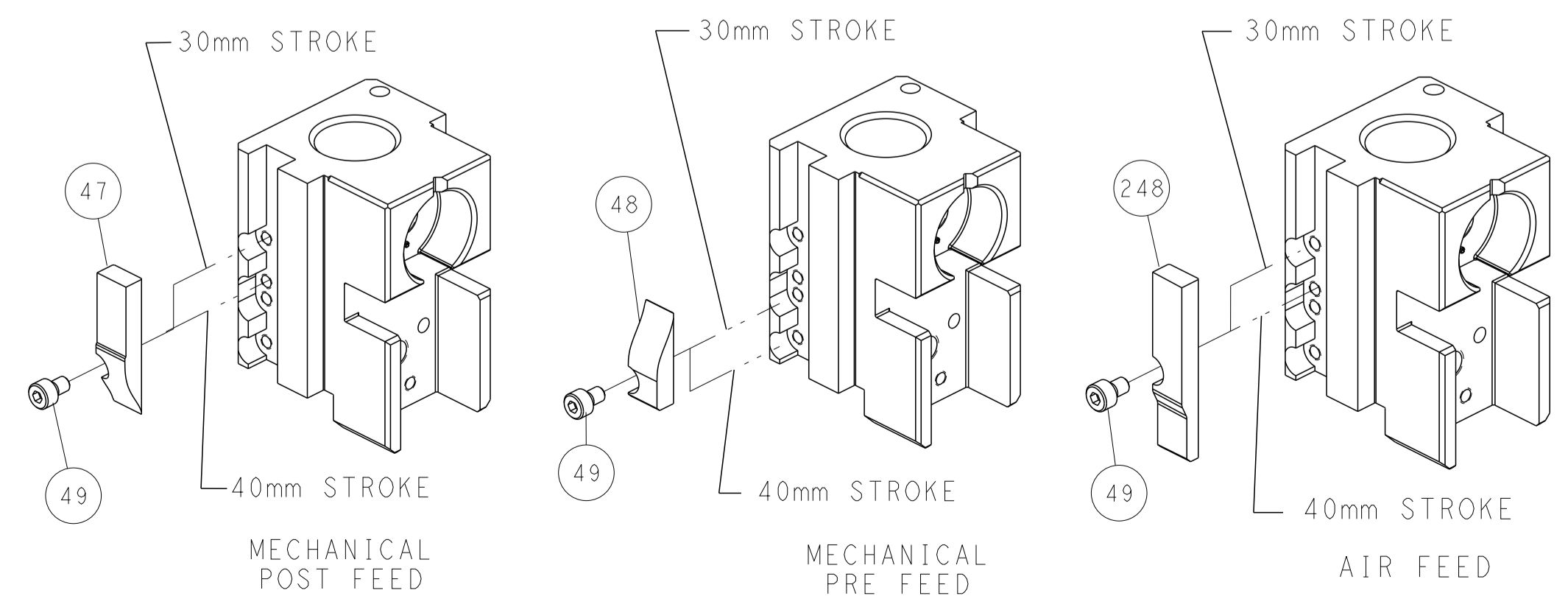


RAM SET-UP



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: R. O. WILSON 27APR2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
	ANGLES FINISH			CHK: K. J. STAKEM 27APR2012	NAME: Ocean Side Feed Applicator		
MATERIAL:				APVD: T. L. ELBIN 30APR2012	PRODUCT SPEC		
				APPLICATION SPEC		RESTRICTED TO	
				WEIGHT	SIZE: A1	CAGE CODE: 00779	DRAWING NO: ©=2151654
				Customer Accessible Production Drawing		SCALE: 1:2	SHEET: 2 of 4
				REV: D			

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151654-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151654-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151654-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: POWER TERMINAL UNI F630 WITH CLIP			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.10-5.90 mm [.201-.232 IN]		Ø2.20-3.20 mm [.087-.126 IN]	
TERMINAL APPLICATION SPECIFICATION	B0-018.003A		
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
1949167-1	17.07920/10	1949167-2	17.07900/20

