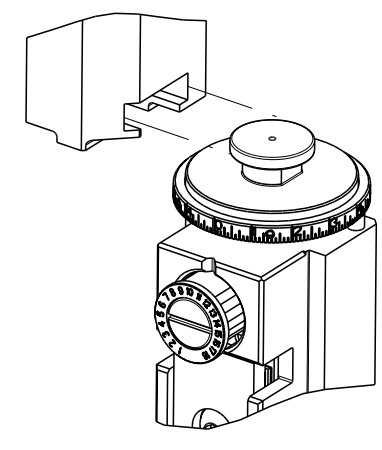


THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2016
 BY BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2151782-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151782-2 | E | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151782-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

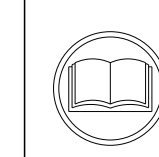


| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 3.30 mm [.130] | F |
| INSUL | 6.60 mm [.260] | O |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-------------|------------------------------------|--------------------------------|
| TERMINAL NAME: TAB 5.8 x 0.8 | | | |
| WIRE STRIP LENGTH | | TERMINAL INSULATION DIAMETER RANGE | |
| 5.70-6.30 mm [.224-.248 IN] | | ∅ 2.70-3.70 mm [.106-.146 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-18052 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE SEAL | SEAL INSULATION DIAMETER RANGE |
| 1-962919-1 | 2-962919-1 | 963245-1 | ∅ 3.40-3.70 mm |
| 1-962919-2 | 2-962919-2 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 4.00mm2 | 2.34+/-0.05 [.092+/- .002] | 9.4 |



- 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.
 - APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
7. 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.

| REVISONS | | DATE | OWN | APVD |
|----------|---------------|-----------|-----|------|
| B | ECR-16-012585 | 15SEP2016 | TB | CT |
| C | ECR-18-015392 | 27SEP2018 | MZ | KZ |
| D | ECR-18-016512 | 17OCT2018 | TB | TE |
| E | ECR-19-005669 | 09APR2019 | JAH | CT |

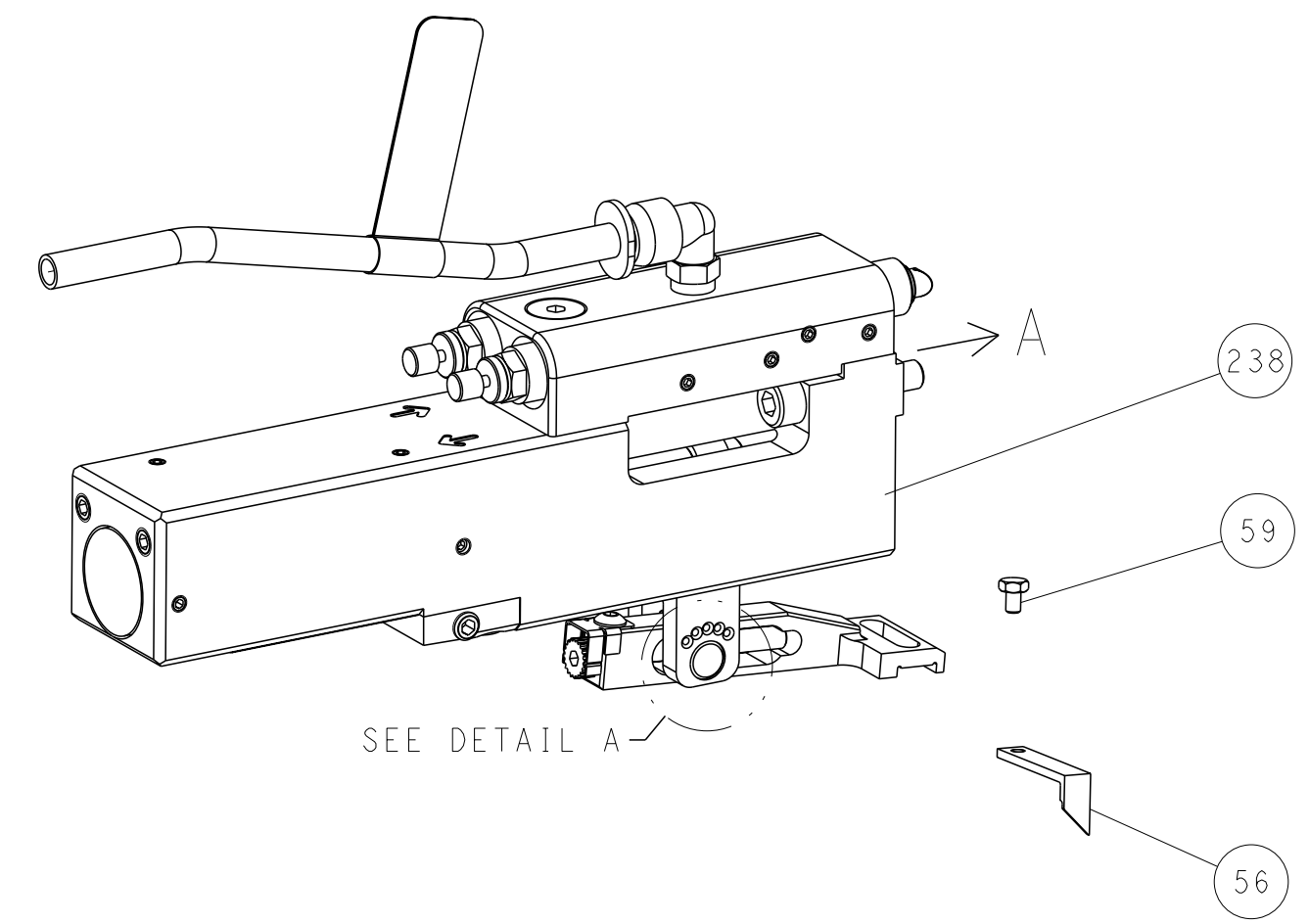
| | | | | | |
|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 2-455888-7 | SPACER, CRIMPER | 259 |
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | 1 | 2119082-8 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| | - | 1 | 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 | 455888-6 | SPACER, CRIMPER | 82 |
| - | 2 | 2 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 79 |
| - | 1 | 1 | 1803096-1 | EXTENSION PLATE | 78 |
| - | 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 | 985575-3 | SCR, FLT SKT HD CAP M3 X 10.0 | 57 |
| - | 1 | 1 | 1338683-8 | FEED PAWL | 56 |
| - | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 |
| - | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 53 |
| - | 1 | 1 | 1803382-2 | 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 | 1803515-2 | RAM ASSEMBLY, SF ATLANTIC | 44 |
| - | 1 | 1 | 1803602-2 | SCR, BHSC, RoHS (M8 X 40) | 41 |
| - | 1 | 1 | 1-1752356-2 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2079383-8 | SCR, BHSC, RoHS (M4 X 16) | 33 |
| - | 2 | 2 | 2-2844962-3 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 455888-4 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1320928-4 | 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 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| | - | 1 | 2119805-4 | SHEAR HOLDER, FRONT | 10 |
| | - | 1 | 1-318707-2 | FLOATING SHEAR, FRONT | 9 |
| | 1 | 2 | 1-1633930-0 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119781-5 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 238011-8 | BLOCK, CRIMPER SPACER | 4 |
| | 1 | 2 | 1803018-5 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 2-455888-5 | SPACER, CRIMPER | 2 |
| | 1 | 2 | 456410-4 | CRIMPER, WIRE PREMIUM | 1 |
| -77 | -72 | -2 | PART NO | DESCRIPTION | 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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | | DWG: R.O. WILSON 05OCT2012 CHK: K.J. STAKEM 08OCT2012 APVD: K.J. STAKEM | | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151782 RESTRICTED TO: CUSTOMER ACCESSIBLE PRODUCTION DRAWING | |
| MATERIAL: - | | FINISH: - | | WEIGHT: - | | SCALE: 1:2 SHEET 1 OF 4 REV E | |

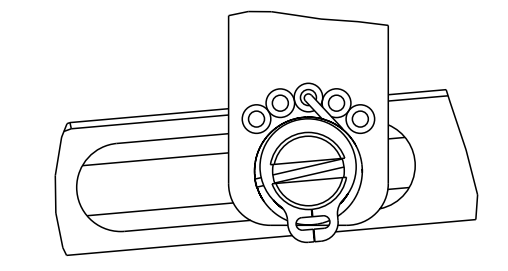
| LOC | DIST | REVISIONS | | | |
|-----|------|-----------|-------------|----|------|
| | | REV | DATE | BY | APPV |
| A | 66 | - | SEE SHEET 1 | - | - |

FEED TYPE PNEUMATIC



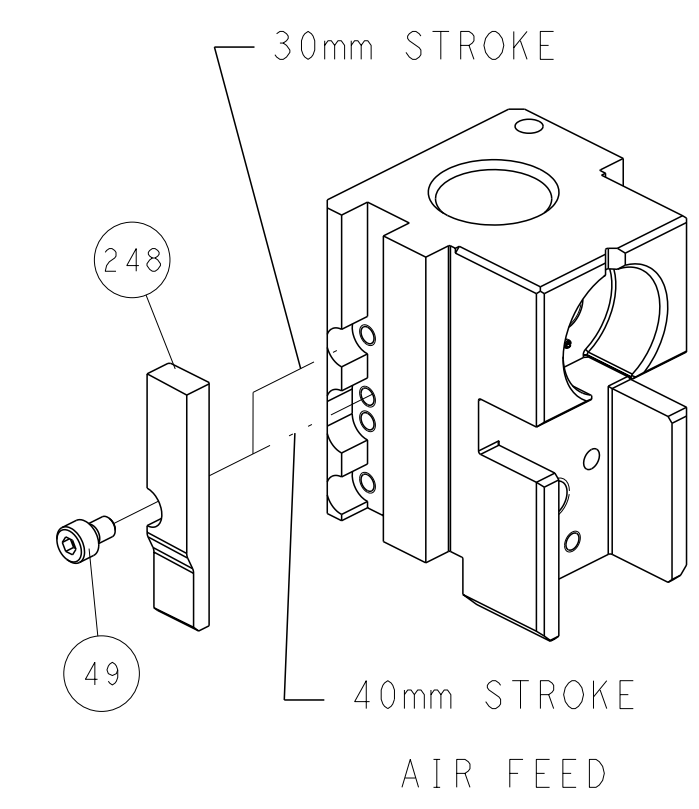
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

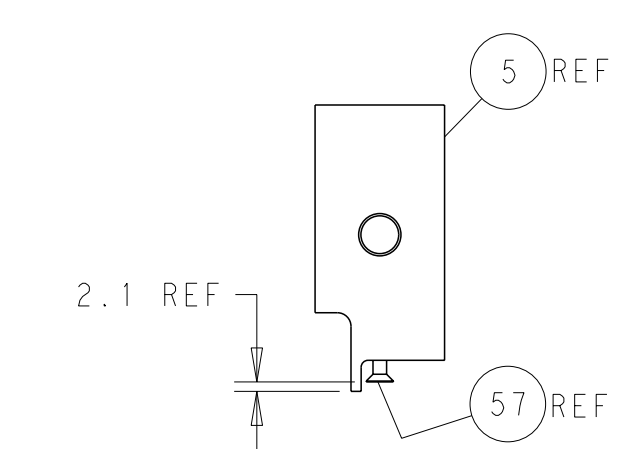
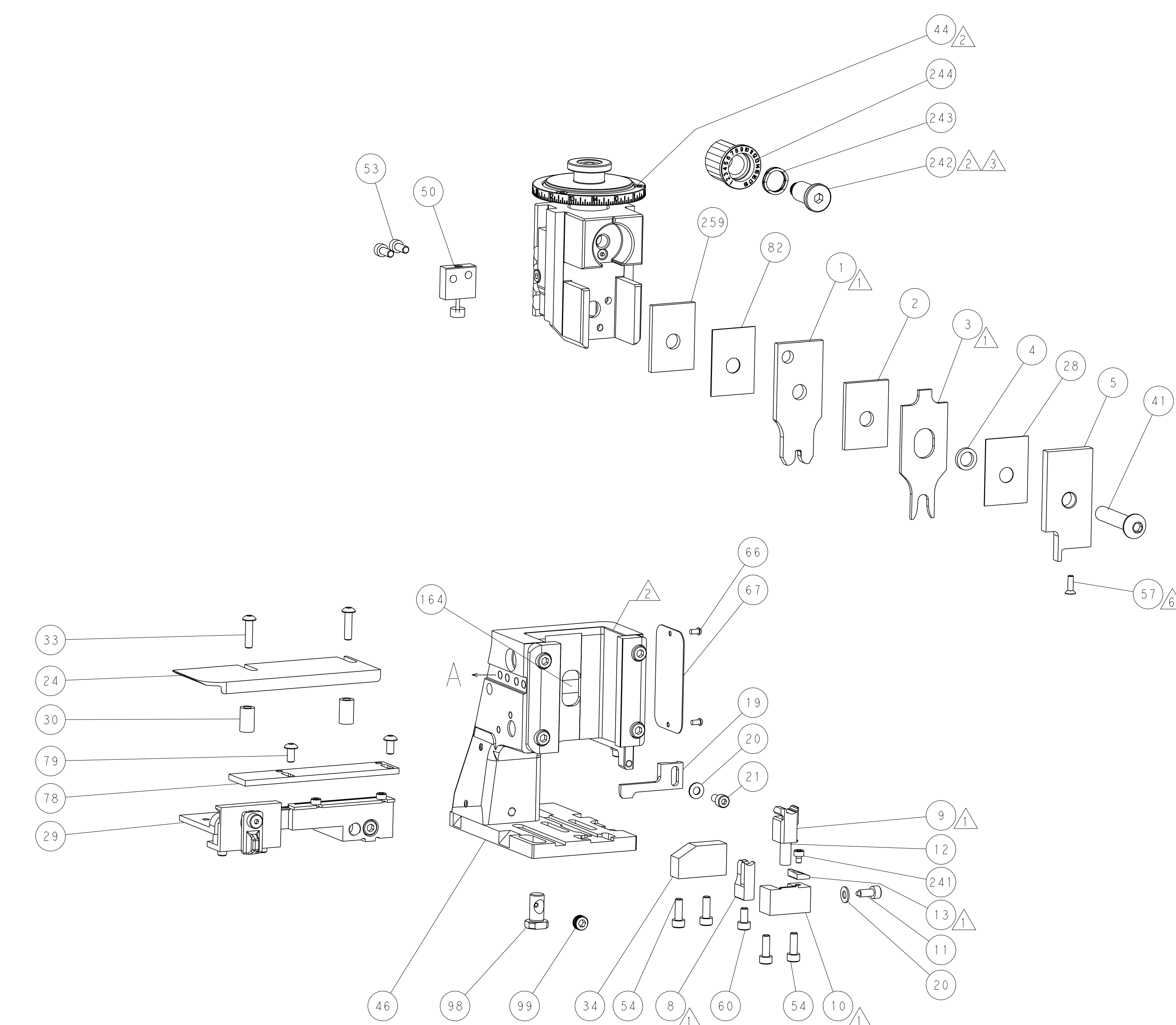


DETAIL A

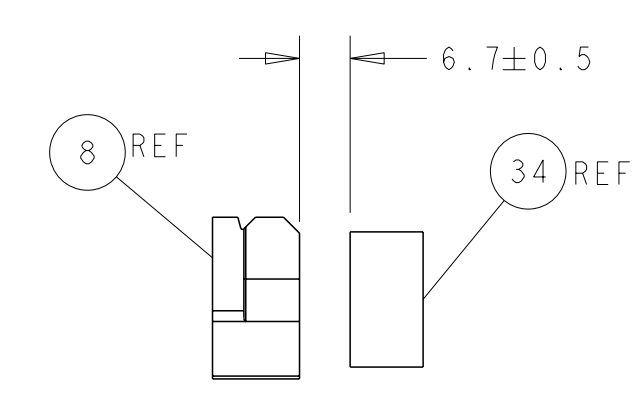
CAM POSITION



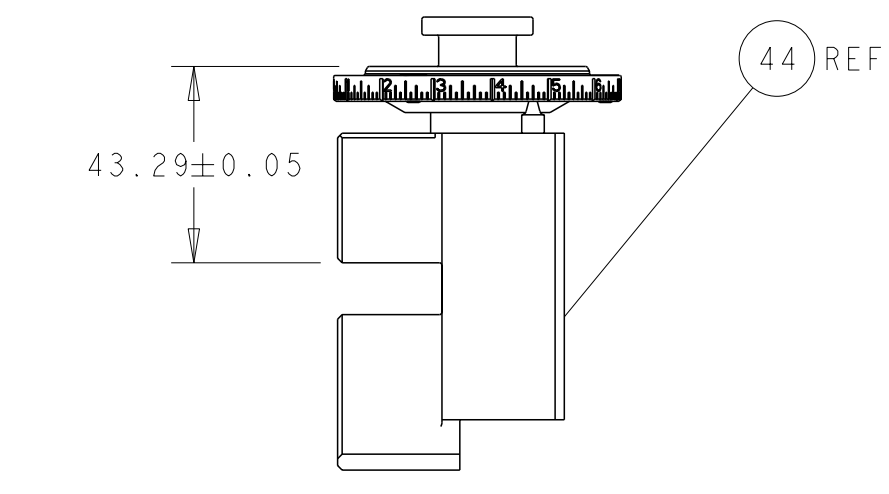
AIR FEED



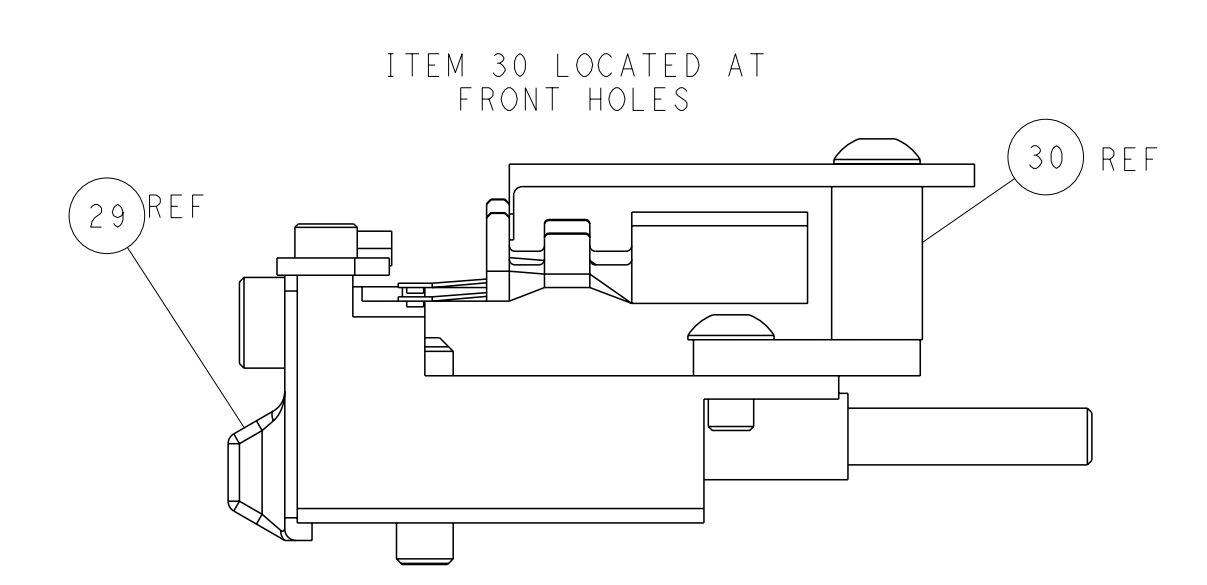
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



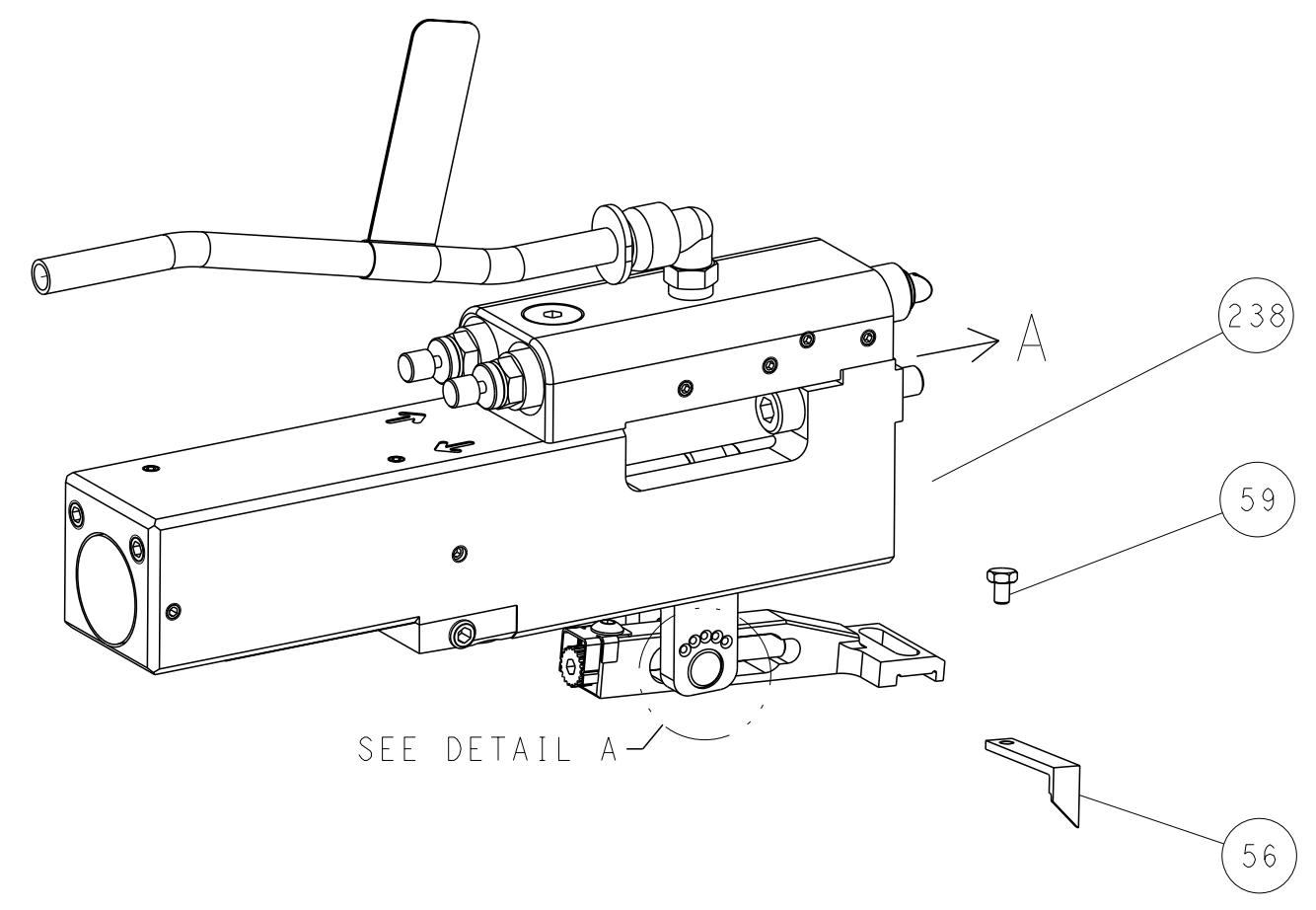
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

| | | | | | | | | | |
|--------------------|--|--|--|---|--|---|--|--|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | | DWG: R. O. WILSON 05OCT2012 CHK: K. J. STAKEM 08OCT2012 APVD: 08OCT2012 | | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151782 SCALE: 1:2 | | TE Connectivity Harrisbury, PA 17105-3608 | |
| MATERIAL: - | | WEIGHT: - | | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | SHEET 2 OF 4 | | REV E | |

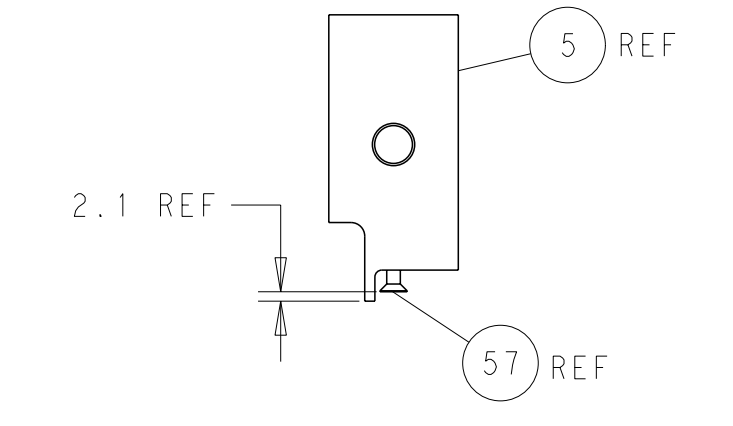
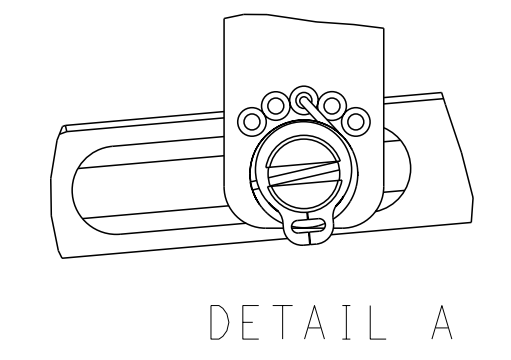
| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| A | 66 | P | LYR | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | - | - | - |

FEED TYPE PNEUMATIC

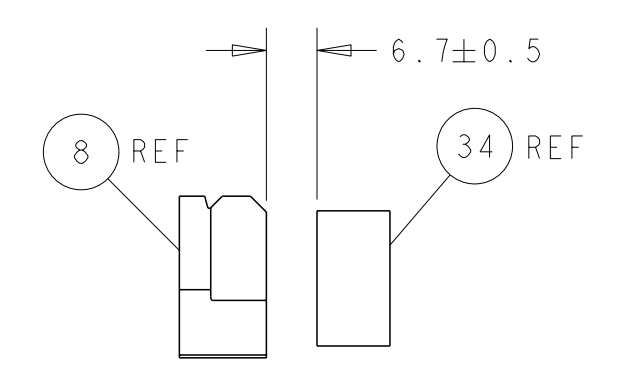


SEE DETAIL A

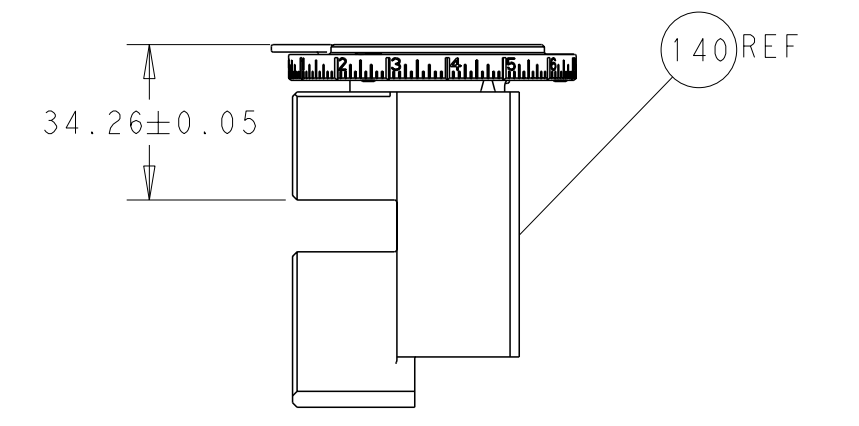
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



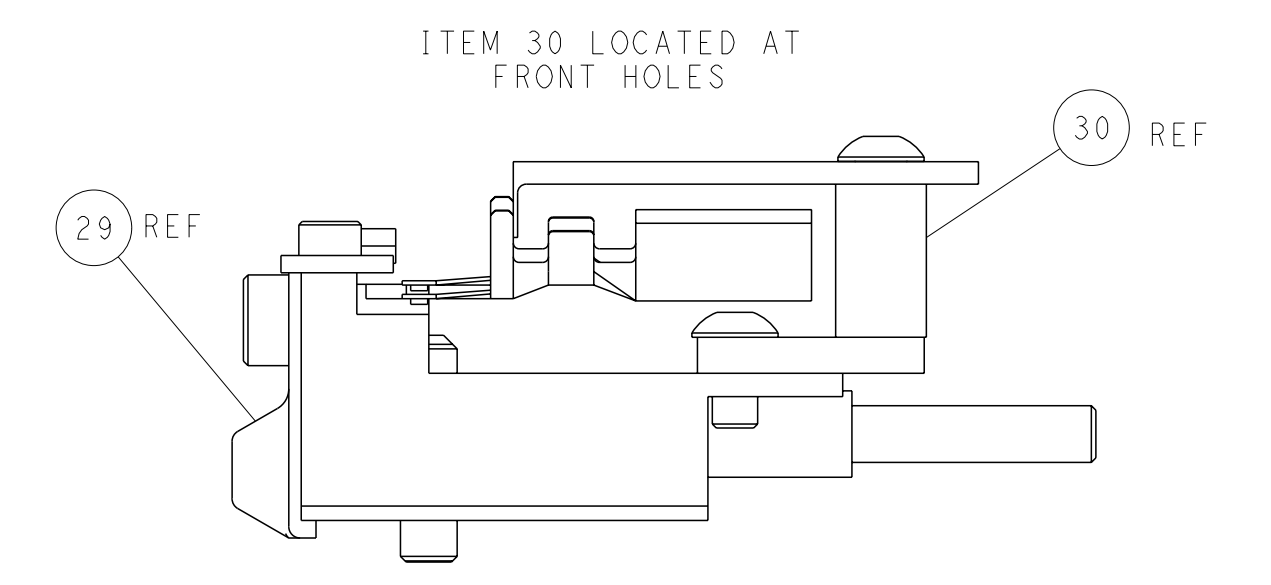
SHEAR DEPRESSOR DETAIL



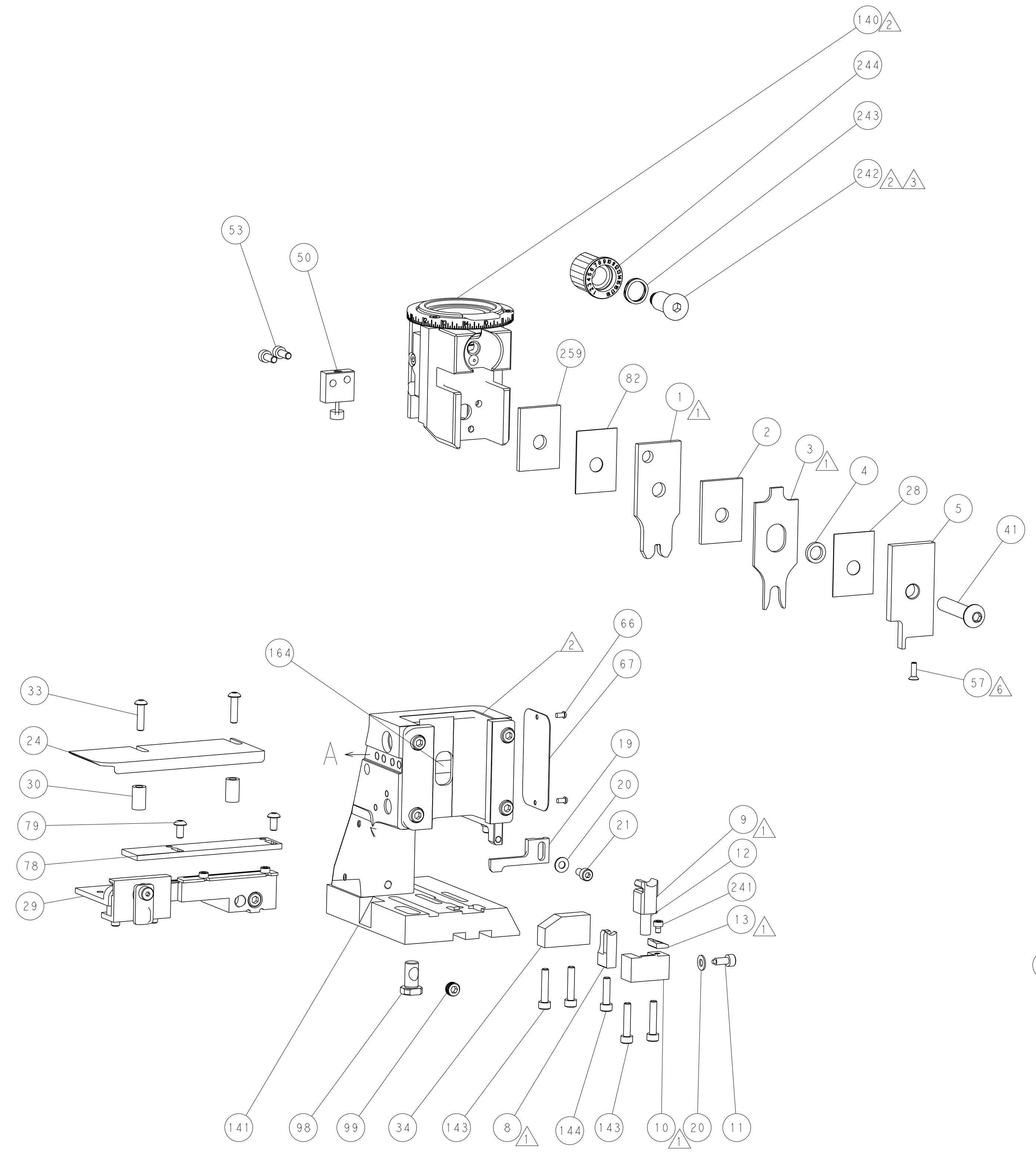
TERMINAL SUPPORT LOCATION



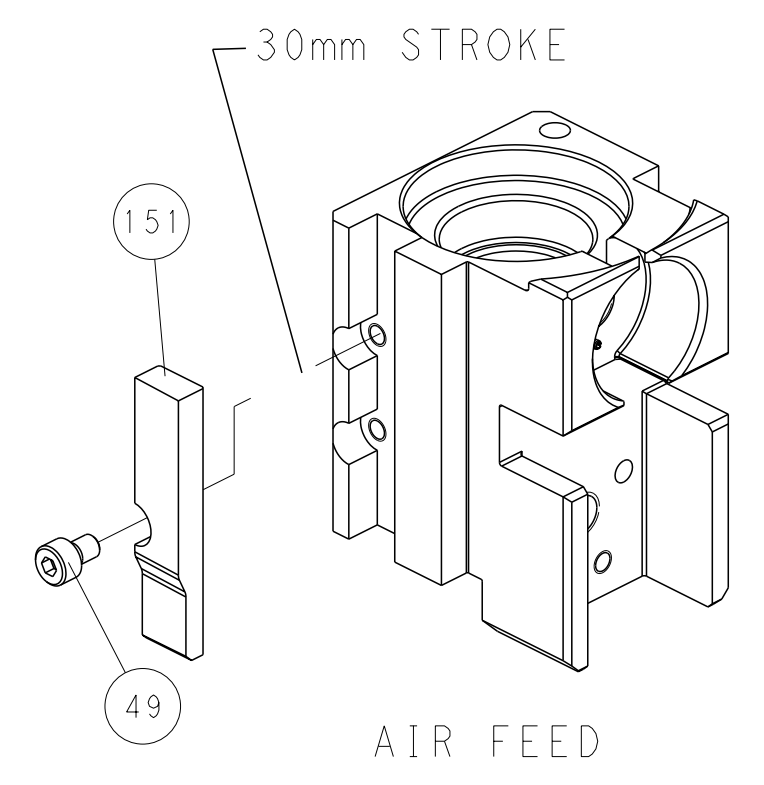
RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL



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 A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: R. O. WILSON 05OCT2012 CHK: K. J. STAKEM 08OCT2012 APVD: J. L. ELBIN 08OCT2012 | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151782 | TE Connectivity Harrisbury, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | MATERIAL: - FINISH: - | WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING | SCALE: 1:2 SHEET 4 OF 4 REV E | RESTRICTED TO: |