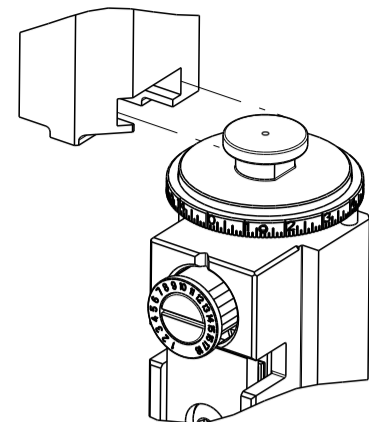


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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151683-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151683-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151683-7	A	CRIMP TOOLING KIT	-

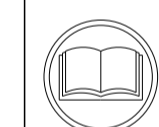
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB WITH DOUBLE LOCKING LANCE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.80-4.80 mm [.189-.189 IN]		1.40-2.00 mm [.055-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022		
TERMINALS APPLIED 5			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
962903-1	962903-2	962883-1	962883-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.56 +/- 0.05 [.061 +/- .002]	3.0
0.75mm2	1.47 +/- 0.05 [.058 +/- .002]	4.0
0.50mm2	1.38 +/- 0.05 [.054 +/- .002]	4.9



- 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.
- 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		C		ECR-15-014379	30SEP2015	KH	TE
		D		ECR-19-001132	23JAN2019	MZ	YY
		D1		ECR-19-001319	25JAN2019	MZ	YY
		E		ECR-19-009768	23JUN2019	TB	TE

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	264
-	1	1	1633782-2	FENCE	263
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-8	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	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	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	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	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	318707-1	FLOATING SHEAR, FRONT	9
1	2	1	2-1333204-4	ANVIL, COMBINATION	8
-	1	1	1-240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	1	5-2119784-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
1	2	1	1-456405-5	CRIMPER, WIRE PREMIUM	1
-	77	-72	-2	PART NO	ITEM NO

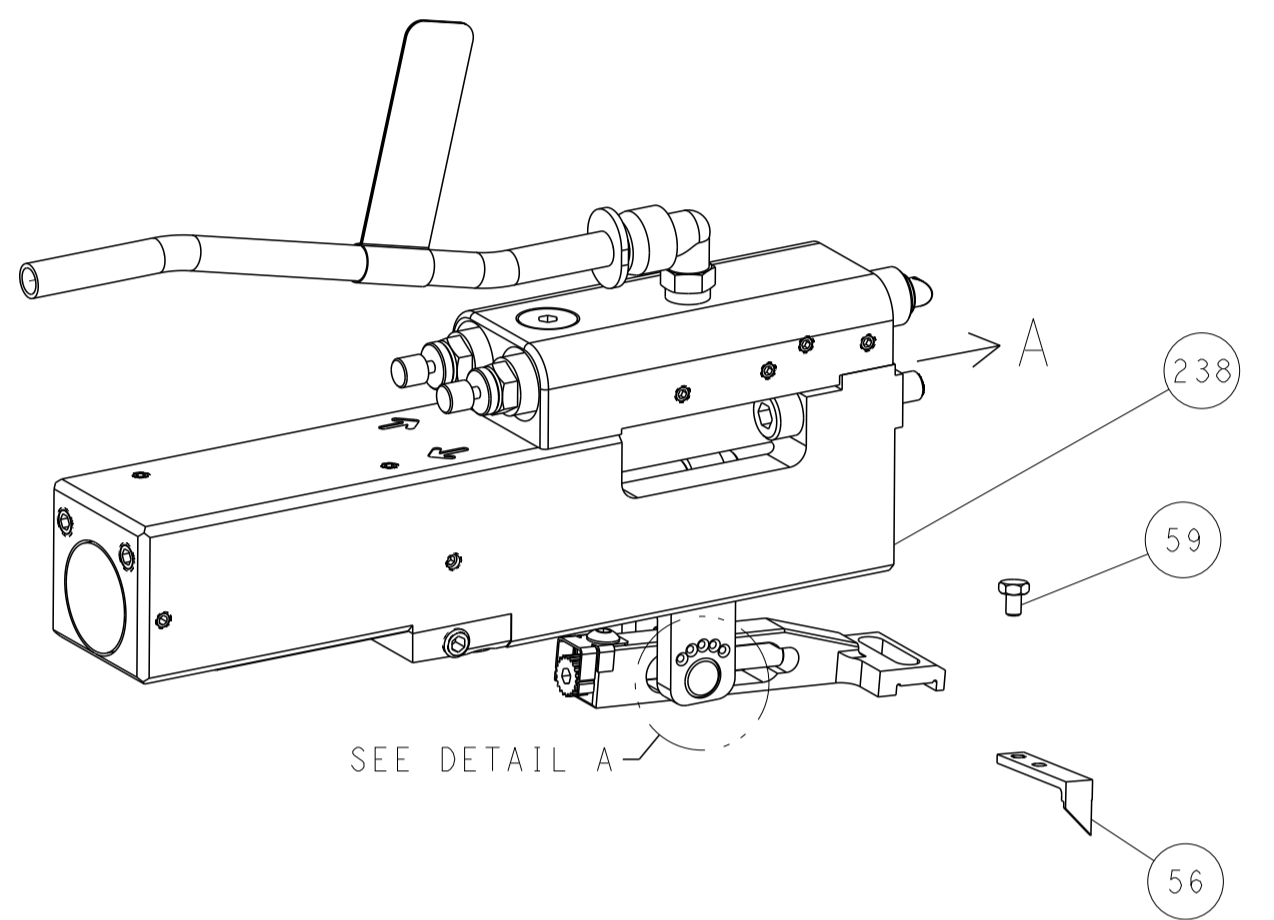
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. CHEN 19JUN2012		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC	±	0.15	±	CHK S.XI 19JUN2012	NAME Ocean Side Feed Applicator		
1 PLC	±	0.25	±	APVD J. CRUZ 19JUN2012	SIZE CAGE CODE DRAWING NO RESTRICTED TO		
2 PLC	±	0.38	±	PRODUCT SPEC	A1 00779 C=2151683		
3 PLC	±	0.51	±	APPLICATION SPEC	SCALE 1:2 SHEET 1 OF 4 REV E		
4 PLC	±	0.64	±	WEIGHT	Customer Accessible Production Drawing		
ANGLES	±	0.15	±				
FINISH							