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.65+/-0.05 [.065+/-0.002]	2.5
1.00mm2	1.55+/-0.05 [.061+/-0.002]	3.6
0.75mm2	1.45+/-0.05 [.057+/-0.002]	4.9
0.50mm2	1.35+/-0.05 [.053+/-0.002]	6.1

- 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.
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)

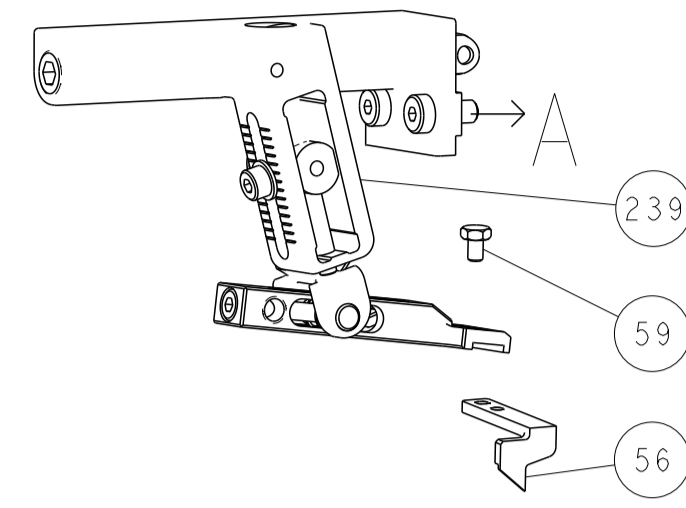
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1-455888-6	SPACER, CRIMPER	82
-	1	1	2-455888-4	SPACER, CRIMPER	81
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1633782-3	FENCE	78
-	1	1	455888-1	SPACER, CRIMPER	75
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1803611-1	PAWL, FEED (SPECIAL)	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1803382-2	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	2-1752356-0	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	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	1320928-6	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	3-22280-5	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-4	SHEAR HOLDER, FRONT	10
-	1	1	3-454276-8	FLOATING SHEAR, FRONT	9
-	1	1	1633932-8	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	5-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-2	SPACER, CRIMPER	2
-	1	1	2-456407-0	CRIMPER, WIRE PREMIUM	1

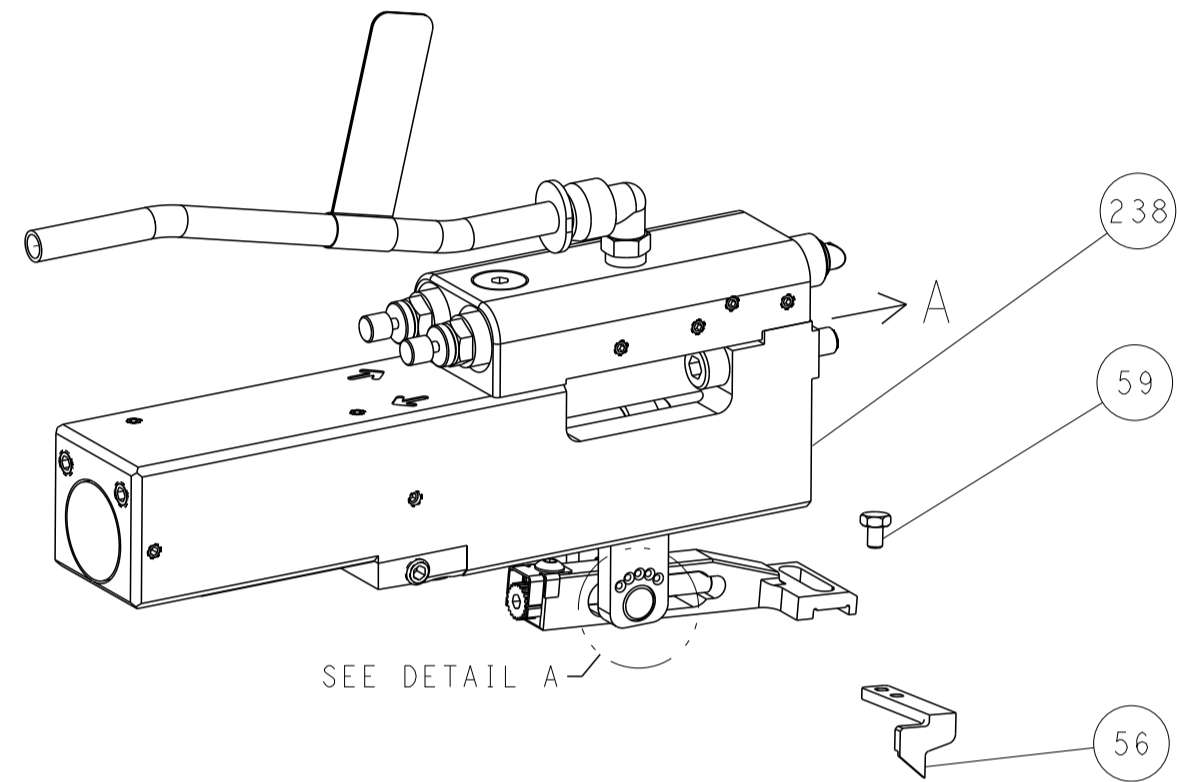
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R.O. WILSON 27APR2012		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CHK: K.J. STARKEM 27APR2012		NAME: Ocean Side Feed Applicator	
2 PLC ±		3 PLC ±		APVD: T.L. ELBIN 30APR2012		SIZE: A1	
4 PLC ±		5 PLC ±		PRODUCT SPEC		CAGE CODE: 00779	
6 PLC ±		FINISH		APPLICATION SPEC		DRAWING NO: 2151654	
MATERIAL		WEIGHT		RESTRICTED TO		SCALE: 1:2	
				Customer Accessible Production Drawing		SHEET 3 OF 4	

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

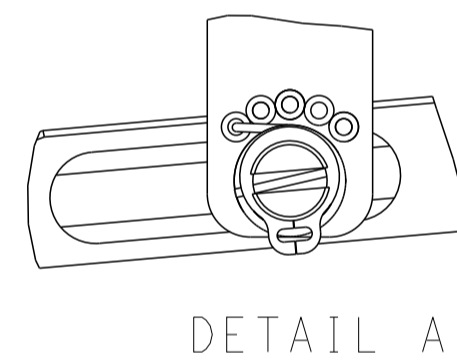
# FEED TYPE MECHANICAL



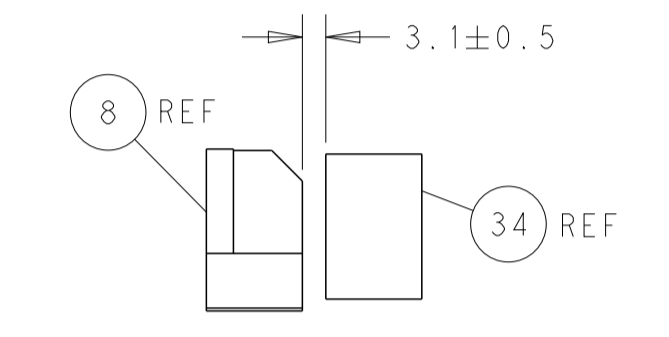
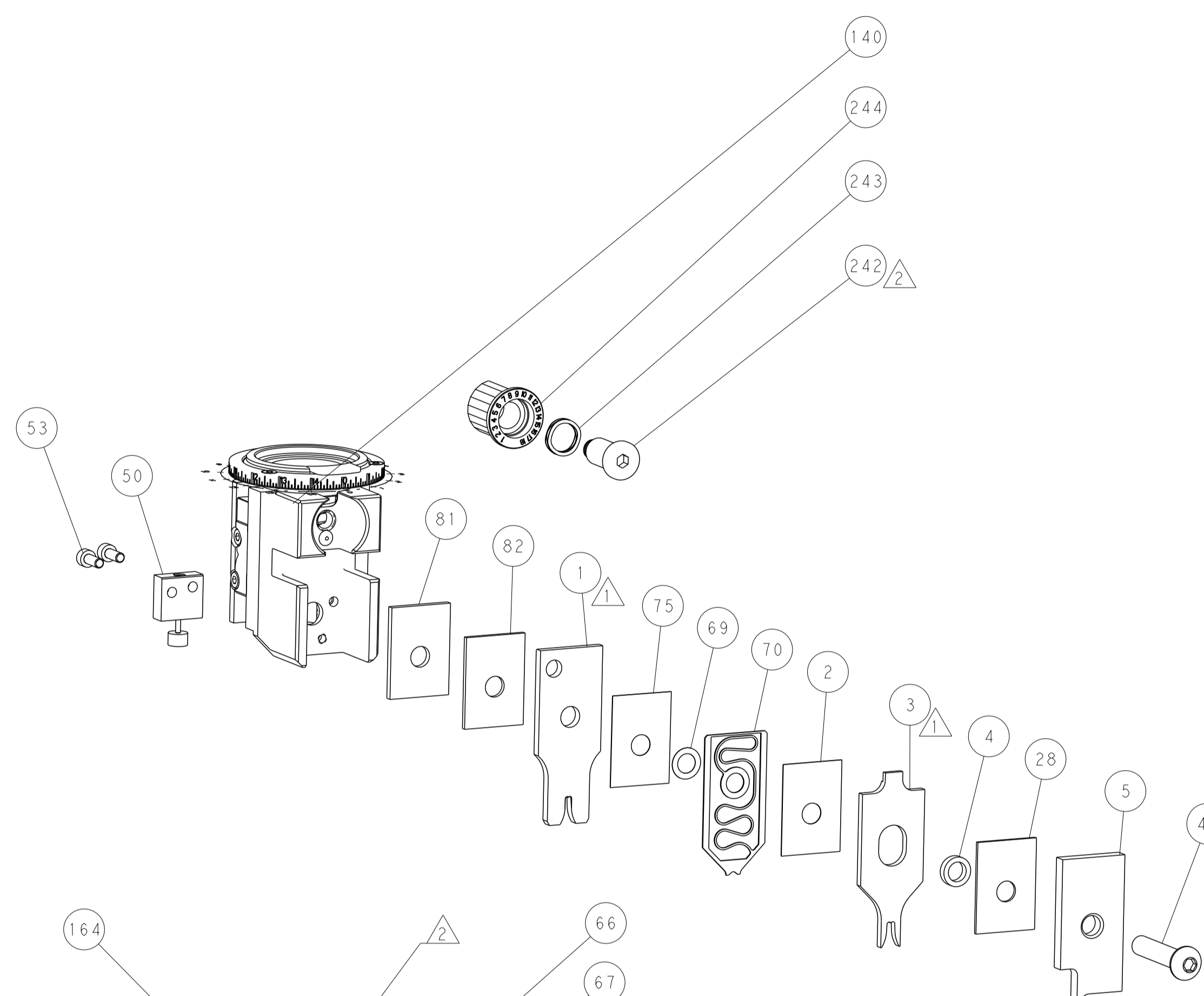
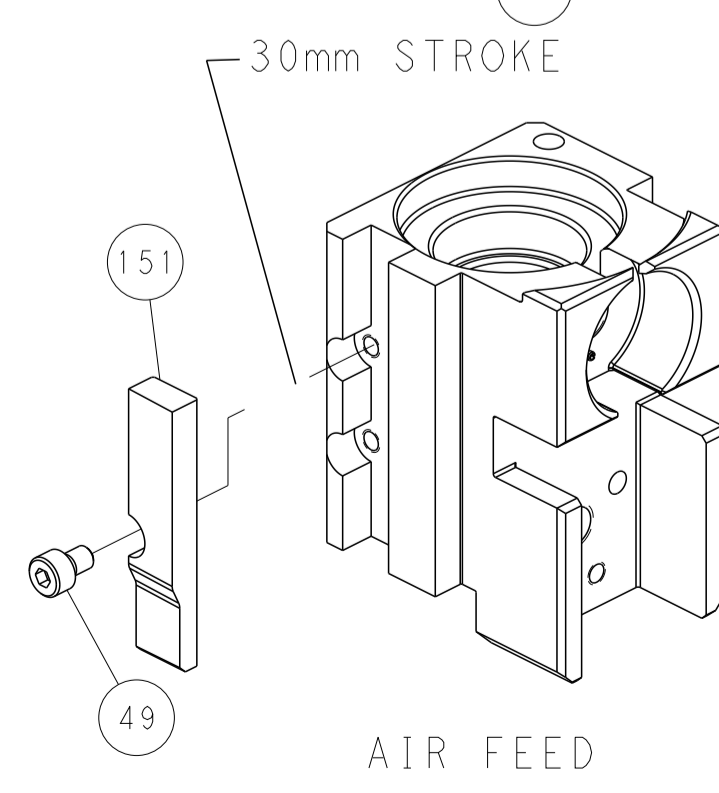
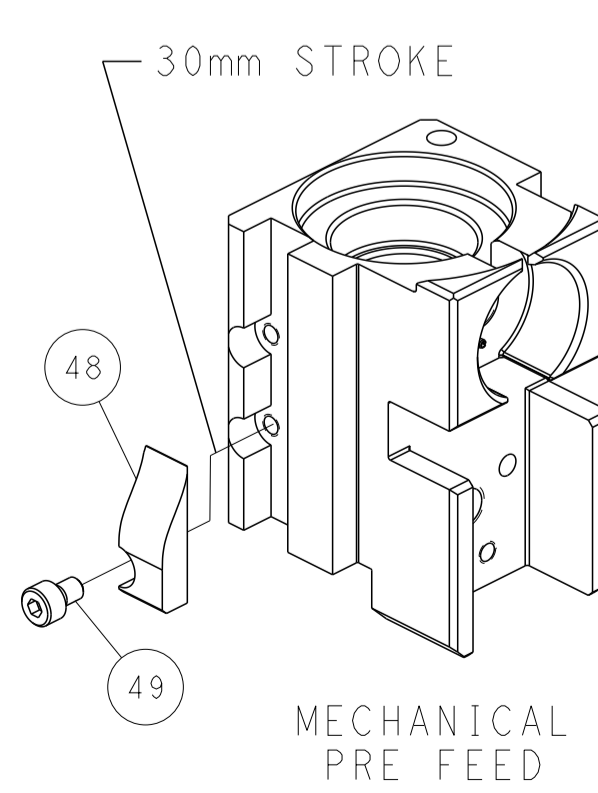
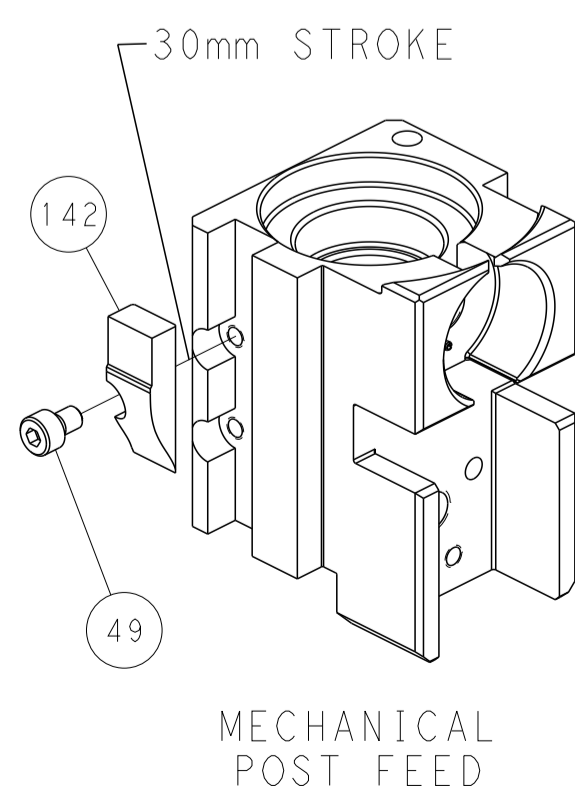
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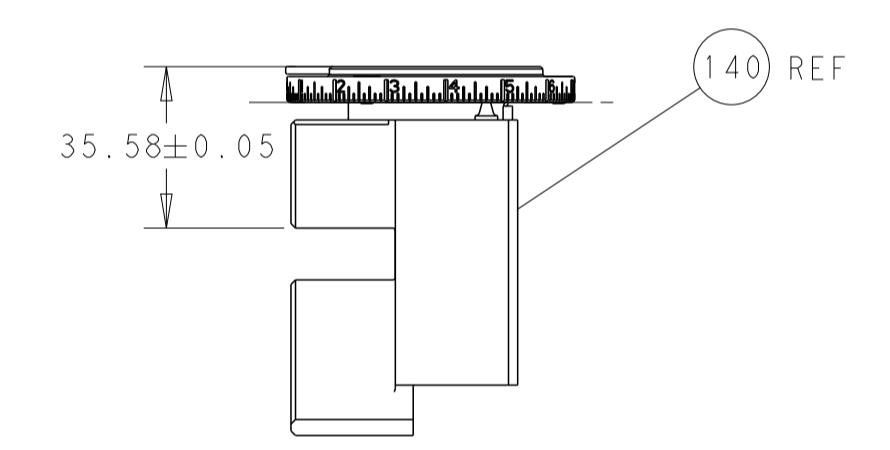
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



## CAM POSITIONS

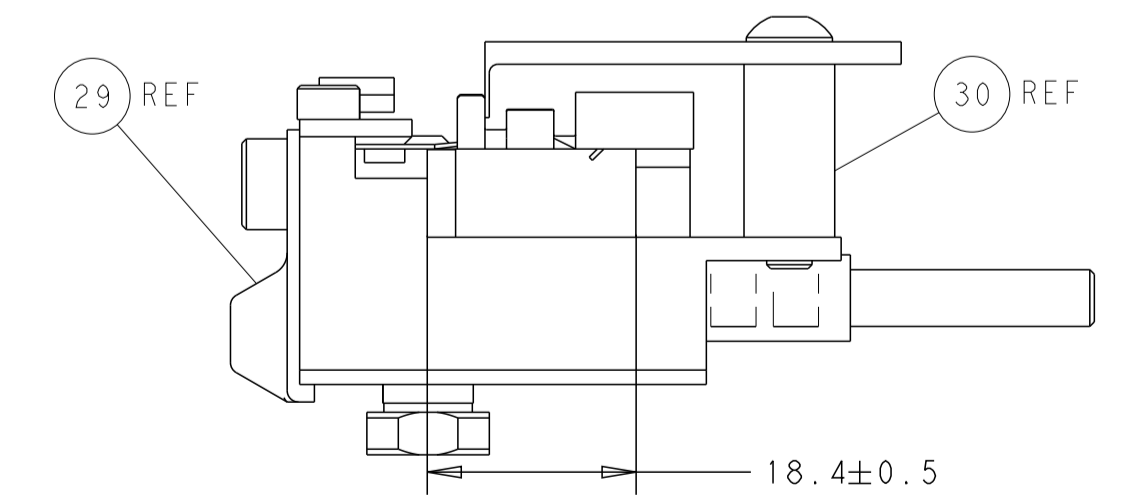


TERMINAL SUPPORT LOCATION

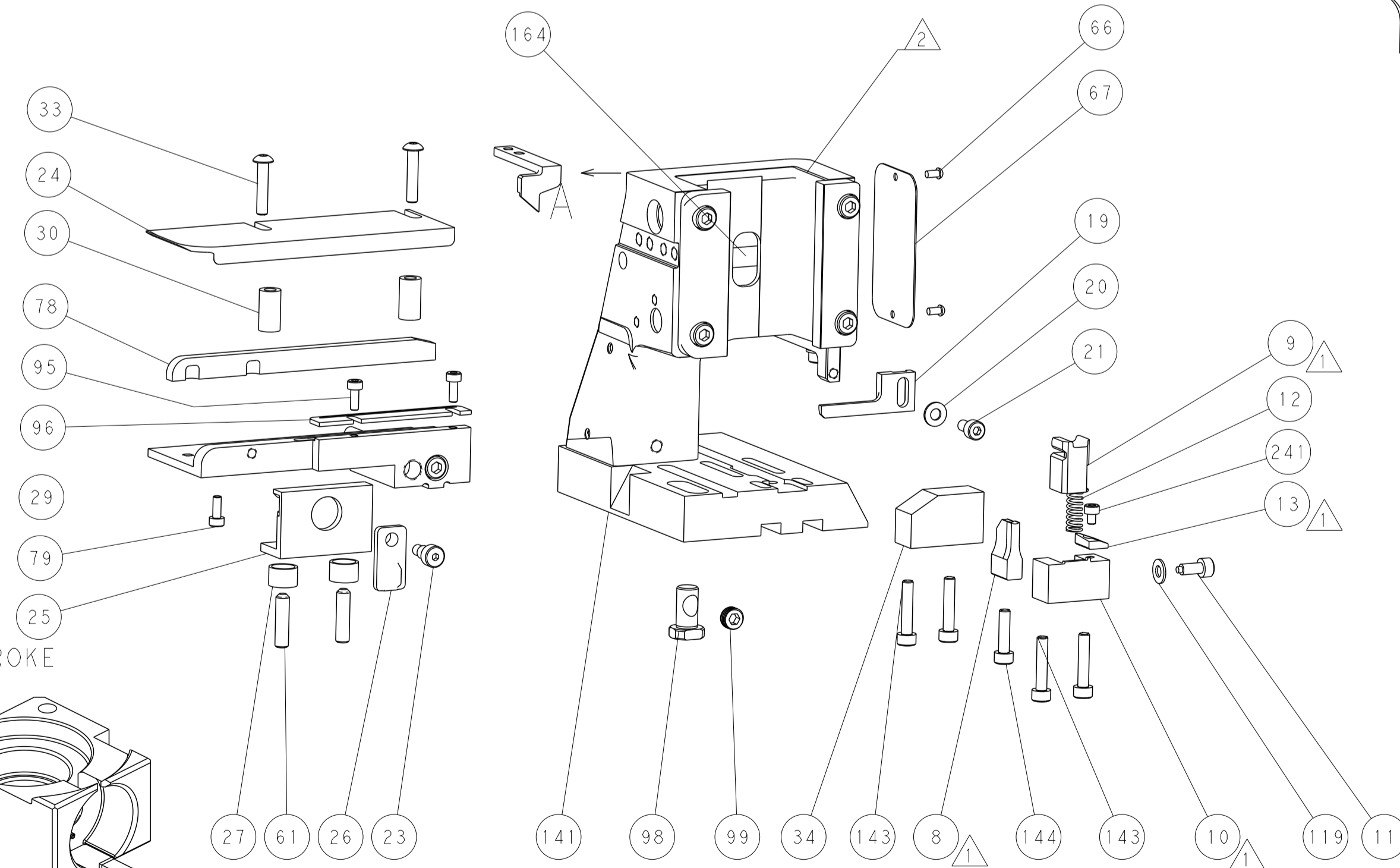


RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES



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. ALL RIGHTS RESERVED.</small>		DWN: R.O. WILSON 27APR2012 CHK: K.J. STAKEM 27APR2012 APVD: T.L. ELBIN 30APR2012	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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151654	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: D
MATERIAL: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION