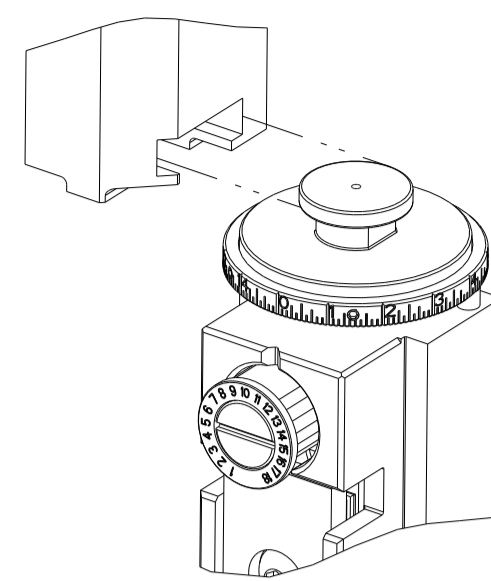


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2151008-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151008-2 | D | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151008-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

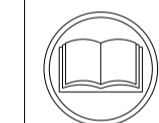


| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm [.110] | F |
| INSUL | 4.57 mm [.180] | F |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|-------------------------------------|------------------------------|------------------------|----------------|
| TERMINAL NAME: .250 LIF FLAG FASTON | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 4.00-6.00 mm [.157-.236 IN] | Ø2.50-3.80 mm [.098-.150 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | (A)114-20088 | (B)114-19025 | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| (A) 180464-1 | (A) 180464-2 | (B) 100645-2 | (B) 100645-3 |
| (A) 180464-4 | (A) 180464-5 | (A) 1-180464-2 | (A) 2-180464-4 |
| (A) 180464-9 | (A) 1-180464-1 | (A) 2-180464-1 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 2.50mm2 | 1.93+/-0.05 [.076+/-0.002] | 6.1 |
| 2.00mm2 | 1.85+/-0.05 [.073+/-0.002] | 6.9 |
| 1.50mm2 | 1.80+/-0.05 [.071+/-0.002] | 7.1 |
| 1.00mm2 | 1.70+/-0.05 [.067+/-0.002] | 8.0 |



- 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 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.
- CUT TO LENGTH AT ASSEMBLY.
- QUANTITY OF ITEM 129 IS IN METERS.
- ALL BELLMOUTH AND CUTOFF VALUES USED SHOULD BE FROM APPLICATION SPECIFICATION 114-19025.
- 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 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | A1 | | ECR-15-007271 | 11MAY2015 | MR | GB |
| | | B | | ECR-18-016028 | 10OCT2018 | FZ | KZ |
| | | C | | ECR-19-009011 | 07JUN2019 | TB | TE |
| | | D | | ECR-23-180187 | 04JUL2023 | FZ | JAH |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | 1 | 2119082-3 | 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 | 2844940-1 | AIR FEED MODULE | 238 |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | 1 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 143 |
| - | 1 | 1 | 2217068-1 | BRACKET, AIR BLAST | 130 |
| - | 1 | 1 | 2030758-3 | TUBING, POLYURETHANE | 129 |
| - | 1 | 1 | 5018030-2 | NUT, HEX, REG, RoHS, M4 | 128 |
| - | 1 | 1 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 127 |
| - | 1 | 1 | 986220-3 | CLAMP, CABLE, BLACK | 126 |
| - | 1 | 1 | 1-22281-8 | SPRING, COMPRESSION | 121 |
| - | 1 | 1 | 455888-4 | SPACER, CRIMPER | 120 |
| - | 1 | 1 | 23238-1 | INSERT, COUPLING | 101 |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 3-690712-4 | FRONT STRIP GUIDE | 96 |
| - | 2 | 2 | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16 | 95 |
| - | 1 | 1 | 2168083-6 | SCR, SKT HD CAP, RoHS, M5 X 65 | 93 |
| - | 1 | 1 | 455888-3 | SPACER, CRIMPER | 82 |
| - | 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 | 1338685-3 | PAWL, FEED | 56 |
| - | 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 |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2844962-2 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 1-2844938-9 | PLATE, STRIP GUIDE | 29 |
| - | 2 | 2 | 22281-6 | SPRING, COMPRESSION | 27 |
| - | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| - | 1 | 1 | 6-690754-5 | DRAG, SPECIAL | 25 |
| - | 1 | 1 | 7-690440-0 | GUIDE, REAR STRIP | 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 |
| - | 4 | 4 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 2119533-6 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 1 | 3-853720-9 | BLADE, SLUG | 15 |
| - | 1 | 1 | 1-853721-3 | BLADE, SLUG | 10 |
| - | 1 | 1 | 2-1803012-8 | PLATE, REAR SHEAR | 9 |
| - | 1 | 2 | 1803010-3 | ANVIL, SPECIAL, COMBINATION | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | - | - | - | - | 5 |
| - | 1 | 1 | 1803409-2 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 2 | 1-2119582-2 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 455888-4 | SPACER, CRIMPER | 2 |
| - | 1 | 2 | 4-456408-0 | 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 | | | Customer Accessible Production Drawing | SCALE | 1:2 | SHEET | 1 | OF | 4 | REV | D |



