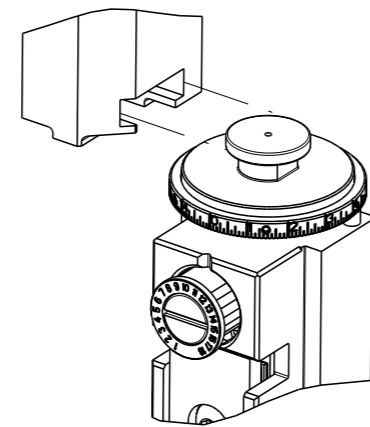


THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151340-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151340-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151340-7	A	CRIMP TOOLING KIT	-

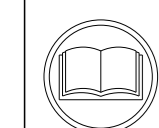
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



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: RECEPTACLE, HEAVY DUTY BURNER CONNECTOR			
WIRE STRIP LENGTH 4.70-5.40 mm [.185-.213 IN]		INSULATION DIAMETER RANGE Ø 3.96 mm MAX [.156 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-1028	-	-
TERMINALS APPLIED 6			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
640748-1	640748-7		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88 +/- 0.05 [0.074 +/- .002]	2.4
16 AWG	1.65 +/- 0.05 [0.065 +/- .002]	5.1
18 AWG	1.47 +/- 0.05 [0.058 +/- .002]	7.2



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

**\*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	REV	DATE	BY	APPV
		B	29AUG2013	XZ	TE
		C	20DEC2018	FL	CT
		D	05JUN2019	FJ	TE
		E	27APR2020	LG	TE

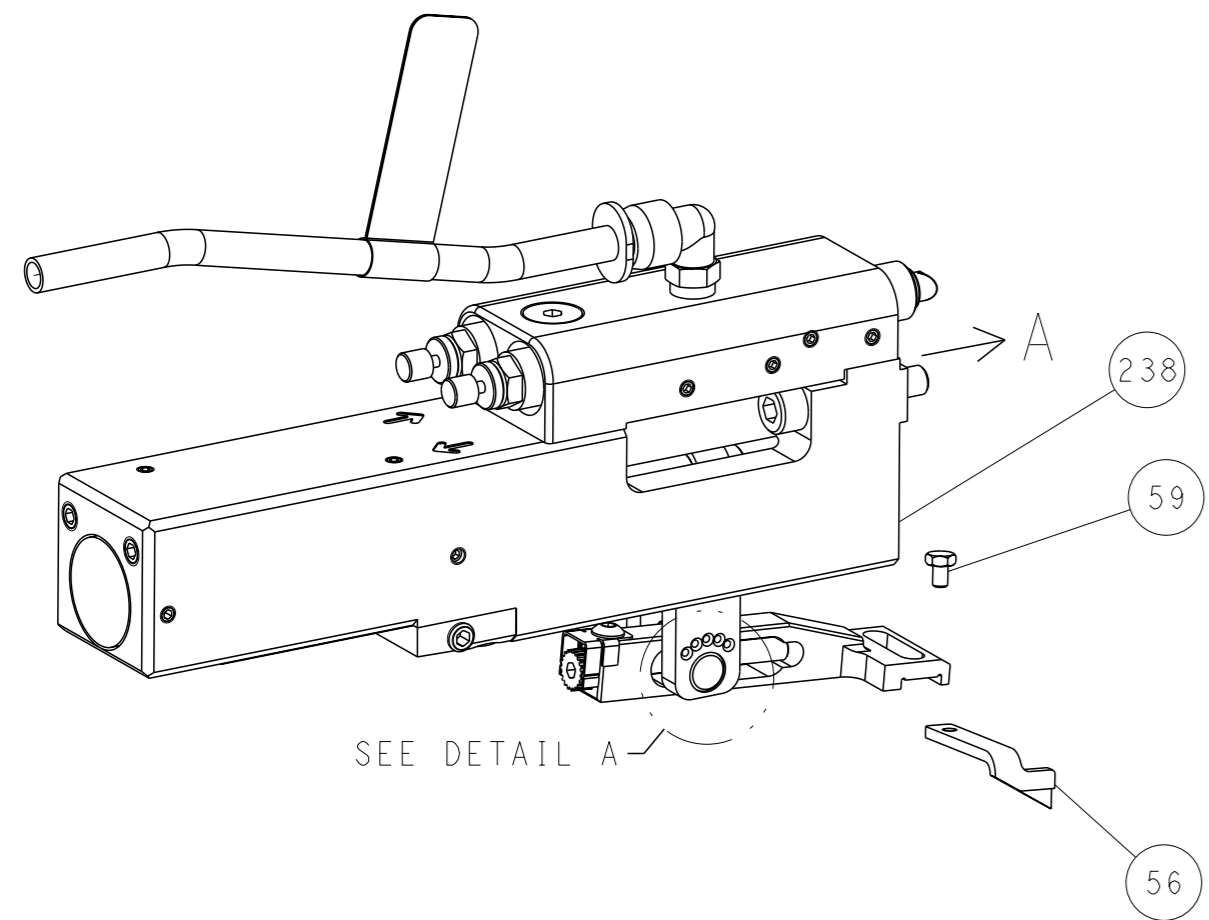
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-5	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	318563-1	GUARD, FRONT CHIP	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-7	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	133240-1	PAWL, FEED (SPECIAL)	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	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	2	2	3-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	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
-	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	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	454276-5	FLOATING SHEAR, FRONT	9
1	2	1	1633134-3	ANVIL, COMBINATION .110	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	2	1	456408-3	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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN X ZHAO 19MAR2012		TE Connectivity	
mm		0 PLC ±		CHK T. ELBIN 19MAR2012		Harrisburg, PA 17105-3608	
1 PLC ±		2 PLC ±		APVD S X I 19MAR2012		NAME	
3 PLC ±		4 PLC ±		PRODUCT SPEC		Ocean Side Feed	
5 PLC ±		FINISH		APPLICATION SPEC		Applicator	
MATERIAL		WEIGHT		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
-		-		A1 00779 C=2151340		-	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 1 OF 4 REV E	