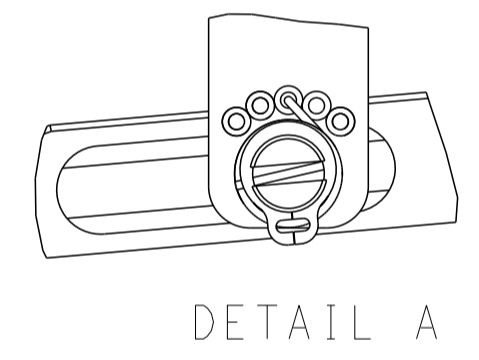
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

# FEED TYPE

## PNEUMATIC

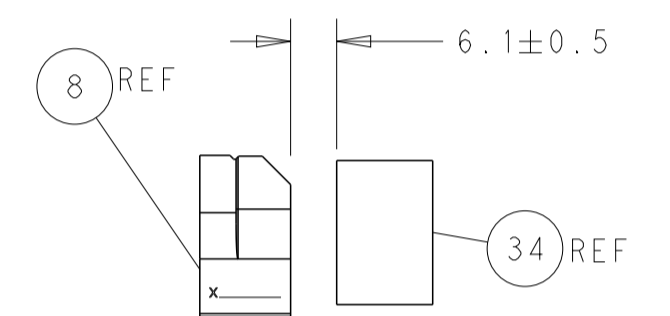
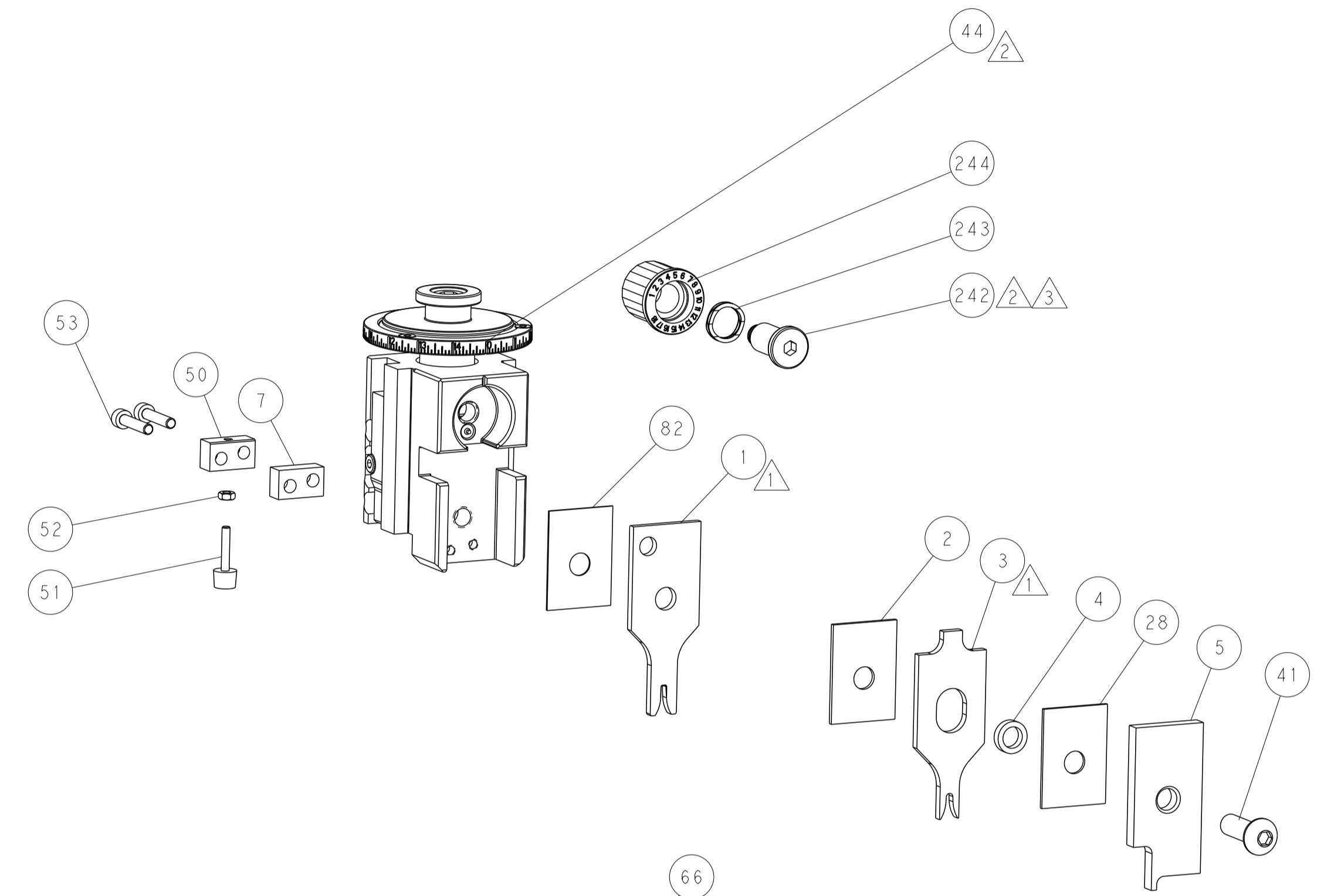
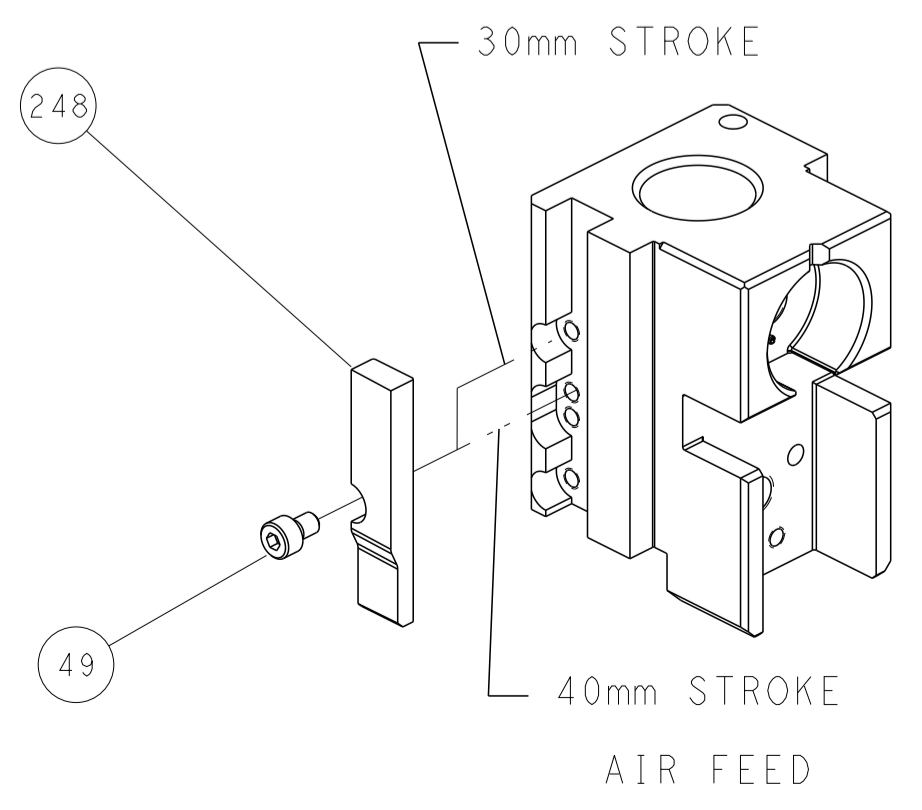


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

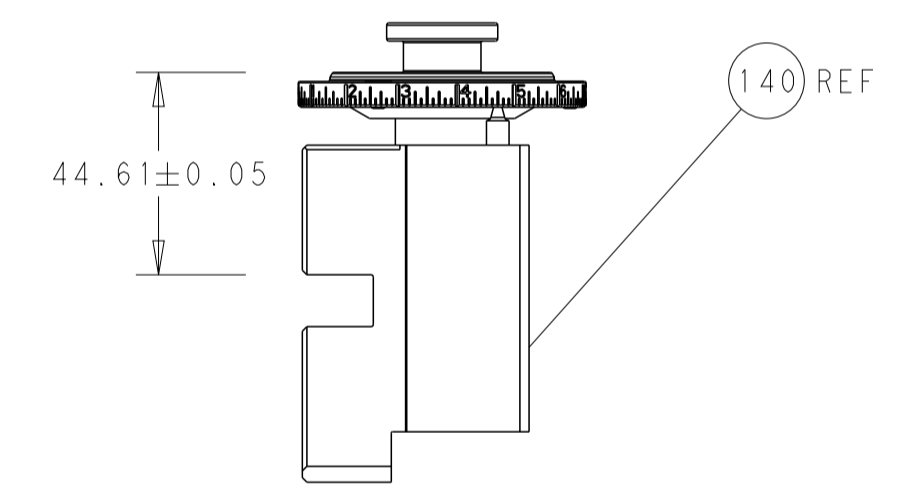


DETAIL A

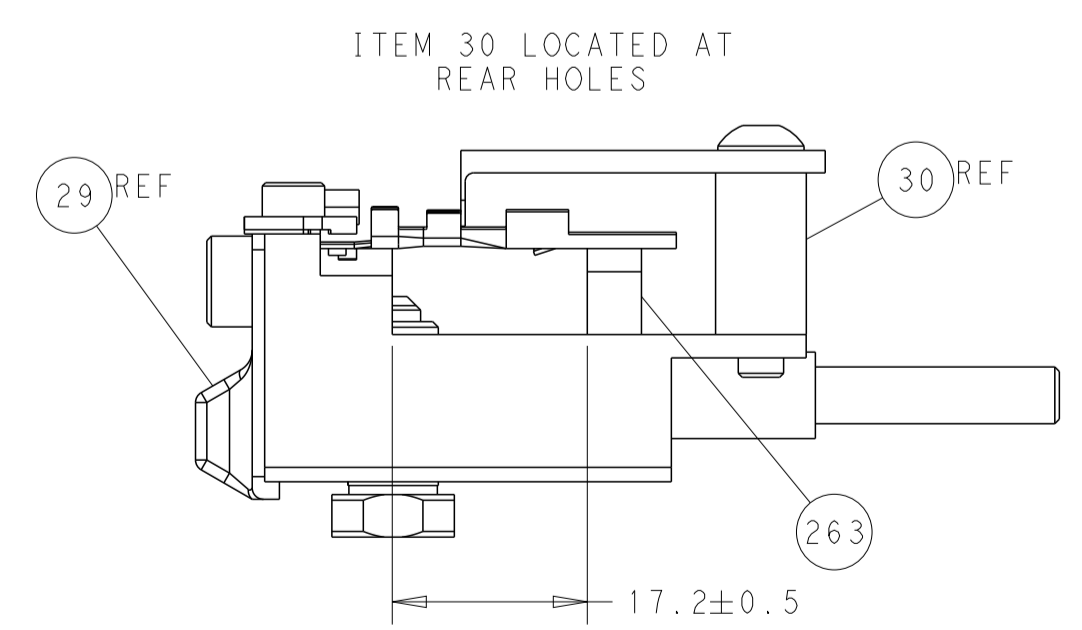
## CAM POSITIONS



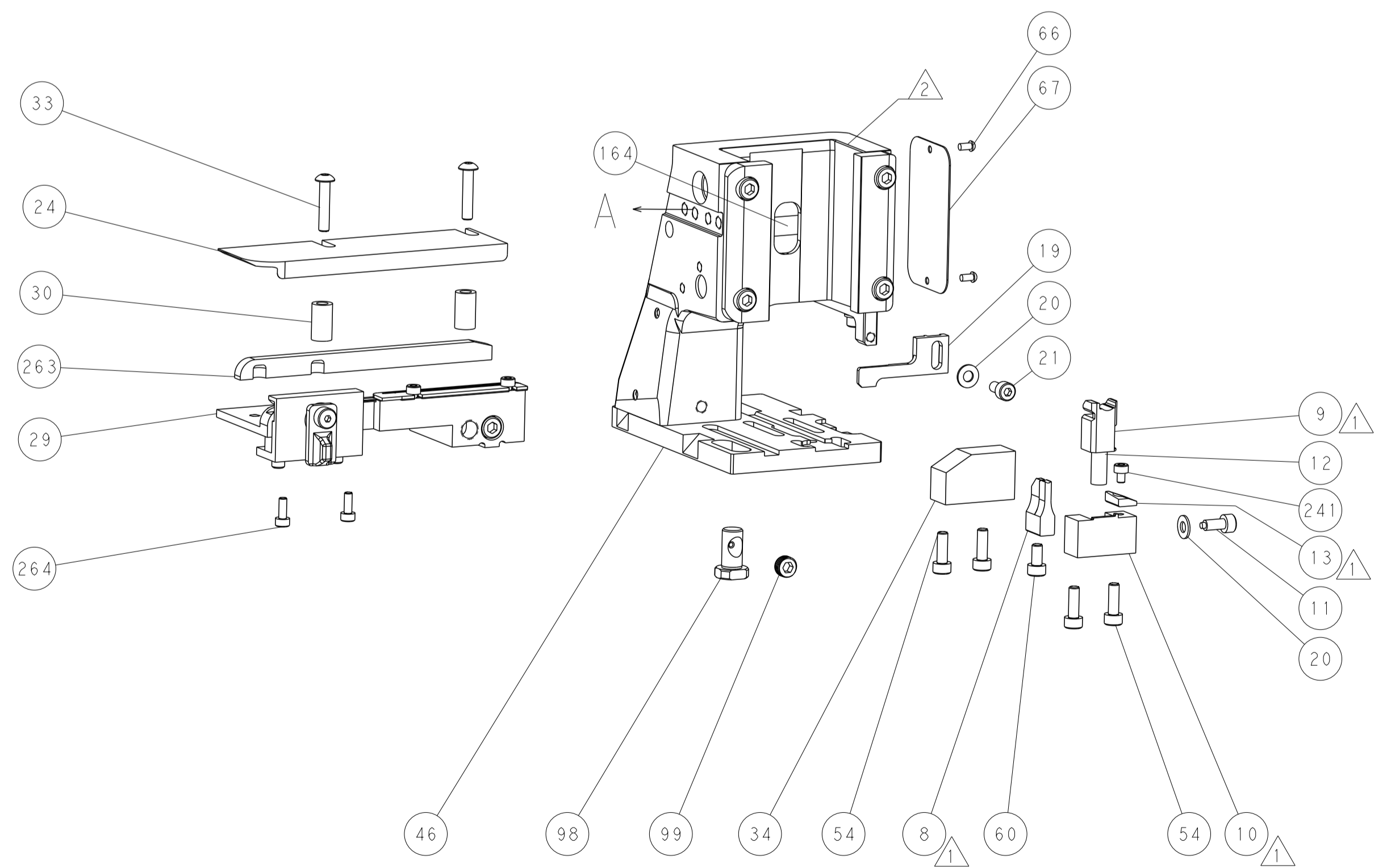
TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

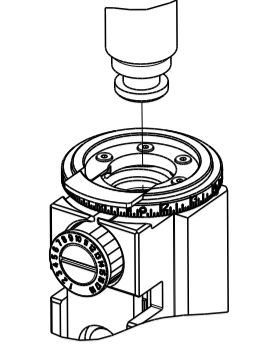


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: C. CHEN 19JUN2012 CHK: S. XI 19JUN2012 APVD: J. CRUZ 19JUN2012	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 DRAWING NO: 2151683	RESTRICTED TO: SCALE: 1:2 SHEET: 2 OF 4 REV: E
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151683-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151683-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB WITH DOUBLE LOCKING LANCE			
WIRE STRIP LENGTH 4.80-4.80 mm [.189-.189 IN]		INSULATION DIAMETER RANGE Ø1.40-2.00 mm [.055-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
962903-1	962903-2	962883-1	962883-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.56+/-0.05 [.061+/-0.002]	3.0
0.75mm2	1.47+/-0.05 [.058+/-0.002]	4.0
0.50mm2	1.38+/-0.05 [.054+/-0.002]	4.9



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

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

-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	264	
-	1	1633782-2	FENCE	263	
-	1	2119082-8	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	2844940-1	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	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	455888-5	SPACER, CRIMPER	82	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1338685-1	PAWL, FEED	56	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53	
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	690753-2	SPACER, TONKER	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	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1320928-2	STRIP GUIDE	24	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	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	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2-1333204-4	ANVIL, COMBINATION	8	
-	1	1-240641-5	SPACER	7	
-	-	-	-	6	
-	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	5-2119784-7	CRIMPER, INSULATION O PREMIUM	3	
-	1	1-455888-4	SPACER, CRIMPER	2	
-	1	1-456405-5	CRIMPER, WIRE PREMIUM	1	
-	77	-22	PART NO	DESCRIPTION	ITEM NO

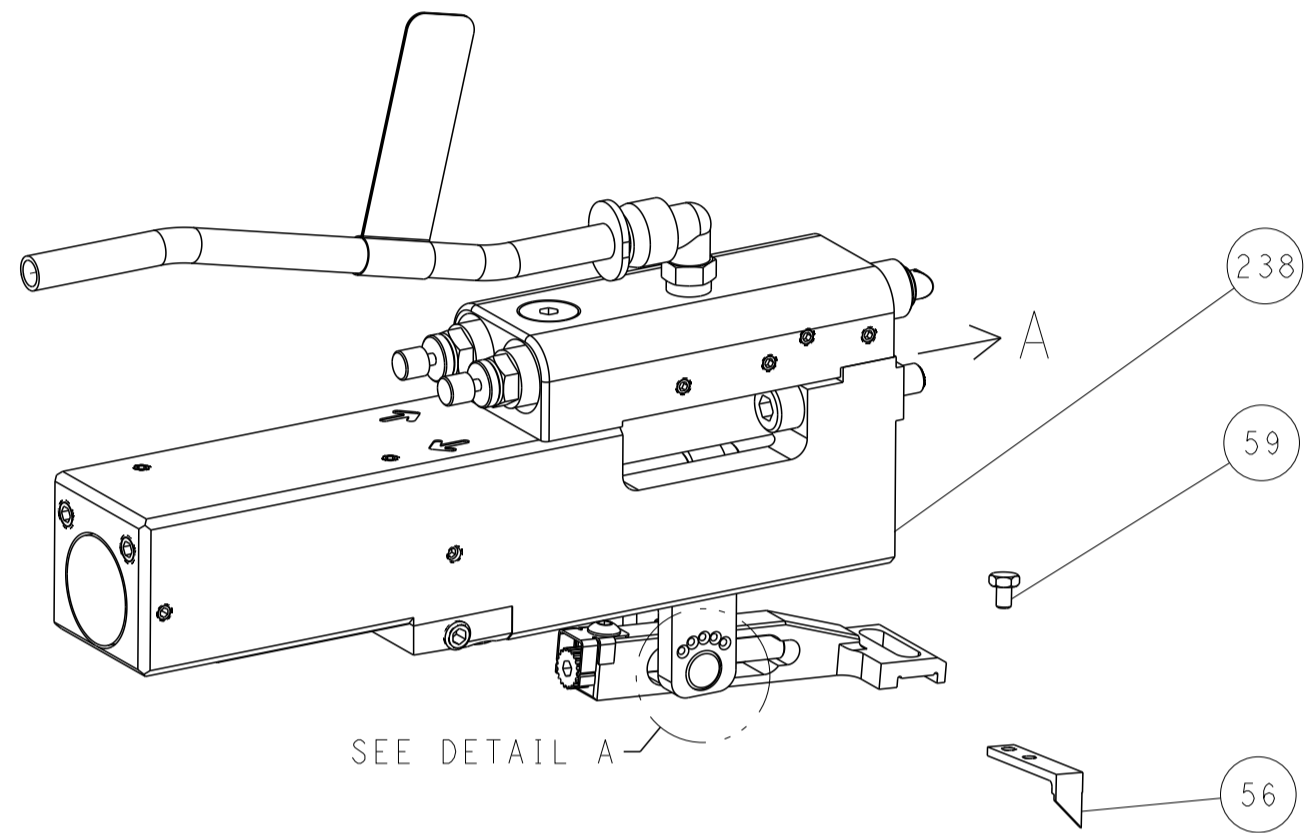
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: C. CHEN 19JUN2012		CHK: S. XI 19JUN2012		APVD: J. CRUZ 19JUN2012		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: E	
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: E	

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

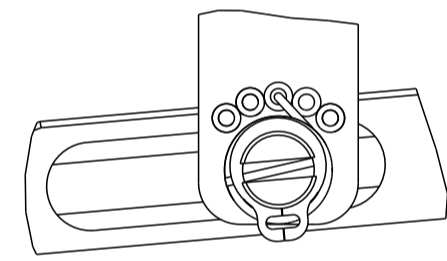
### FEED TYPE

#### PNEUMATIC



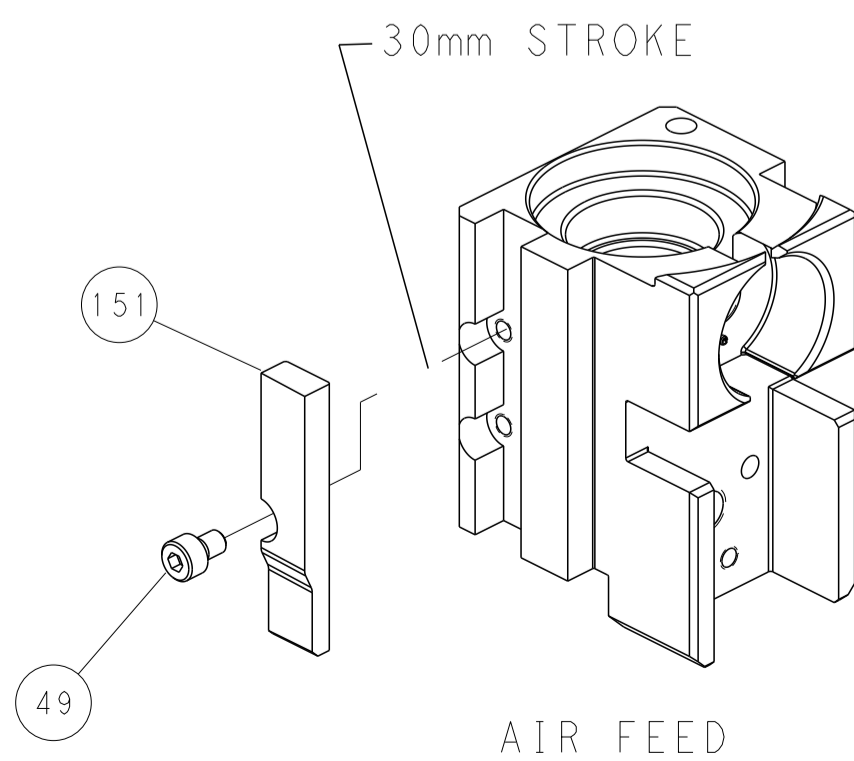
SEE DETAIL A

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

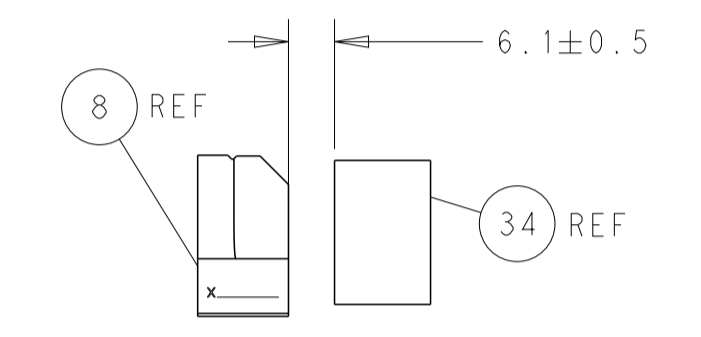
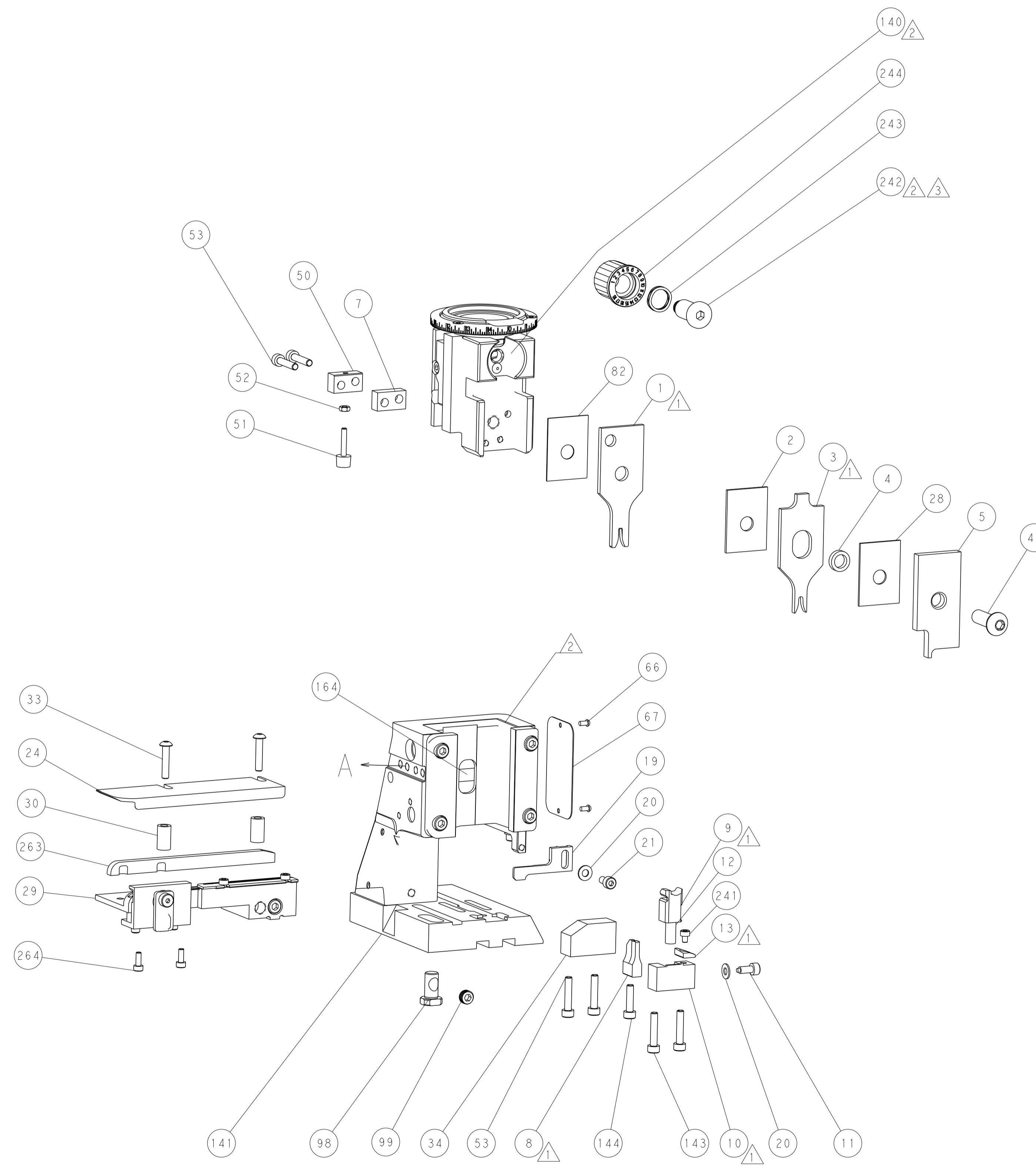


DETAIL A

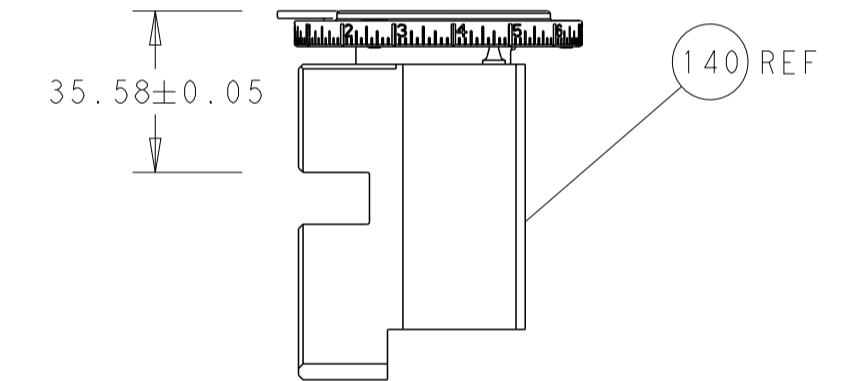
### CAM POSITIONS



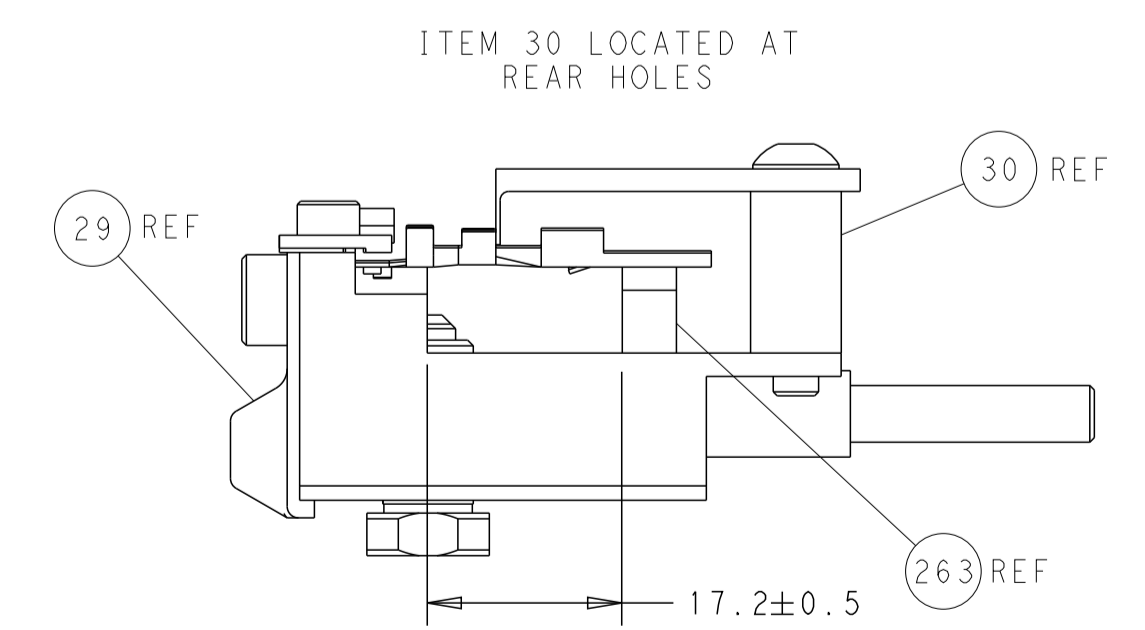
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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:		DWG: C. CHEN 19JUN2012		NAME: TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK: S. XI 19JUN2012	APVD: J. CRUZ 19JUN2012	Ocean Side Feed Applicator	
MATERIAL:				PRODUCT SPEC	APPLICATION SPEC	SIZE: A1	CAGE CODE: 00779
				WEIGHT:	SCALE: 1:2	DRAWING NO: 2151683	RESTRICTED TO: E
				Customer Accessible Production Drawing		SHEET 4 OF 4 REV	