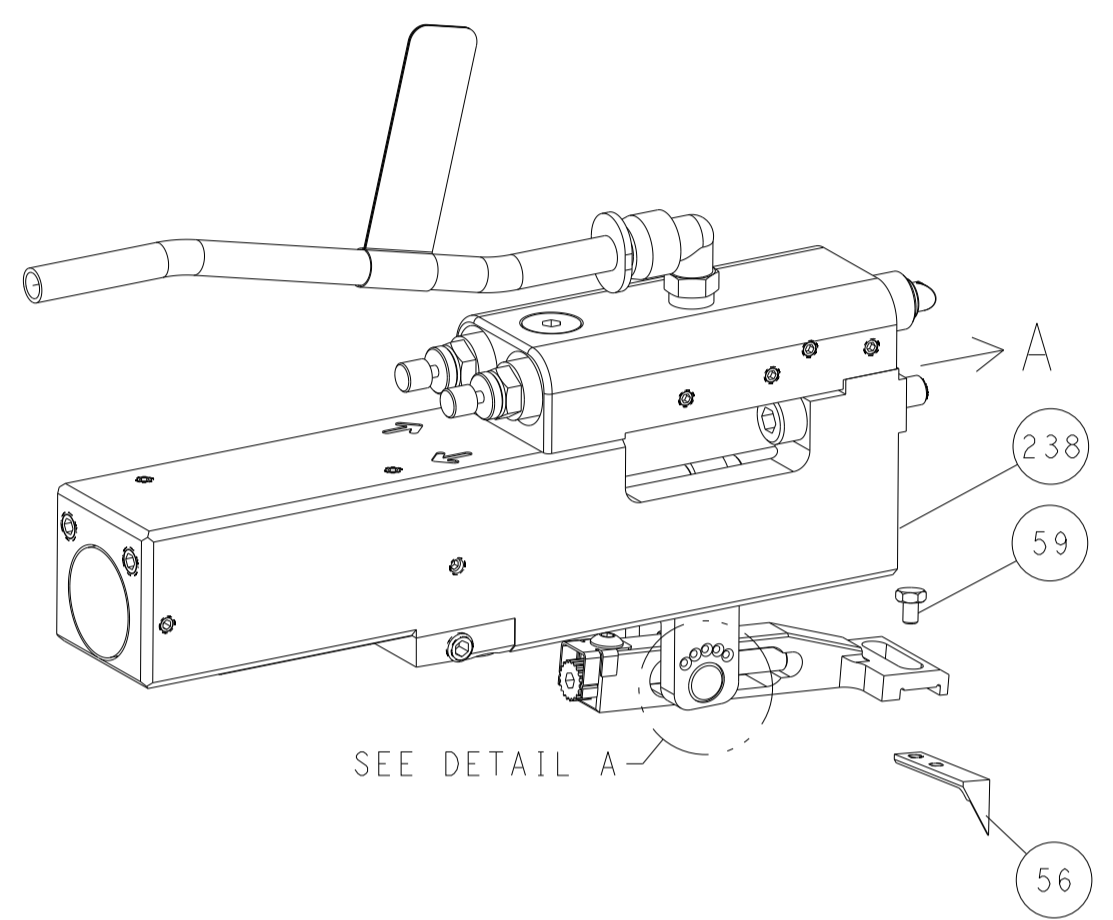
Ocean Side Feed Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151008

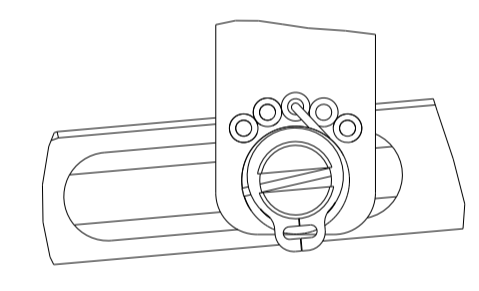
| LOC | DIST | REVISIONS | | | |
|-----|------|-------------|------|-----|------|
| P | LTN | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | SEE SHEET 1 | - | - | - |
| | | | | | |
| | | | | | |

FEED TYPE

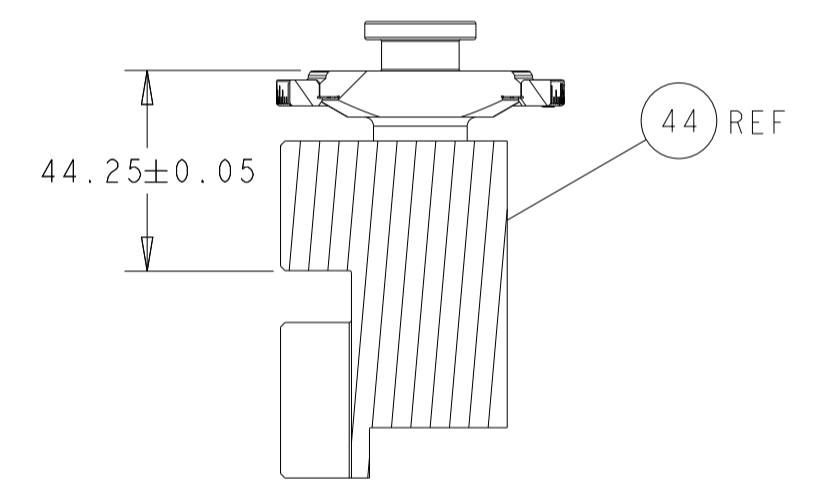
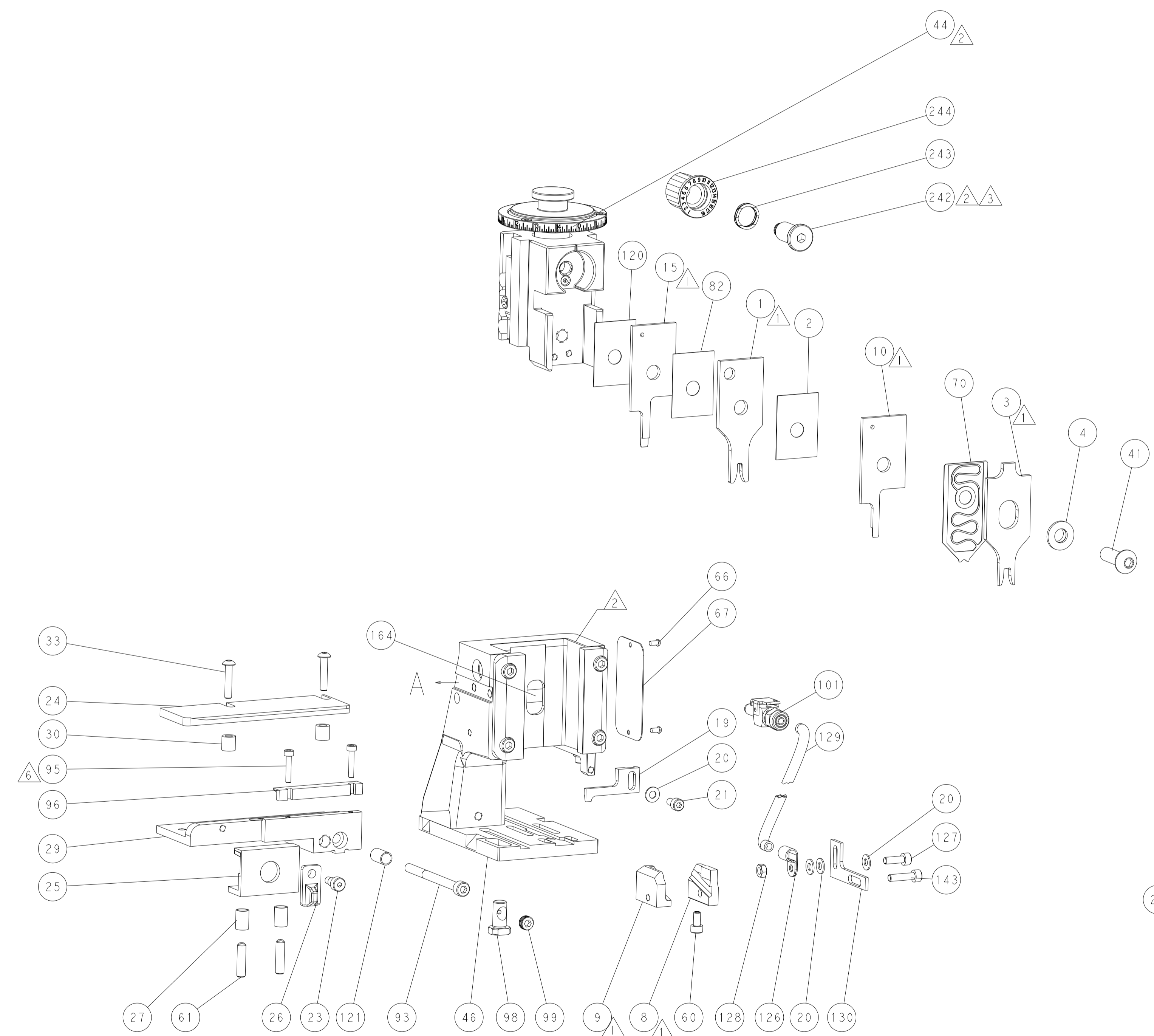
PNEUMATIC



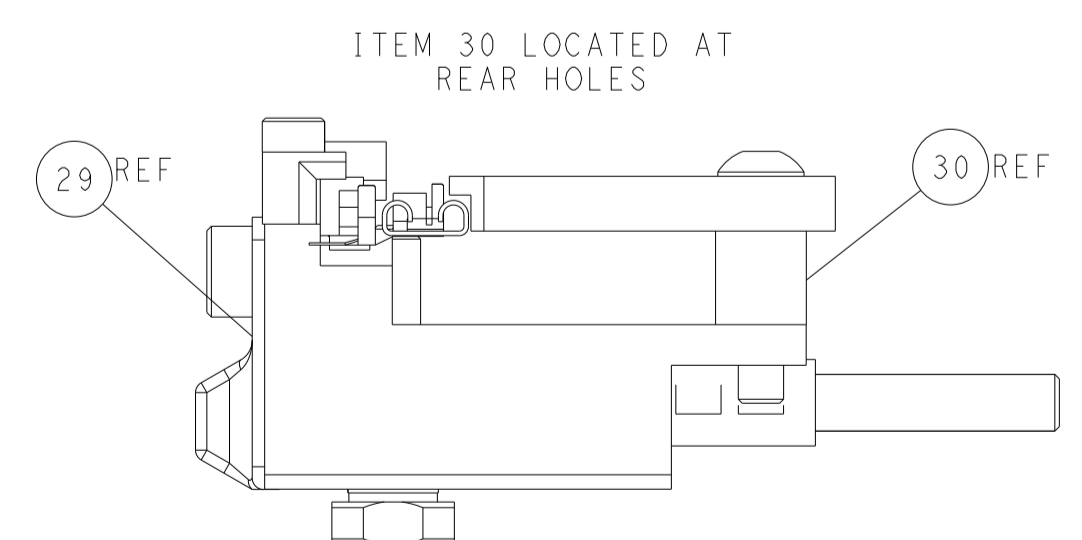
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

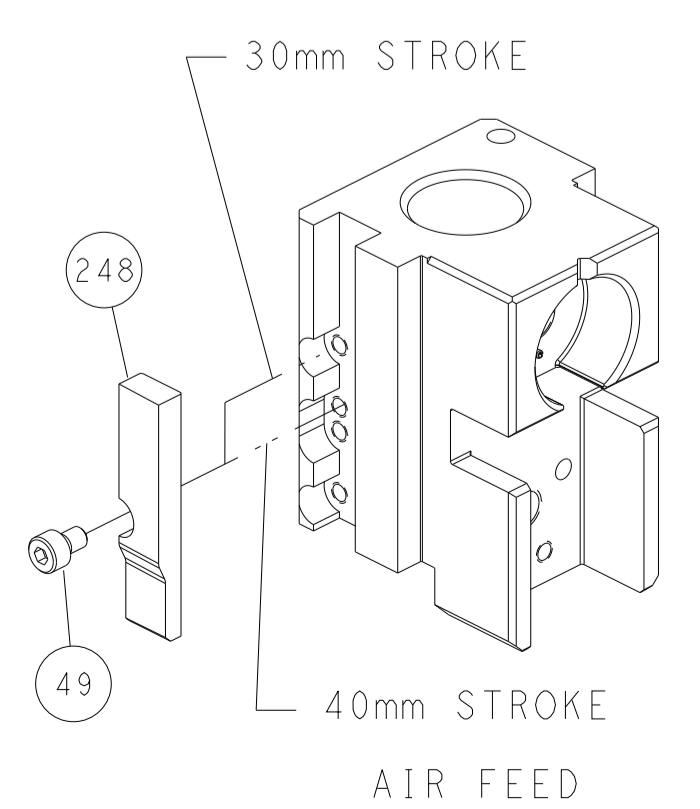


RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION AND BODY

CAM POSITION

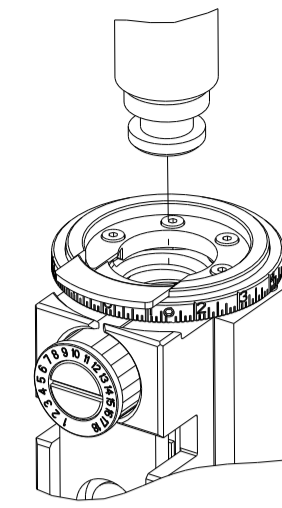


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | | | | |
|--|---------|--|---------|-------------------------|---------|--|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: H. HUANG 20JAN2015 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | CHK: L. ZHANG 20JAN2015 | | NAME: Ocean Side Feed Applicator | |
| APVD: J. GUO 20JAN2015 | | PRODUCT SPEC: | | APPLICATION SPEC: | | SIZE: A1 | |
| CAGE CODE: 00779 | | DRAWING NO: C=2151008 | | RESTRICTED TO: | | SCALE: 1:2 | |
| Customer Accessible Production Drawing | | SHEET 2 OF 4 | | REV D | | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|-----------|
| 2-2151008-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151008-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|-----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm [1.110] | F |
| INSUL | 4.57 mm [1.180] | F |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|-------------------------------------|----------------|-------------------------------|----------------|
| TERMINAL NAME: .250 LIF FLAG FASTON | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.00-6.00 mm [1.57-.236 IN] | | Ø2.50-3.80 mm [1.098-.150 IN] | |
| TERMINAL APPLICATION SPECIFICATION | (A)114-20088 | (B)114-19025 | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| (A) 180464-1 | (A) 180464-2 | (B) 100645-2 | (B) 100645-3 |
| (A) 180464-4 | (A) 180464-5 | (A) 1-180464-2 | (A) 2-180464-4 |
| (A) 180464-9 | (A) 1-180464-1 | (A) 2-180464-1 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 2.50mm2 | 1.93+/-0.05 [0.76+/-0.002] | 6.1 |
| 2.00mm2 | 1.85+/-0.05 [0.73+/-0.002] | 6.9 |
| 1.50mm2 | 1.80+/-0.05 [0.71+/-0.002] | 7.1 |
| 1.00mm2 | 1.70+/-0.05 [0.67+/-0.002] | 8.0 |

- 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 CUT TO LENGTH AT ASSEMBLY.
- 7 QUANTITY OF ITEM 129 IS IN METERS.
- 8 ALL BELLMOUTH AND CUTOFF VALUES USED SHOULD BE FROM APPLICATION SPECIFICATION 114-19025.
- 9. 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 | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| | | P | LTM | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | - | - | SEE SHEET 1 | - | - | - |

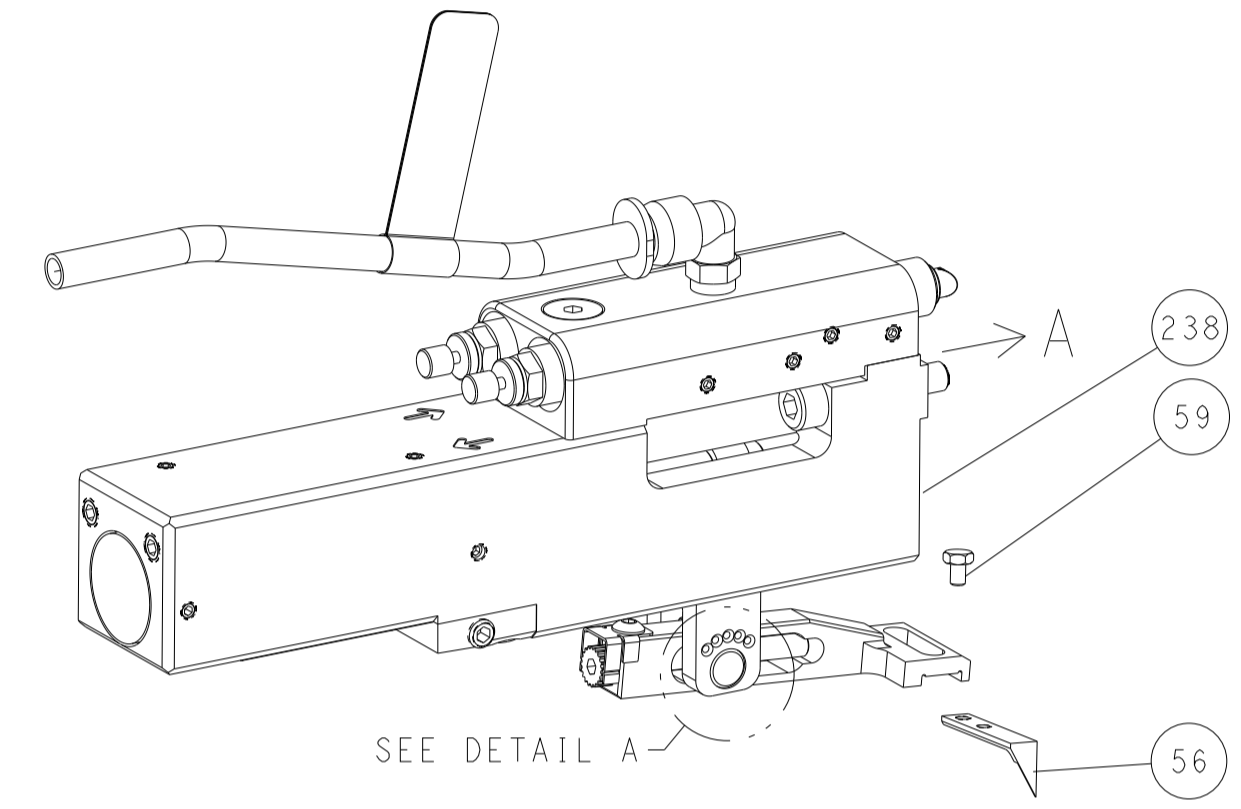
| | | | | | |
|---|-----|-------------|-------------------------------------|-------------------------------|---|
| - | 1 | 2119082-3 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | |
| - | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 | |
| - | 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 | |
| - | 1 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 143 | |
| - | 1 | 1-1803583-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 | |
| - | 1 | 1803516-1 | RAM ASSEMBLY, SF PACIFIC | 140 | |
| - | 1 | 2217068-1 | BRACKET, AIR BLAST | 130 | |
| - | 1 | 2030758-3 | TUBING, POLYURETHANE | 129 | |
| - | 1 | 5018030-2 | NUT, HEX, REG, RoHS, M4 | 128 | |
| - | 1 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 127 | |
| - | 1 | 986220-3 | CLAMP, CABLE, BLACK | 126 | |
| - | 1 | 1-22281-8 | SPRING, COMPRESSION | 121 | |
| - | 1 | 455888-4 | SPACER, CRIMPER | 120 | |
| - | 1 | 23238-1 | INSERT, COUPLING | 101 | |
| - | 1 | 2844908-1 | SCREW, LOCKING | 99 | |
| - | 1 | 2844907-1 | POST, LOCKING | 98 | |
| - | 1 | 3-690712-4 | FRONT STRIP GUIDE | 96 | |
| - | 2 | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16 | 95 | |
| - | 1 | 2168083-6 | SCR, SKT HD CAP, RoHS, M5 X 65 | 93 | |
| - | 1 | 455888-3 | SPACER, CRIMPER | 82 | |
| - | 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 | 1338685-3 | PAWL, FEED | 56 | |
| - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 | |
| - | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 | |
| - | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2844962-2 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 | |
| - | 1 | 1-2844938-9 | PLATE, STRIP GUIDE | 29 | |
| - | 2 | 22281-6 | SPRING, COMPRESSION | 27 | |
| - | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 | |
| - | 1 | 6-690754-5 | DRAG, SPECIAL | 25 | |
| - | 1 | 7-690440-0 | GUIDE, REAR STRIP | 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 | |
| - | 4 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 | |
| - | 1 | 2119533-6 | STRIPPER, SIDE FEED | 19 | |
| - | 1 | 3-853720-9 | BLADE, SLUG | 15 | |
| - | 1 | 1-853721-3 | BLADE, SLUG | 10 | |
| - | 1 | 2-1803012-8 | PLATE, REAR SHEAR | 9 | |
| - | 1 | 1803010-3 | ANVIL, SPEICAL, COMBINATION | 8 | |
| - | - | - | - | 7 | |
| - | - | - | - | 6 | |
| - | - | - | - | 5 | |
| - | 1 | 1803409-2 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 1 | 9-2119582-2 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 455888-4 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 4-456408-0 | CRIMPER, WIRE PREMIUM | 1 |

| | | | | | | | | | |
|----------------|--|--|--|-------------------------|--|--|--|----------------------------------|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: H. HUANG 20JAN2015 | | CHK: L. ZHANG 20JAN2015 | | NAME: Ocean Side Feed Applicator | |
| 0 PLC ± | | 1 PLC ± | | APVD: U. GUO 20JAN2015 | | PRODUCT SPEC | | SIZE: A1 | |
| 2 PLC ± | | 3 PLC ± | | APPLICATION SPEC | | CAGE CODE | | DRAWING NO: 00779 | |
| 4 PLC ± | | ANGLES ± | | WEIGHT | | SCALE: 1:2 | | SHEET 3 OF 4 | |
| MATERIAL | | FINISH | | RESTRICTED TO | | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | REV: D | |

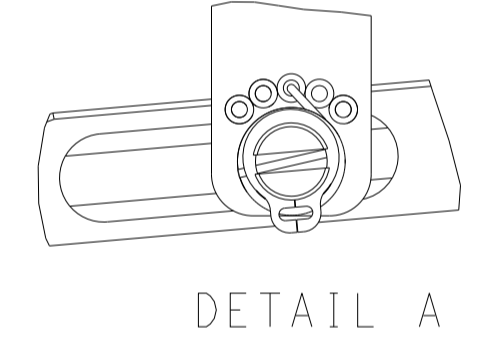
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

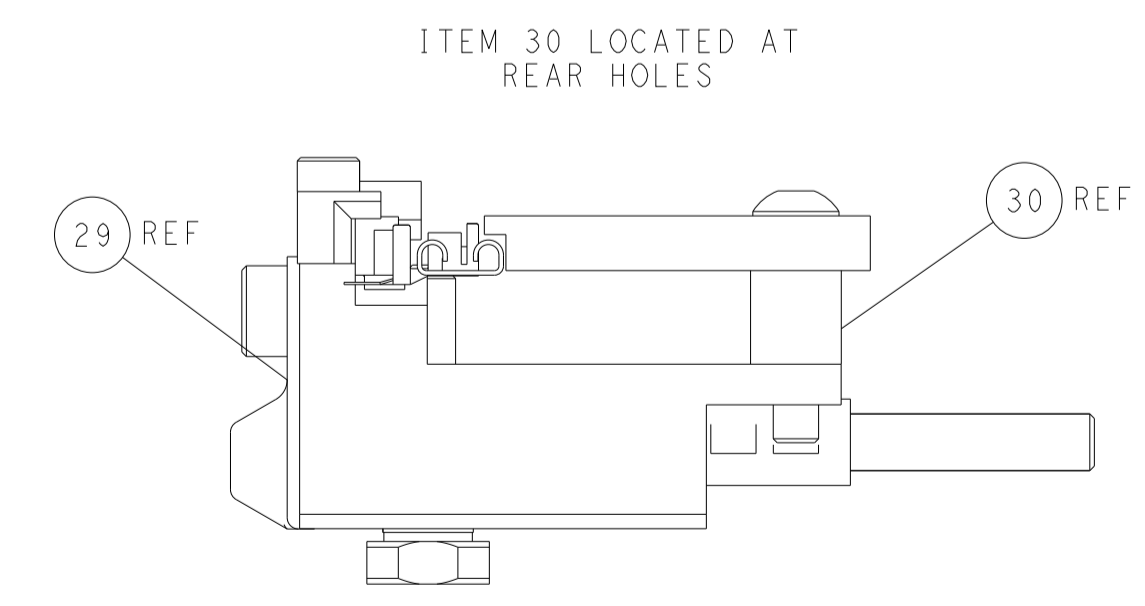
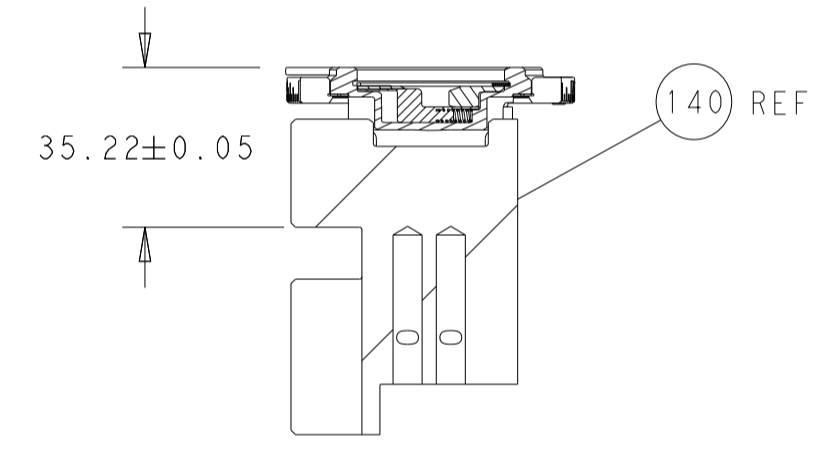
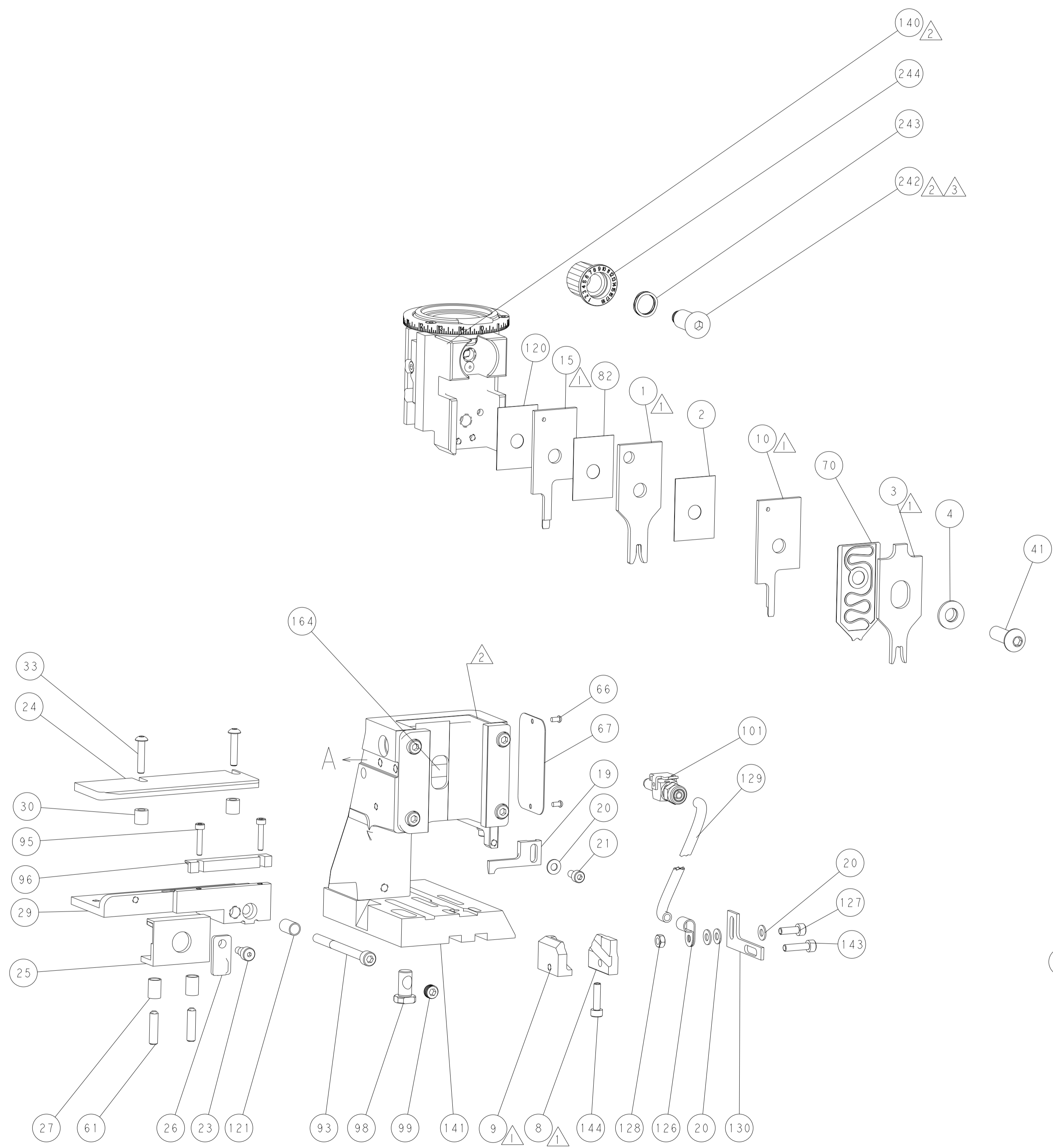
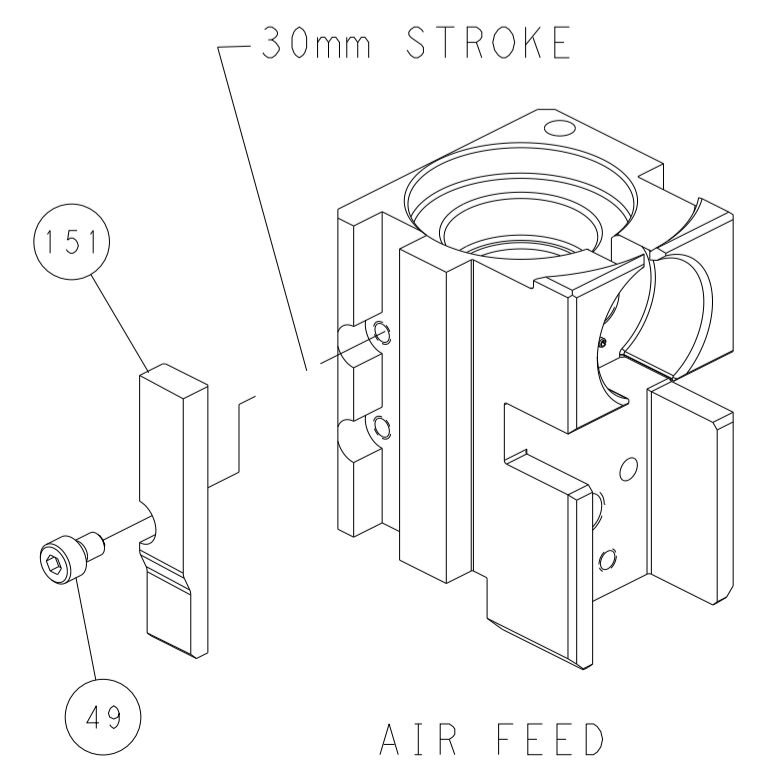
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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> | | DMN: H. HUANG 20JAN2015 CHK: L. ZHANG 20JAN2015 APVD: J. GUO 20JAN2015 | NAME: Ocean Side Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151008 | RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: D |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ± | MATERIAL: - FINISH: - | WEIGHT: - PRODUCT SPEC: - APPLICATION SPEC: - | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | |