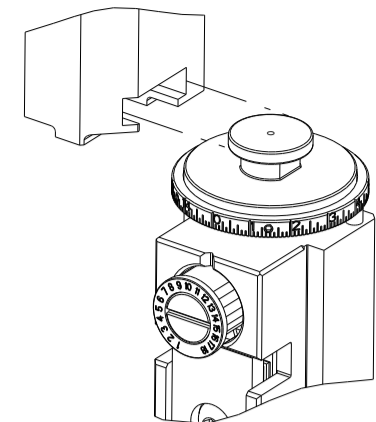


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151524-2	AB	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151524-2	AB	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
5-2151524-2	AB	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151524-2	AB	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151524-7	V	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.27 mm [.050]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO MQS TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-3.80 mm [.138-.150 IN]		Ø1.20-1.30 mm [.047-.051 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18858		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-1703930-1	2-1703930-2	2-1703930-3	2-1703930-4

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI DYNMIC WIRE SIDE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.55-3.75 mm [.139-.148 IN]		Ø0.95-1.30 mm [.037-.051 IN]	
TERMINAL APPLICATION SPECIFICATION	114-137526		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2834464-6			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.78+/- .02 [.0307+/- .0008]	9.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.72+/- .02 [.0280+/- .0008]	10.2
0.22mm2	0.64+/- .02 [.0250+/- .0008]	11.0

- 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.
- PRODUCTION ONLY ALLOWED WITH TOOLS WITH PNEUMATIC FEED. MECHANICAL FEED IS NOT ALLOWED.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEM 49 & 248.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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
		23		ECR-21-111089	23AUG2021	FJ	RK
		AA		ECR-21-120637	12NOV2021	FJ	RK
		AB		ECR-22-126544	13JAN2022	JWC	GB
		AB1		ECR-22-128110	30JAN2022	FZ	YY

-	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-3	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	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	2119740-1	TAG IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	36
-	1	1	1	1	9-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	31
-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-7	FLOATING SHEAR, FRONT	9
-	1	2	1	1	6-1633620-7	ANVIL, COMBINATION	8
-	1	1	1	1	2-240641-4	SPACER	7
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4
-	1	2	1	1	1803143-6	CRIMPER, INSULATION O	3
-	1	2	1	1	2-1333281-7	CRIMPER, WIRE, F, SMALL WIRE APPLICATION	3

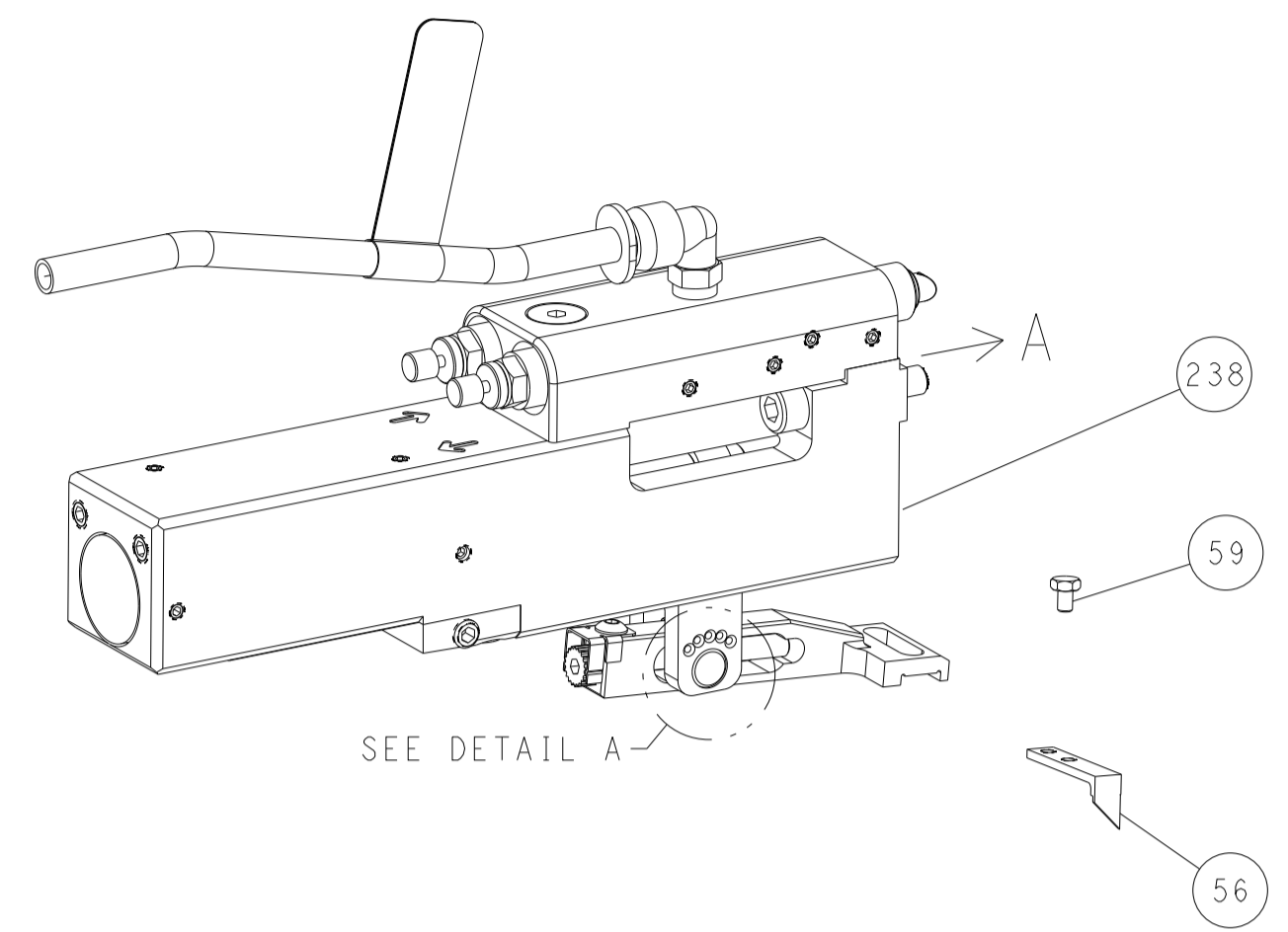
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		WEIGHT:		SCALE:	
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 AB1

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

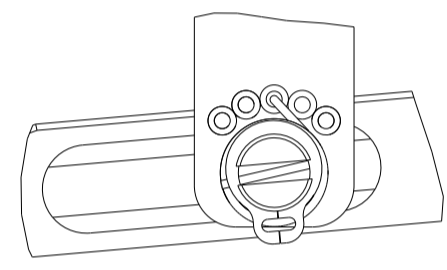
FEED TYPE

PNEUMATIC



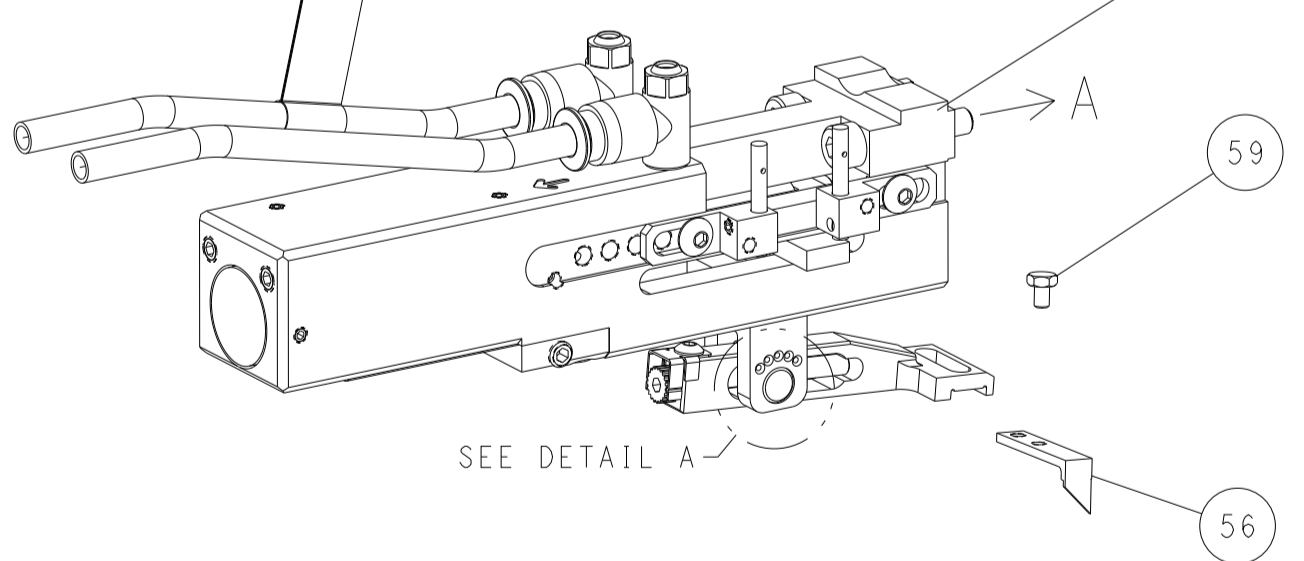
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



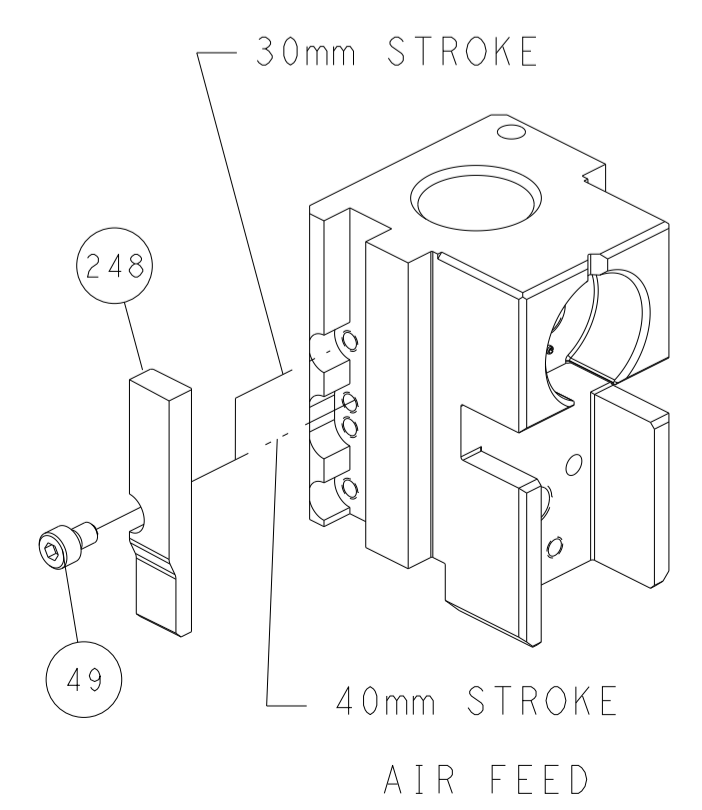
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

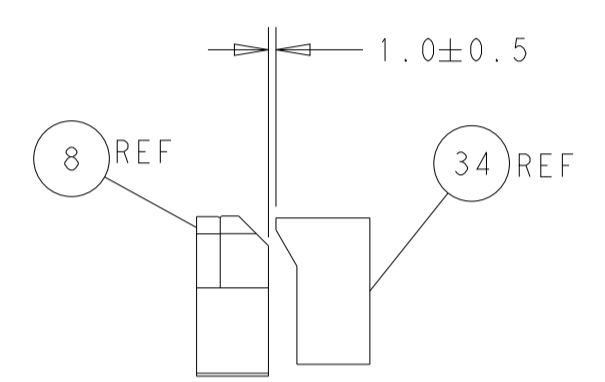
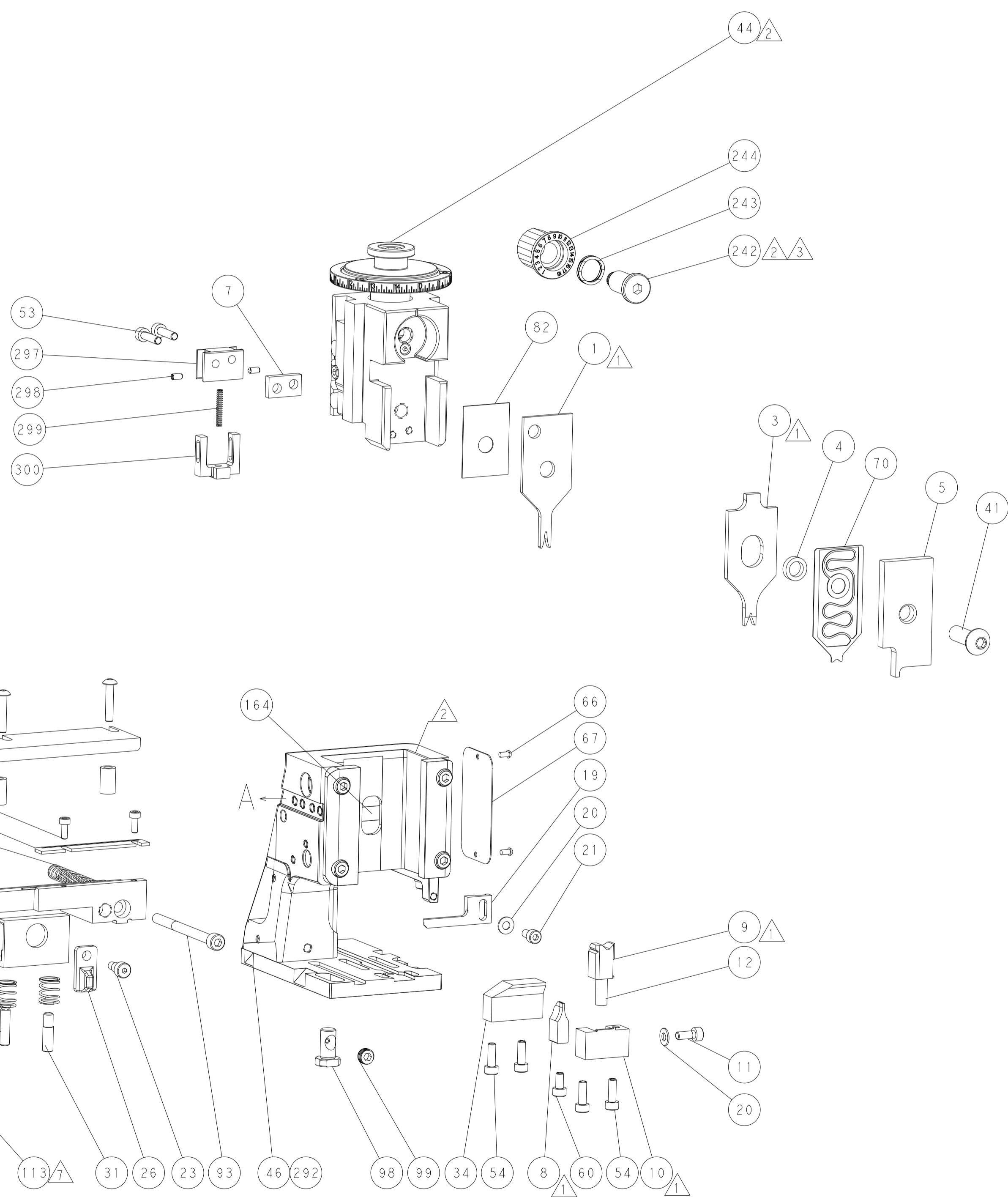


SEE DETAIL A

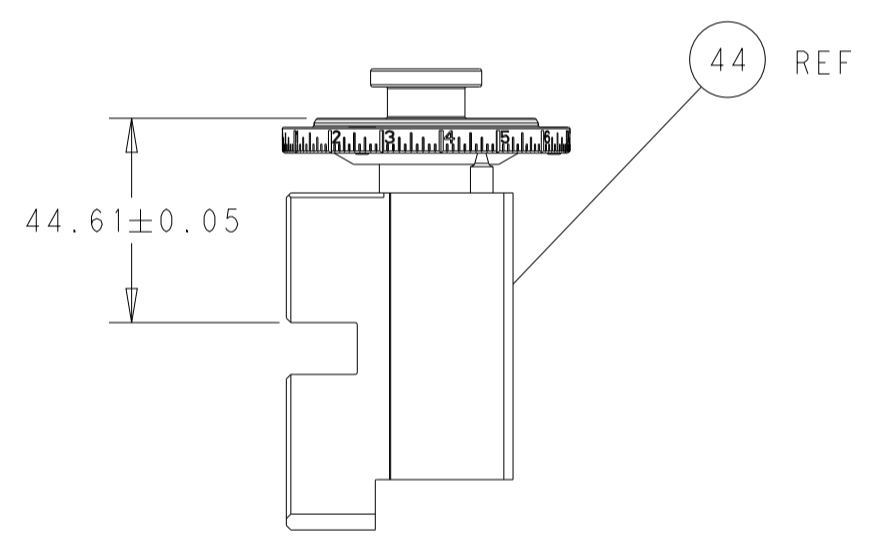
CAM POSITION



AIR FEED

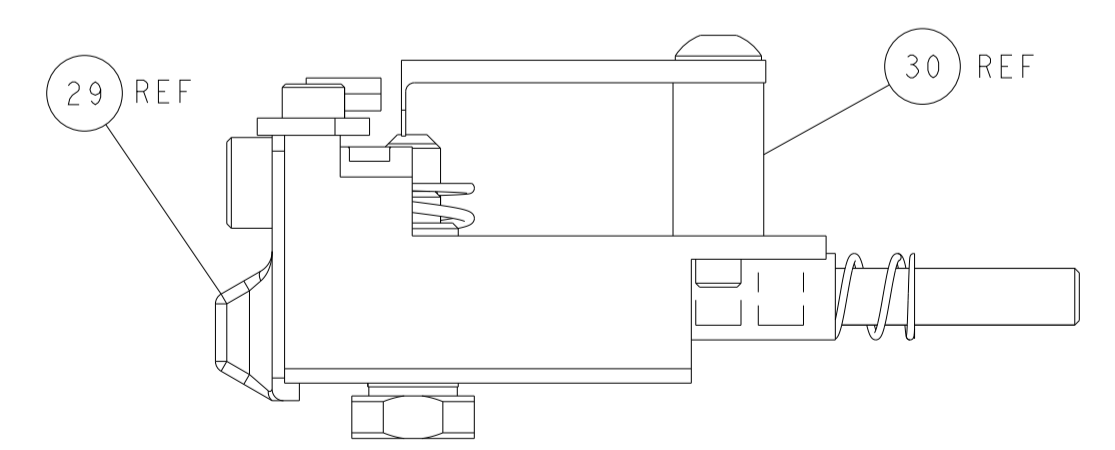


TERMINAL SUPPORT LOCATION



RAM AND HOLD-DOWN SET UP

ITEM 30 LOCATED AT FRONT HOLES



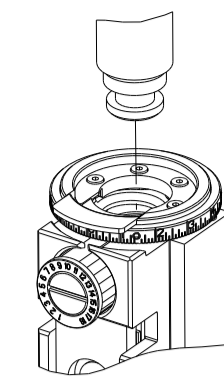
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2011 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER 01JUN2011 CHK: G. HOFENER 01JUN2011 APVD: T. ELBIN 01JUN2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151524 SCALE: 1:2 SHEET: 2 OF 4 REV: AB1
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	TE Connectivity Harrisburg, PA 17105-3608	RESTRICTED TO:

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151524-2	AB	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151524-2	AB	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTNG PNEUMATIC WITH SENSORS
7-2151524-7	V	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.27 mm [.050]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO MQS TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-3.80 mm [.138-.150 IN]		Ø1.20-1.30 mm [.047-.051 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-18858			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-1703930-1	2-1703930-2	2-1703930-3	2-1703930-4

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI DYNMIC WIRE SIDE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.55-3.75 mm [.139-.148 IN]		Ø0.95-1.30 mm [.037-.051 IN]	
TERMINAL APPLICATION SPECIFICATION 114-137526			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2834464-6			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.78+/- .02 [.0307+/- .0008]	9.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.72+/- .02 [.0280+/- .0008]	10.2
0.22mm2	0.64+/- .02 [.0250+/- .0008]	11.0

- 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.
- PRODUCTION ONLY ALLOWED WITH TOOLS WITH PNEUMATIC FEED. MECHANICAL FEED IS NOT ALLOWED.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEM 49 & 151.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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			

-	1	1	1803945-4	TONKER	300	
-	1	1	22278-9	SPRING, COMPRESSION	299	
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298	
-	1	1	1803944-1	SPACER, TONKER	297	
-	1	-	2844950-1	AIR FEED MODULE	290	
-	1	1	2119082-3	CAM, SNATL, INSULATION ADJUSTMENT	244	
-	1	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	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	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	1	1-22281-8	SPRING, COMPRESSION	121	
	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96	
-	1	1	1-690438-0	FRONT STRIP GUIDE	95	
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1338685-1	PAWL, FEED	56	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	36	
-	1	1	9-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	31	
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844938-1	PLATE, STRIP GUIDE	29	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1803142-1	DRAG, TERMINAL	25	
-	1	1	1320928-2	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	
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11	
	-	1	2119805-1	SHEAR HOLDER, FRONT	10	
	-	1	1803095-7	FLOATING SHEAR, FRONT	9	
	1	1	1	6-1633620-7	ANVIL, COMBINATION	8
-	1	1	2-240641-4	SPACER	7	
-	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4	
	1	1	1	1803143-6	CRIMPER, INSULATION O	3
	1	1	1	2-1333281-7	CRIMPER, WIRE, F, SMALL WIRE APPLICATION	3

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:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±	FINISH			

CHK	DATE	DESCRIPTION
D. WEAVER	01JUN2011	TE Connectivity
G. HOFFNER	01JUN2011	Harrisburg, PA 17105-3608
T. ELBIN	01JUN2011	

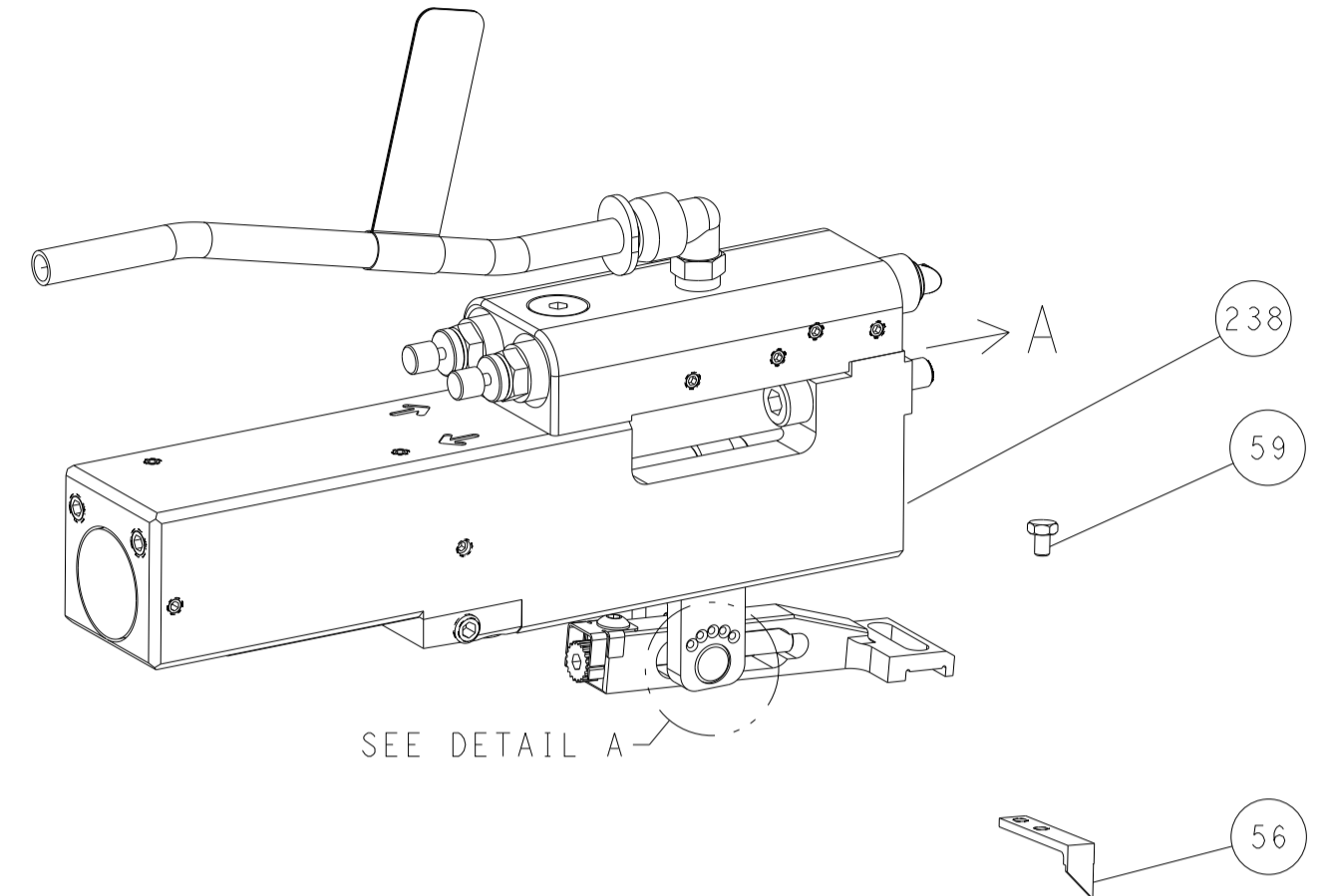
NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Ocean Side Feed Applicator	A1	00779	2151524	

Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV AB1

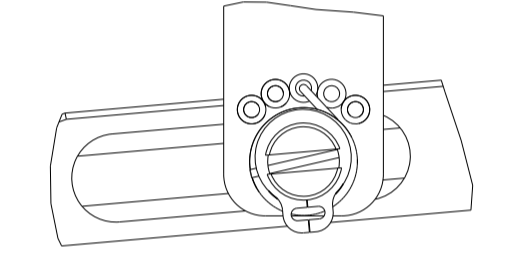
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

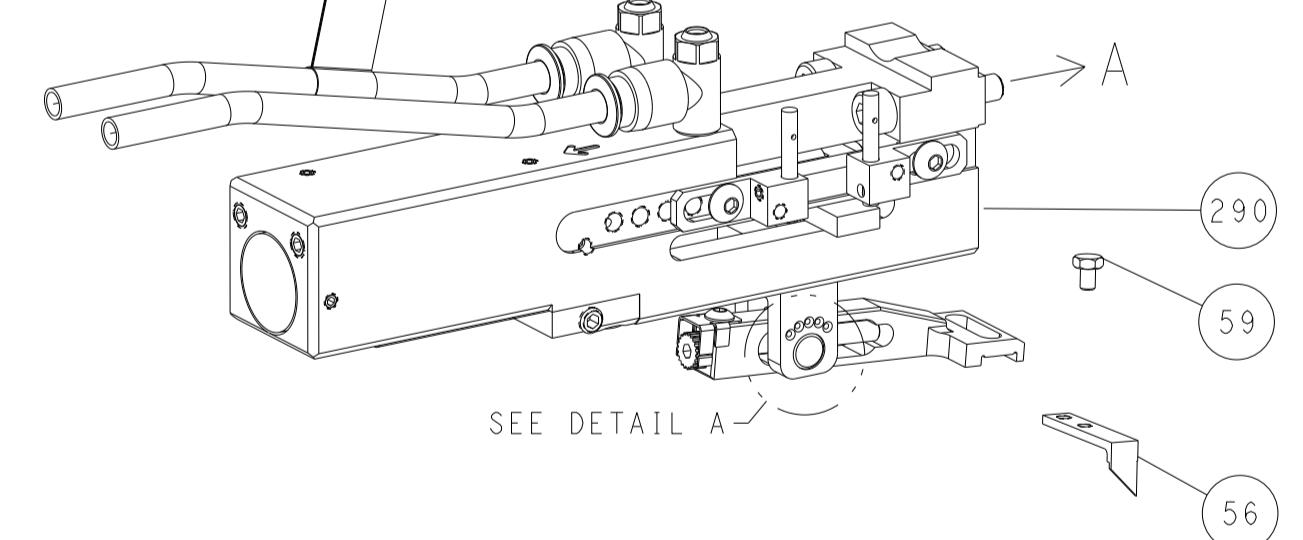


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

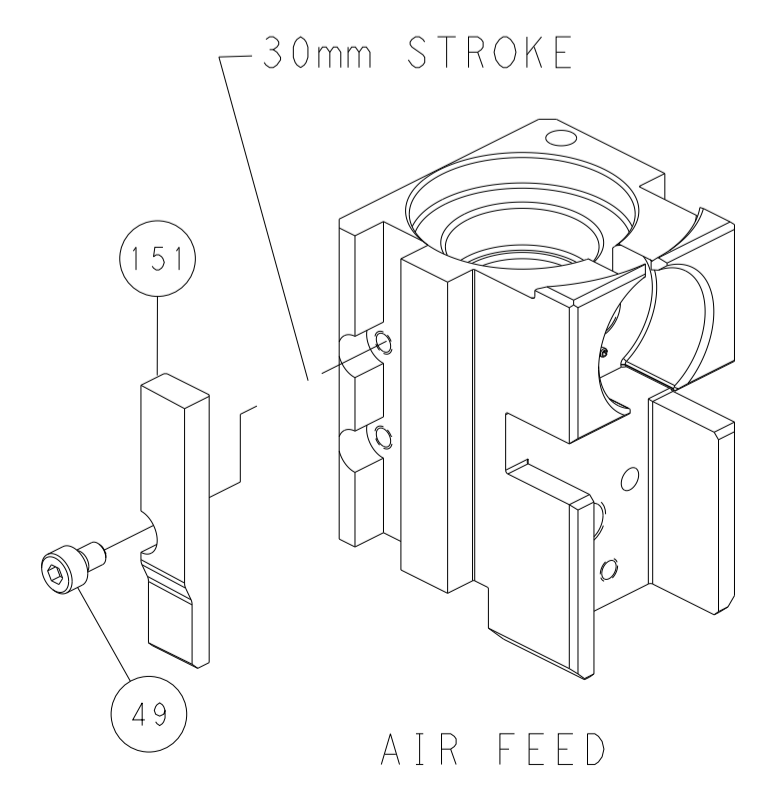


DETAIL A

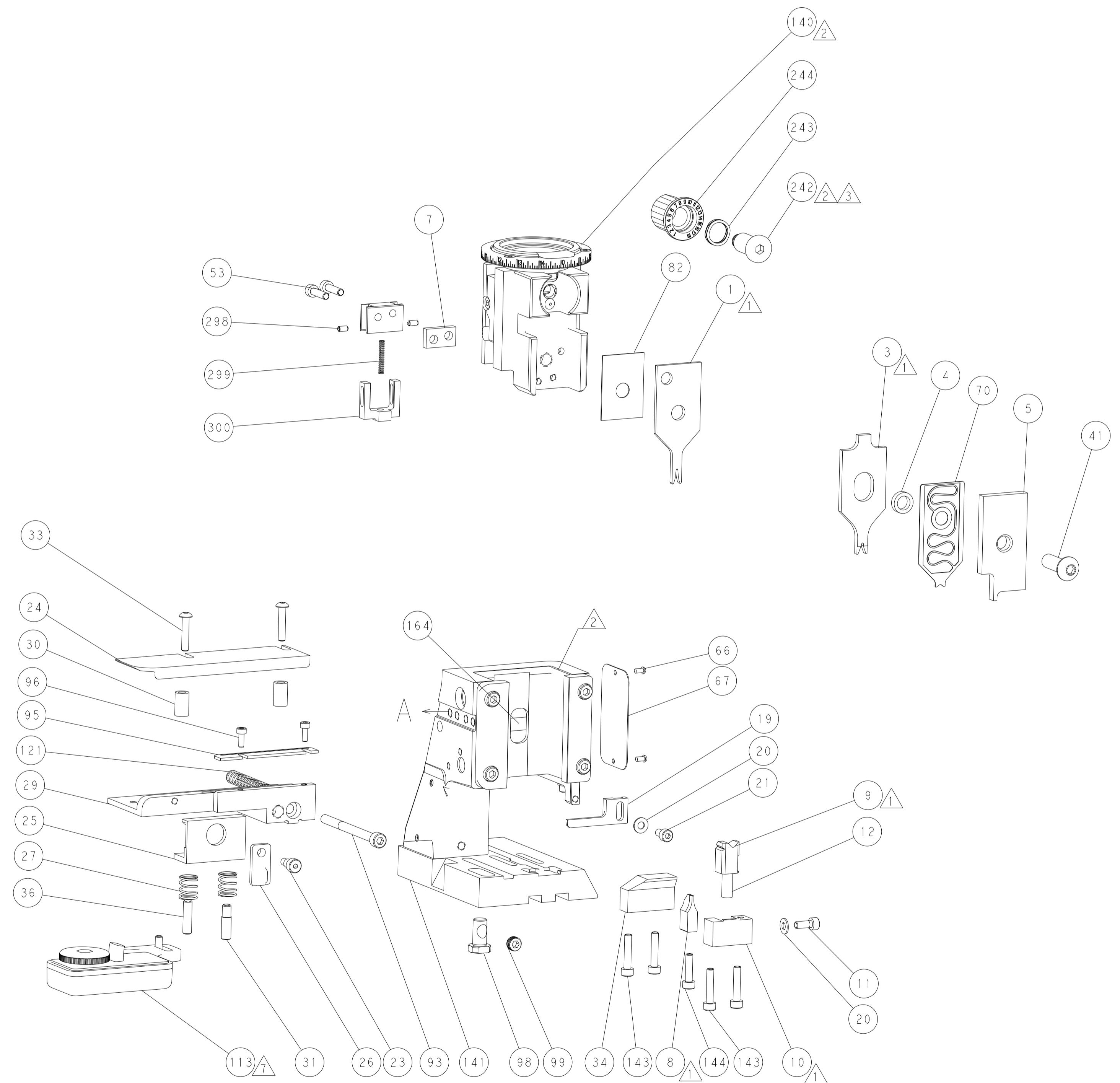
DOUBLE ACTING PNEUMATIC WITH SENSORS



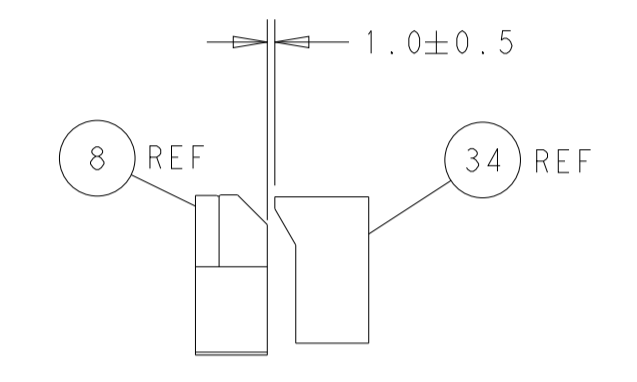
CAM POSITION



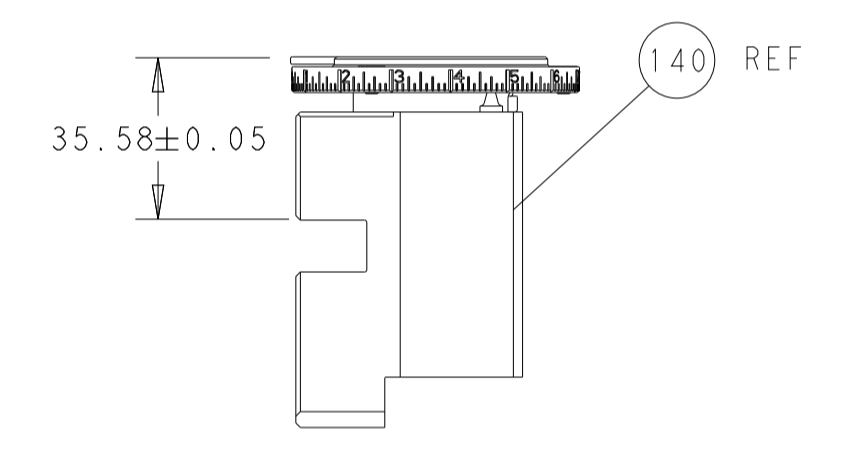
AIR FEED



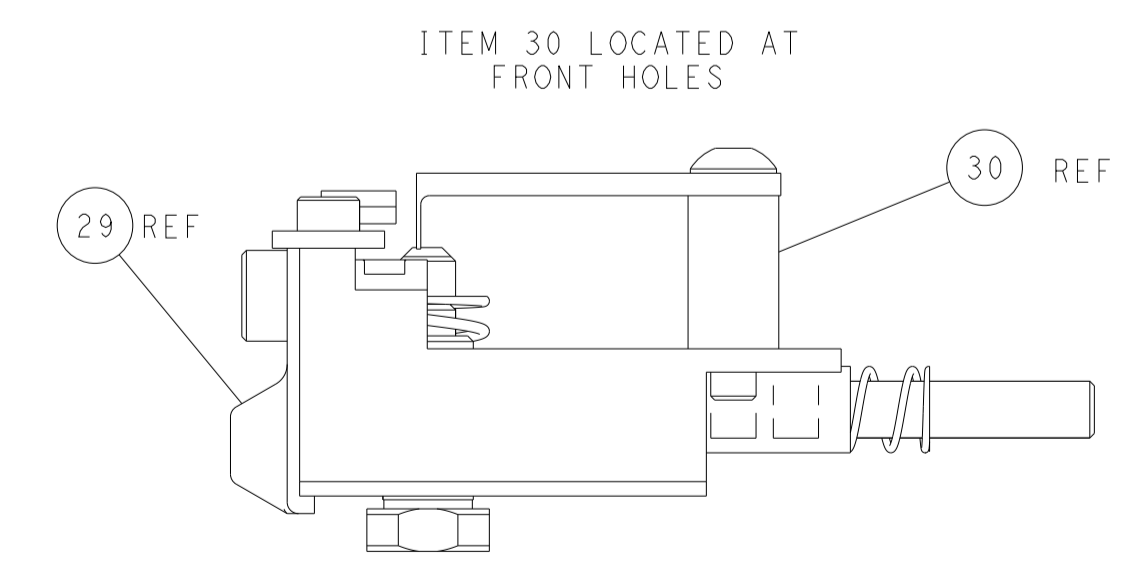
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator APPLICATION SPEC: - PRODUCT SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151524 SCALE: 1:2 SHEET: 4 OF 4 REV: AB1	RESTRICTED TO: -