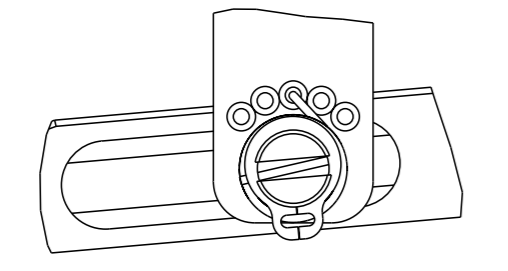
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

# FEED TYPE PNEUMATIC

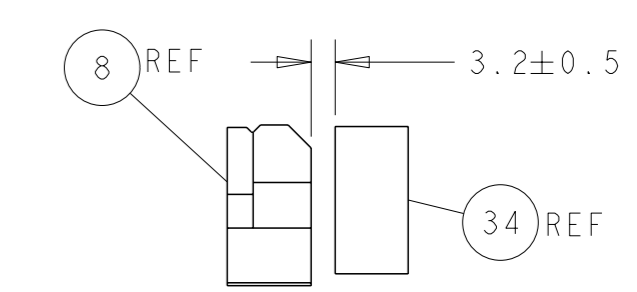
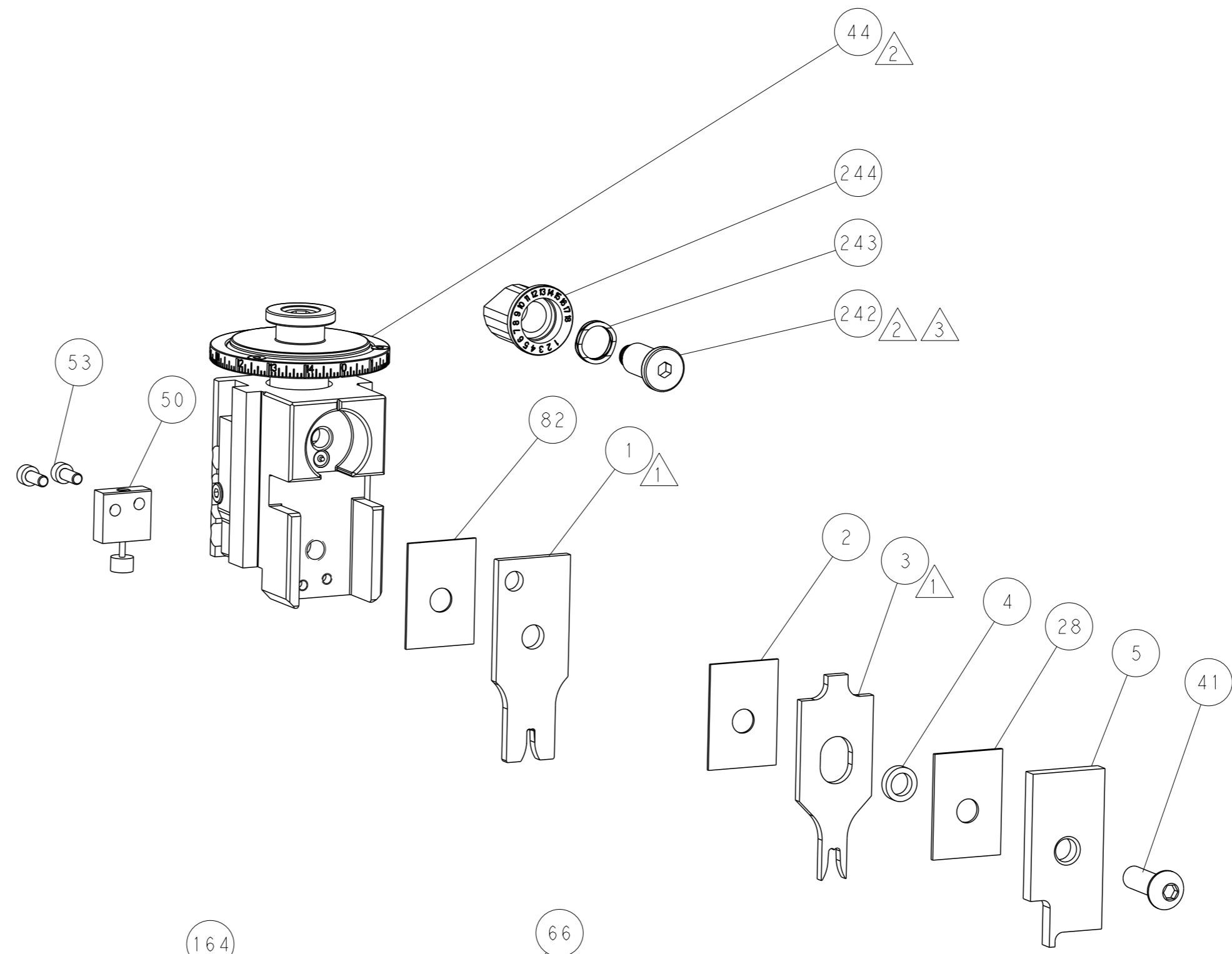


SEE DETAIL A

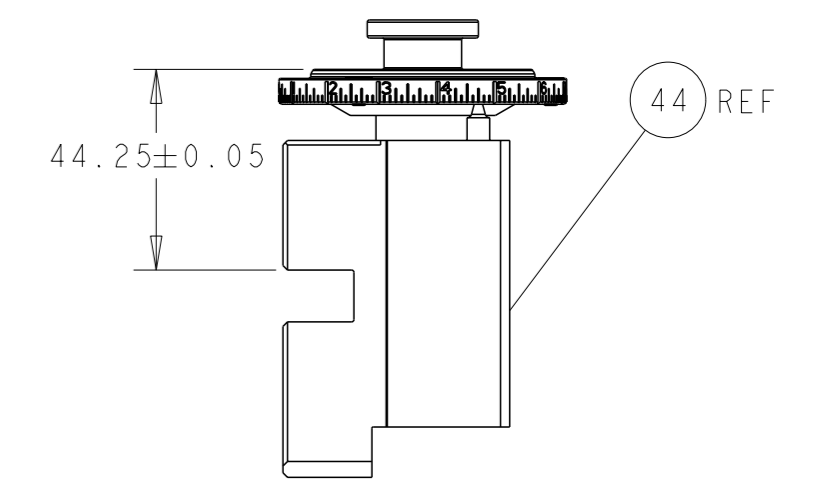
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



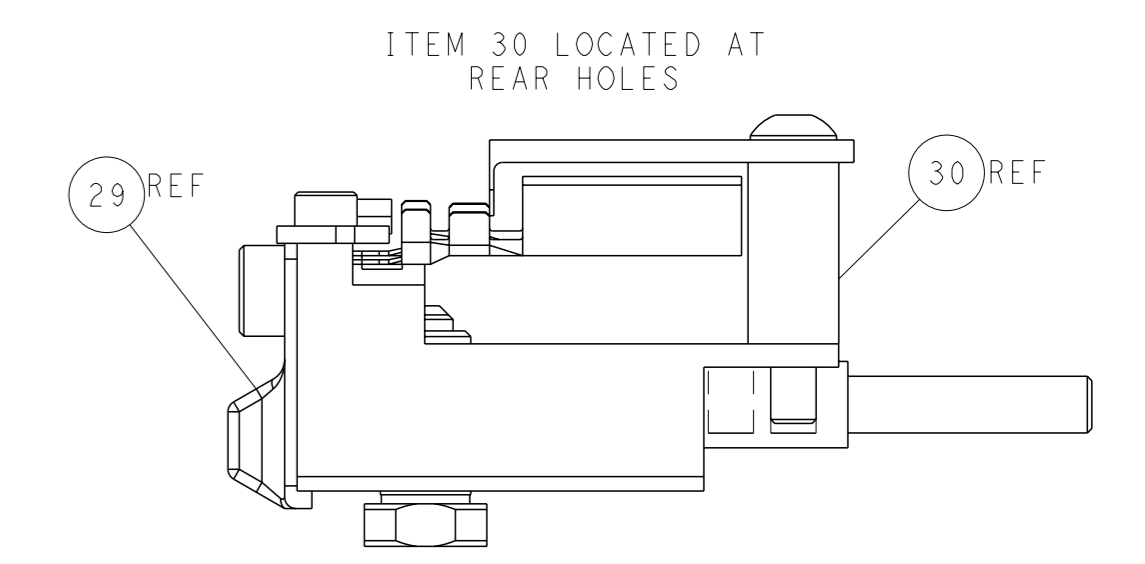
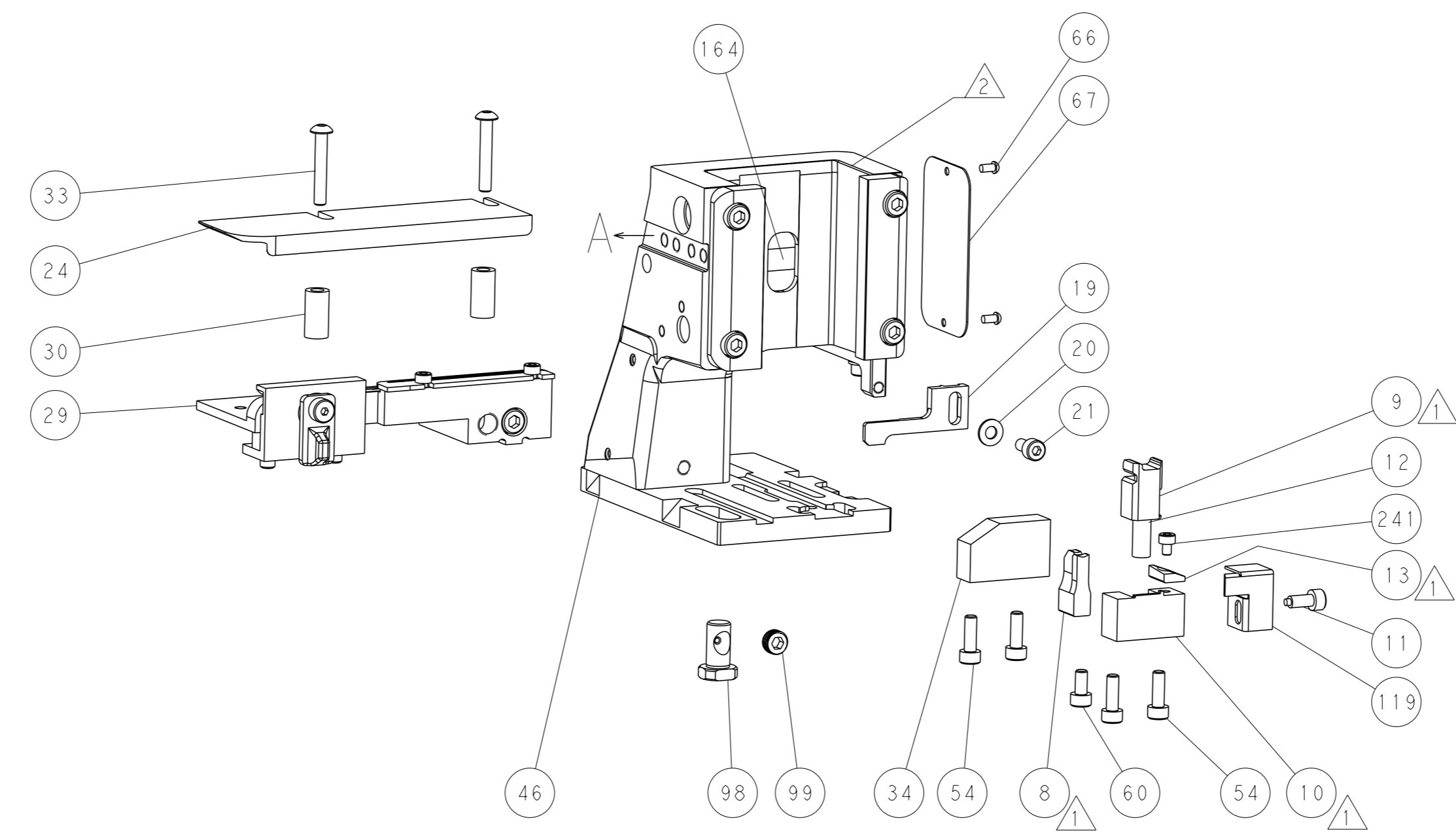
DETAIL A



TERMINAL SUPPORT LOCATION

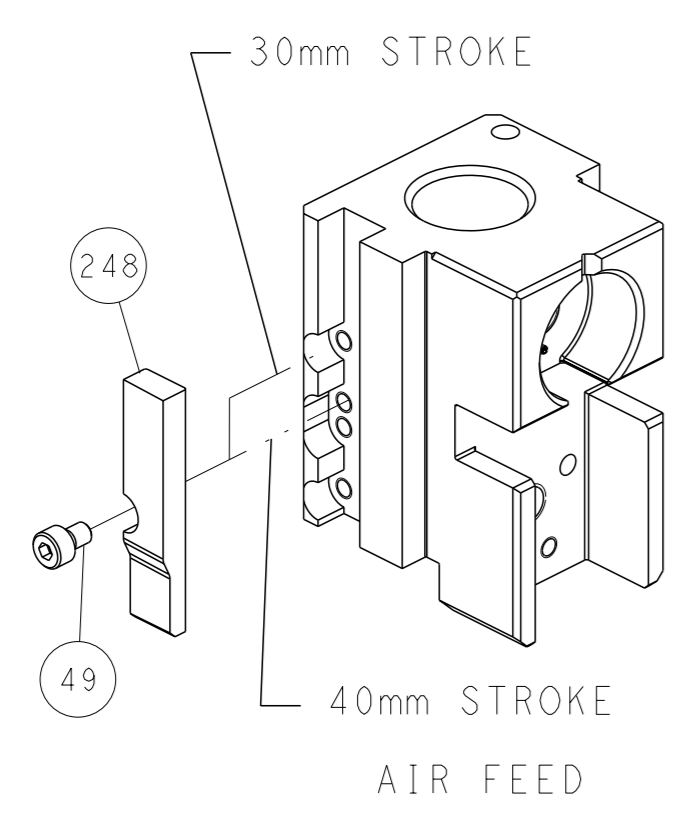


RAM SET-UP



FEED TRACK POSITION  
GUIDE BY WIRE BARREL

# CAM POSITION

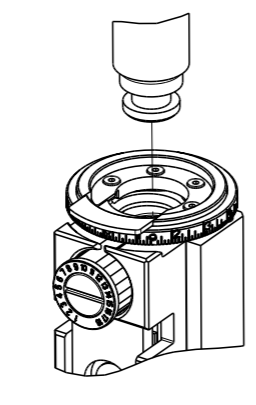


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN X.ZHAO 19MAR2012 CHK T.ELBIN 19MAR2012 APVD S.XI 19MAR2012	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 SIZE CAGE CODE DRAWING NO. A1 00779 C=2151340 WEIGHT - Customer Accessible Production Drawing	RESTRICTED TO - SCALE 1:2 SHEET 2 of 4 REV E

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151340-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151340-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER

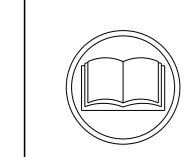


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, HEAVY DUTY BURNER CONNECTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.40 mm [.185-.213 IN]		Ø 3.96 mm MAX [.156 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-1028	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
640748-1	640748-7		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88 +/- 0.05 [.074 +/- .002]	2.4
16 AWG	1.65 +/- 0.05 [.065 +/- .002]	5.1
18 AWG	1.47 +/- 0.05 [.058 +/- .002]	7.2



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1		-	-

-	1	2119082-9	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	2844940-5	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	318563-1	GUARD, FRONT CHIP	119
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-7	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	1333240-1	PAWL, FEED (SPECIAL)	56
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1752356-1	SUPPORT, TERMINAL	34
-	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	2	3-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-1	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
-	1	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	1633134-3	ANVIL, COMBINATION .110	8
-	-	-	-	7
-	-	-	-	6
-	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-7	SPACER, CRIMPER	2
-	1	456408-3	CRIMPER, WIRE PREMIUM	1
-	77	-22	PART NO	ITEM NO

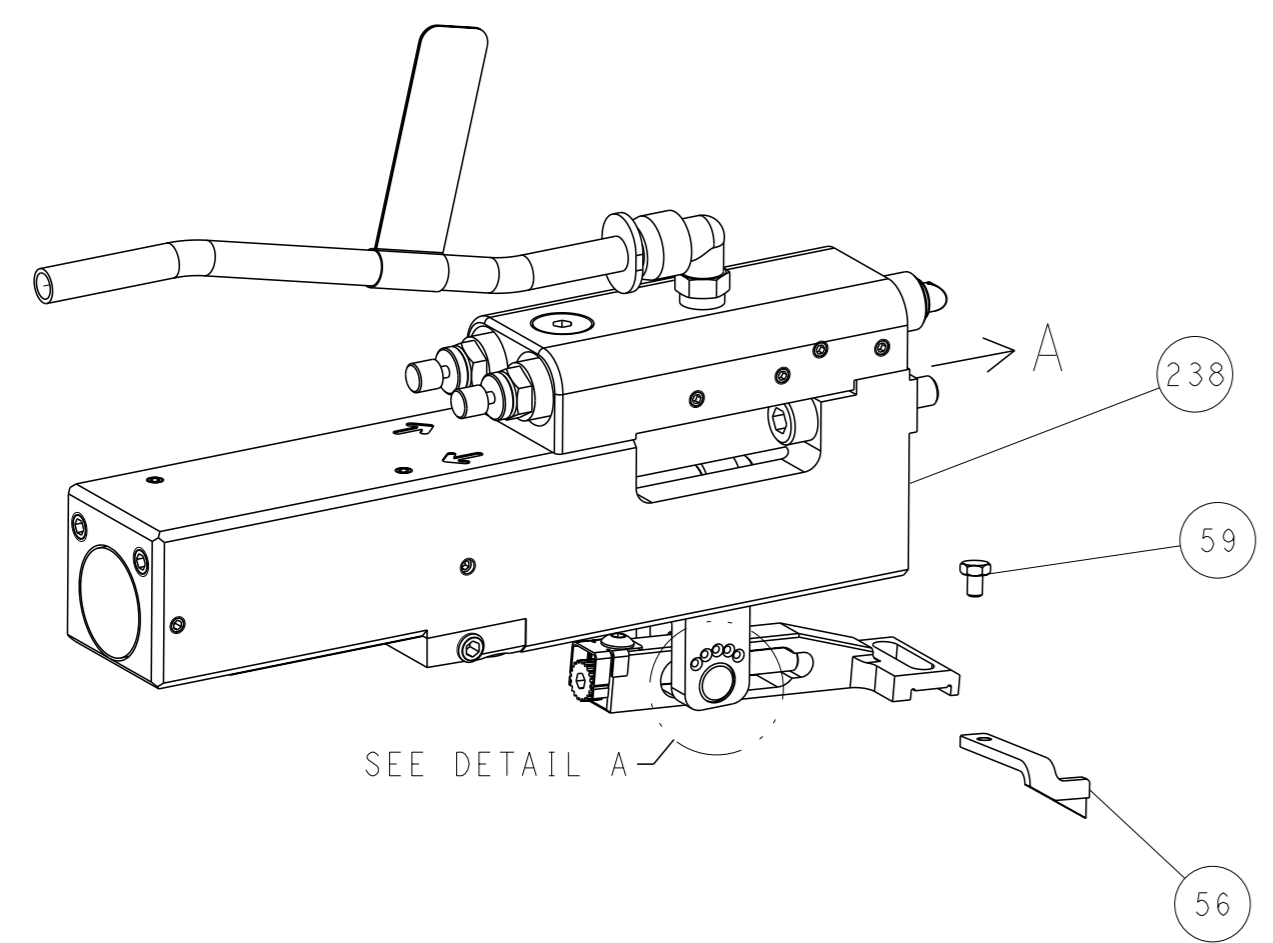
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN X ZHAO 19MAR2012 CHK T ELBIN 19MAR2012 APVD S YI 19MAR2012		NAME Ocean Side Feed Applicator	
MATERIAL .		WEIGHT .		SIZE CAGE CODE DRAWING NO A1 00779 ©=2151340		RESTRICTED TO .	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 3 OF 4 REV E		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	

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

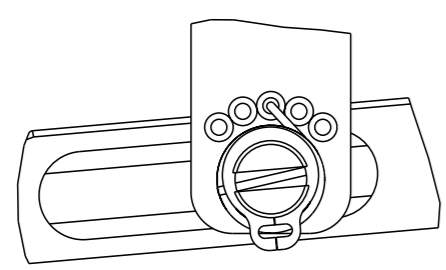
# FEED TYPE

## PNEUMATIC

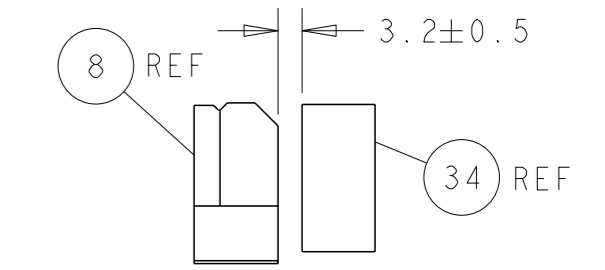
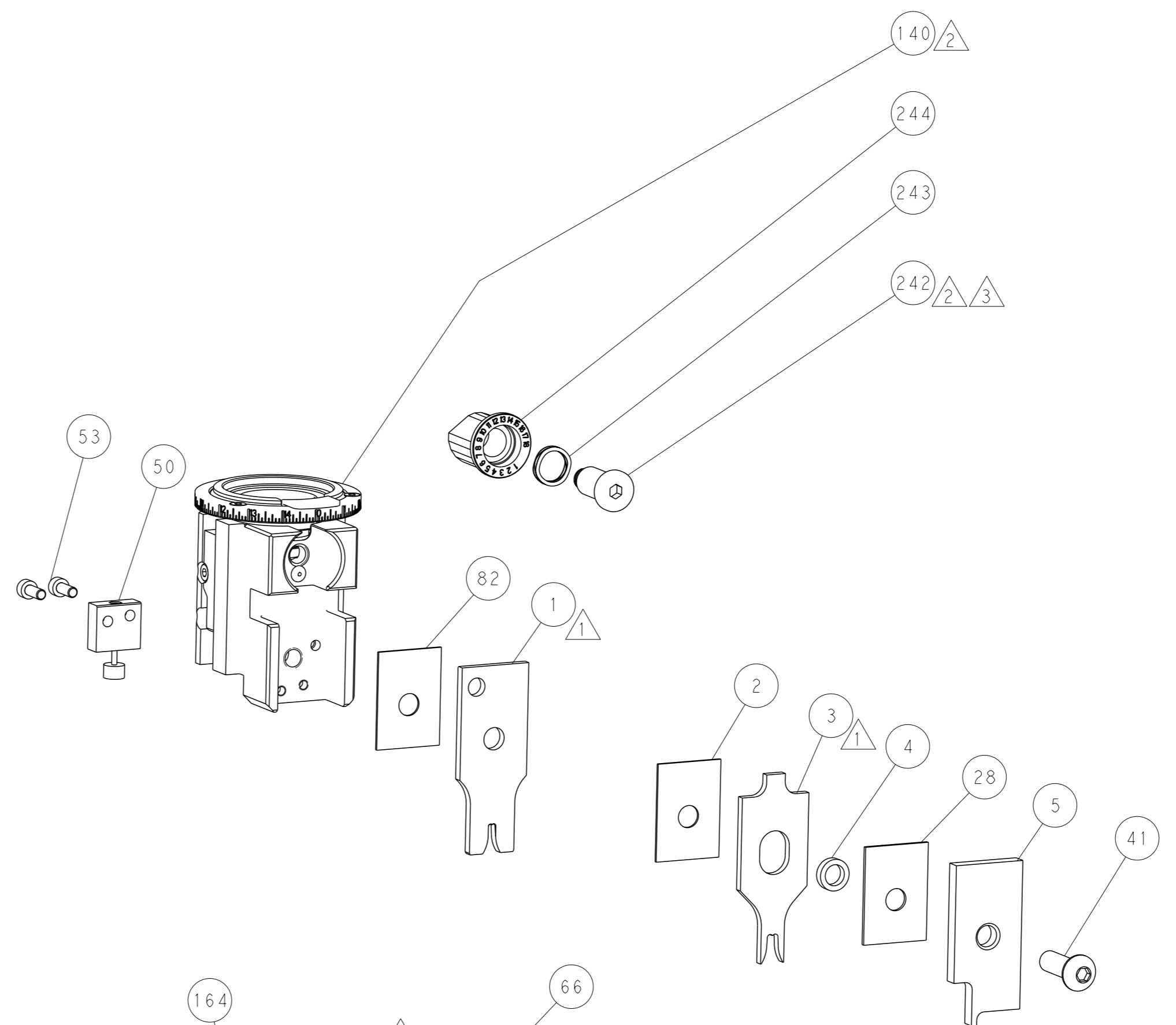


SEE DETAIL A

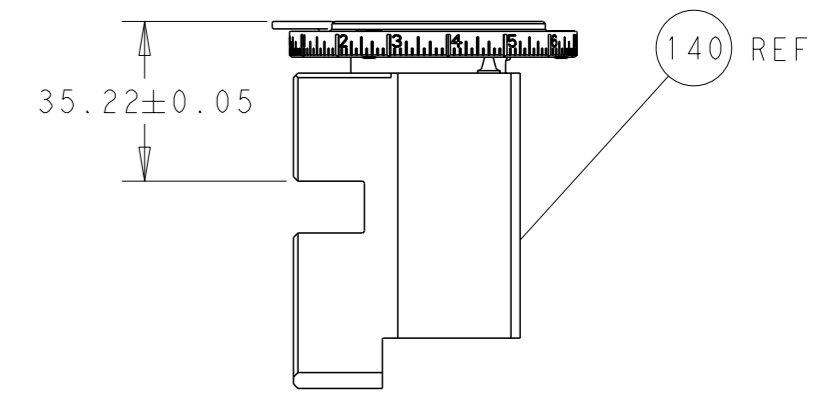
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



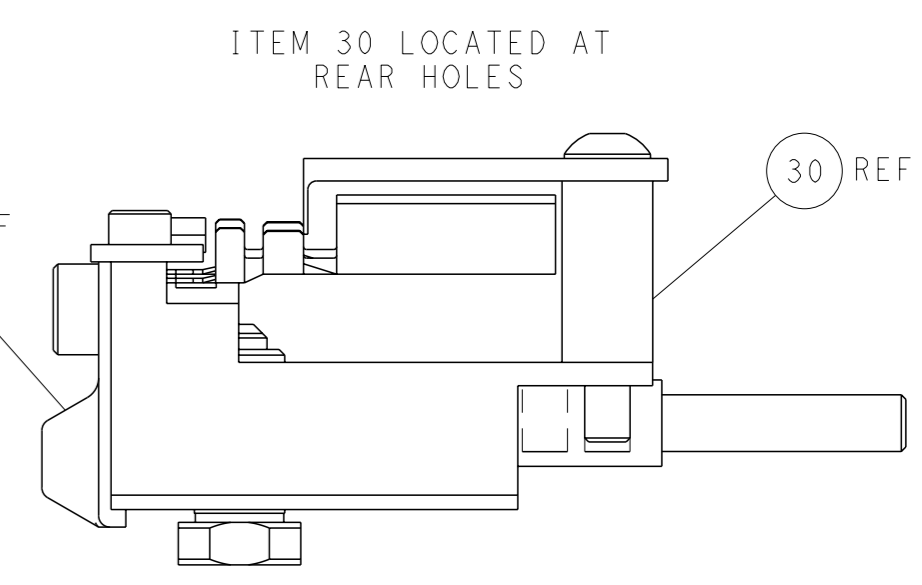
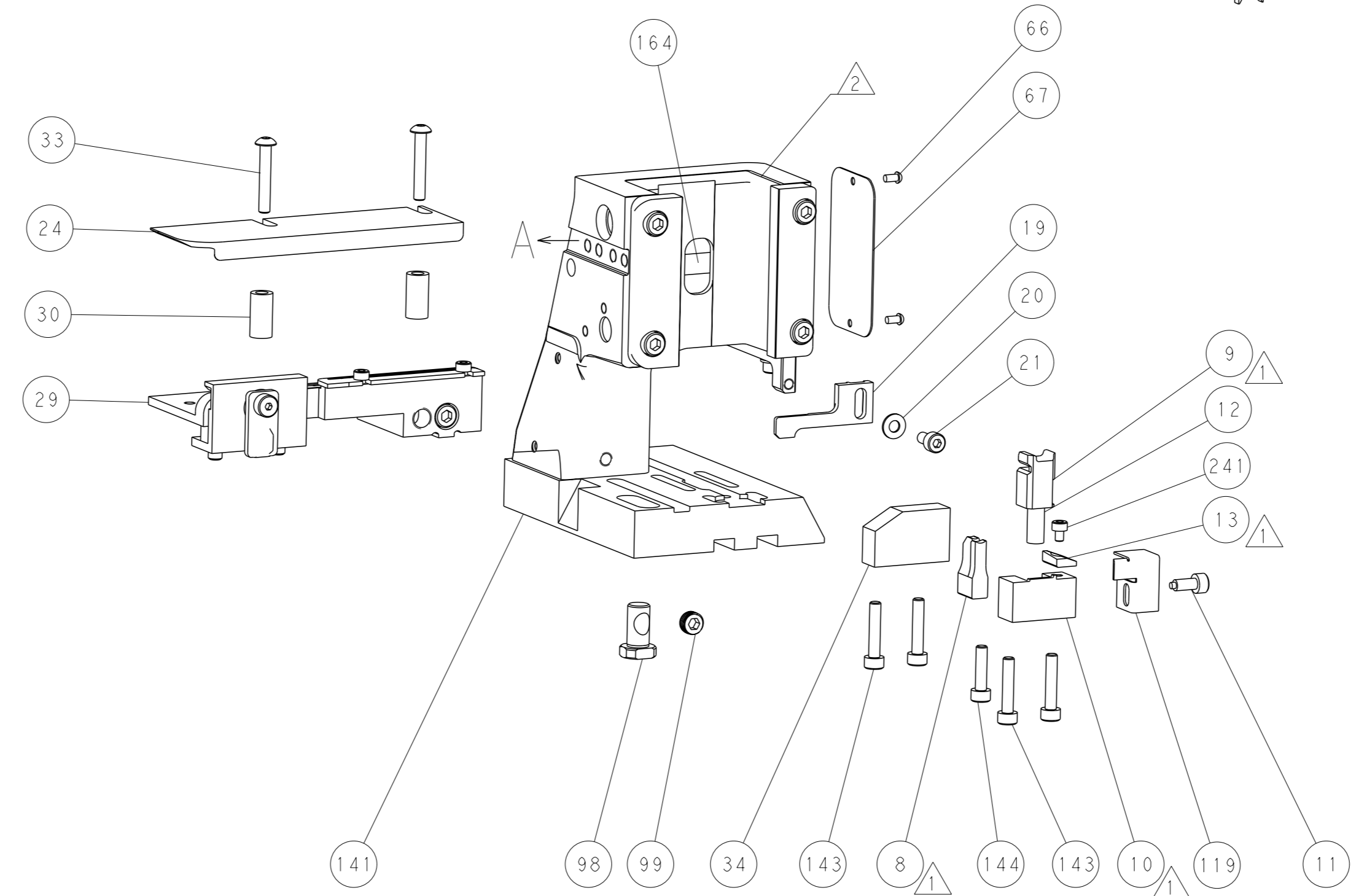
DETAIL A



TERMINAL SUPPORT LOCATION

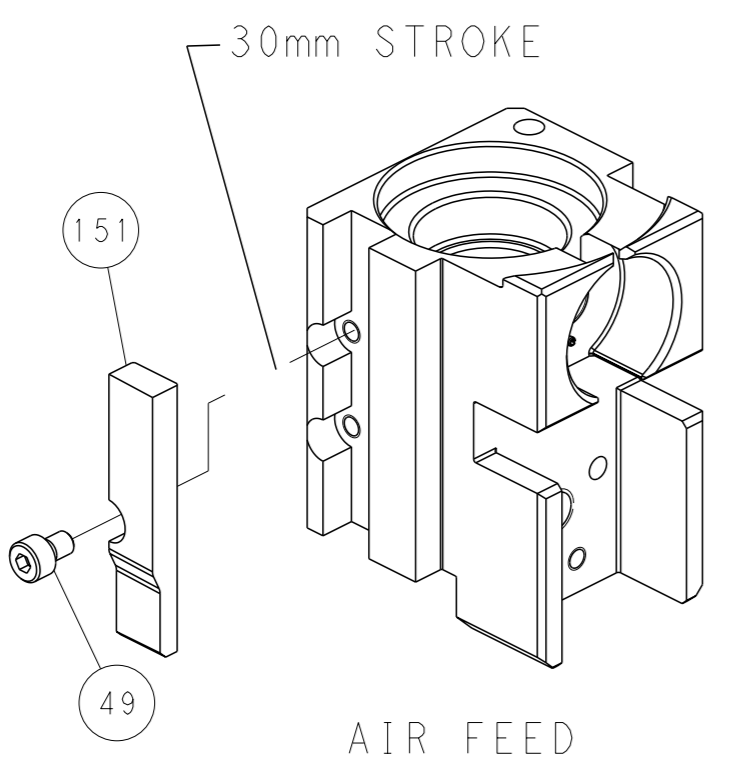


RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

## 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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER SHALL CONTACT THE DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN X.ZHAO 19MAR2012 CHK T.ELBIN 19MAR2012 APVD S.XI 19MAR2012	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151340 SCALE: 1:2 SHEET: 4 of 4 REV: E	RESTRICTED TO:
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing