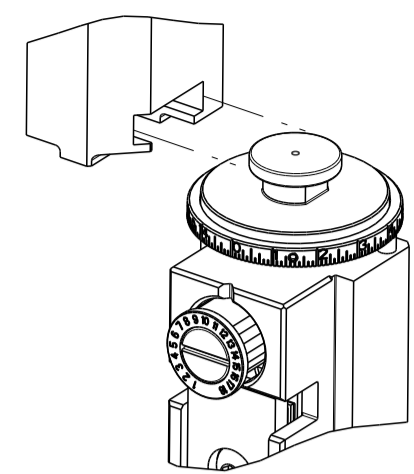


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151316-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151316-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151316-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.59 mm [.220]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POWER RING			
WIRE STRIP LENGTH 5.95-6.75 mm [.234-.266 IN]		INSULATION DIAMETER RANGE Ø2.79-4.06 mm [.110-.160 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2087			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63166-1	63166-2	63166-4	63166-5
521843-1	521844-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 14 AWG	3.07+/-0.05 [.121+/-0.002]	3.7
12 AWG	2.90+/-0.05 [.114+/-0.002]	5.1
14 AWG	2.64+/-0.05 [.104+/-0.002]	8.0
16 AWG	2.46+/-0.05 [.097+/-0.002]	10.4

- 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.
- WIRE STRIP LENGTHS LISTED ARE FOR AWG WIRE. WIRE STRIP LENGTHS FOR HOUSEHOLD WIRE IS: 18.65-19.45 mm [.734-.766 IN].
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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	APPD
		B		ECR-18-004534	26MAR2018	MEH	JDG
		C		ECR-20-005218	08APR2020	FJ	TE
		D		ECR-20-007667	28MAY2020	JAH	GB
		E		ECR-22-153498	22SEP2022	ROY	GEB

-	1	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	283	
-	1	1	1803315-1	LOWER SHEAR, RIGHT	282	
-	1	1	1-18028-3	WASHER, FLAT, REG M5	281	
-	1	1	1803196-1	STUD, ADJUSTMENT SCREW	280	
-	1	1	23238-1	INSERT, COUPLING	278	
-	1	1	2030758-3	TUBING, POLYURETHANE	277	
-	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	276	
-	1	1	986220-2	CLAMP, CABLE, BLACK	275	
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	274	
-	1	1	1803319-1	SUPPORT, AIR BLAST	273	
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	269	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	265	
-	1	1	1803313-1	SLUG BLADE	264	
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	263	
-	1	1	1803312-1	LOWER SHEAR, LEFT	262	
-	1	1	9-240641-0	SPACER	261	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-4	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	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1-22281-6	SPRING, COMPRESSION	121	
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1803310-1	STRIP GUIDE, FRONT	96	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	2168083-7	SCR, SKT HD CAP, RoHS, M3 X 30	93	
-	1	1	1-455888-0	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	
-	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	1338683-9	FEED PAWL	56	
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	53	
-	1	1	1-2119830-3	HOLDER, SLUG BLADE	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	1803309-2	PLATE, STRIP GUIDE	29	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	3-690754-8	DRAG, SPECIAL	25	
-	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	
-	5	5	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	-	-	-	-	10	
-	-	-	-	-	9	
-	1	2	1	1803316-1	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	1	1	1	6-690518-4	HOLD DOWN, TERMINAL	6
-	-	-	-	-	5	
-	1	1	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	1	1-1633966-1	CRIMPER, INSULATION O	3
-	1	1	1	1-455888-3	SPACER, CRIMPER	2
-	1	2	1	3-456411-0	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC	±					
	1 PLC	±					
	2 PLC	±					
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
	FINISH						

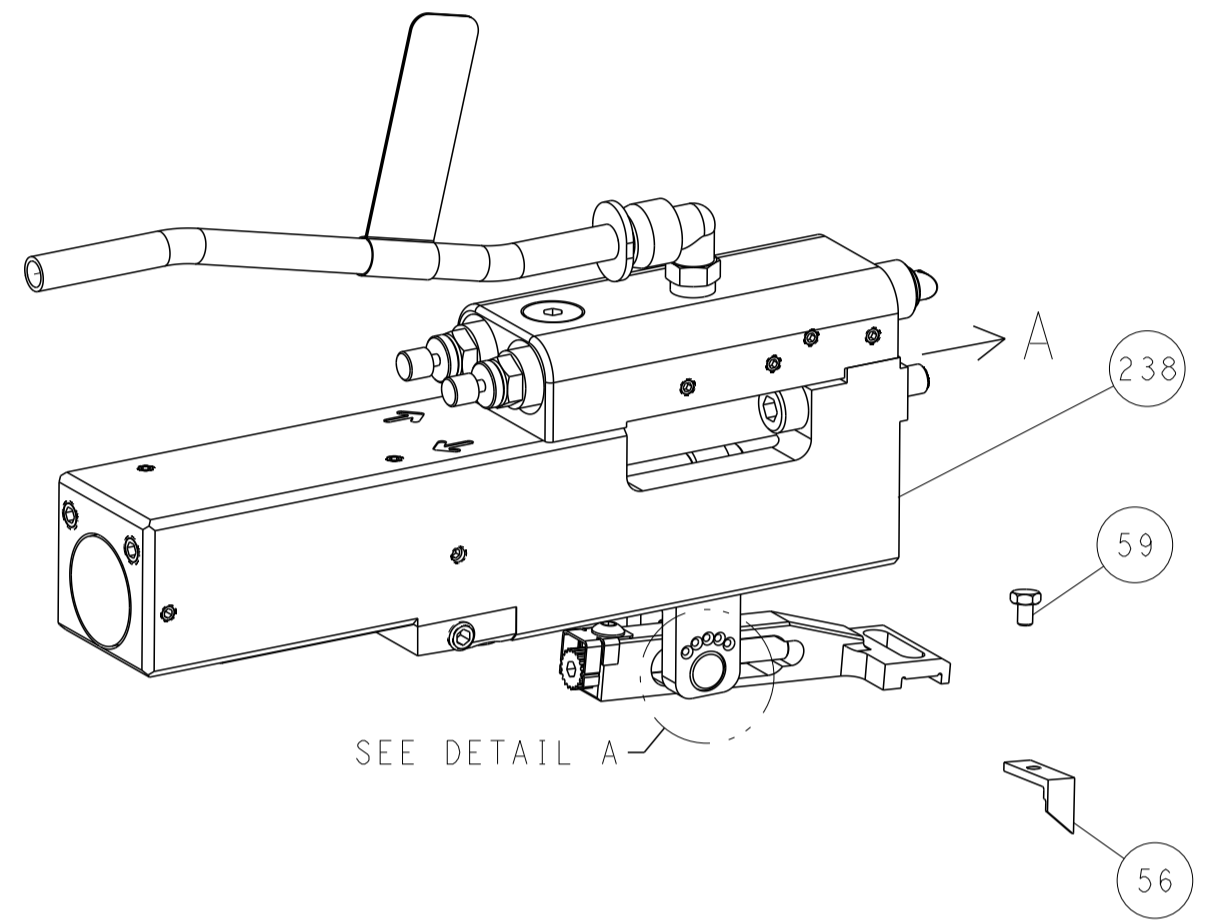
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R. KNEPPER	G. BAILEY	T. ELBIN	21-Oct-15		A1	00779	2151316	

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

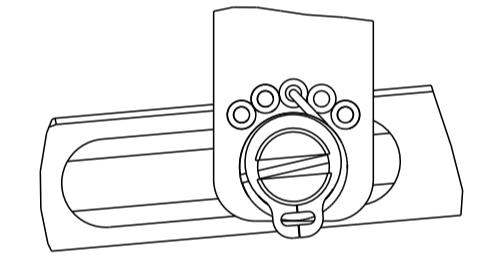
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

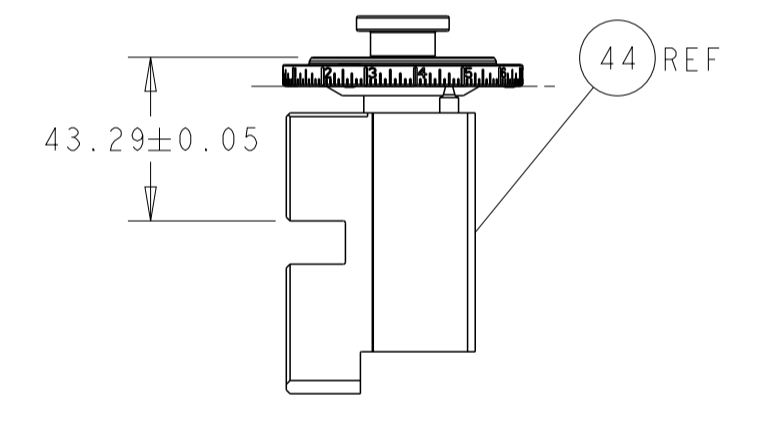
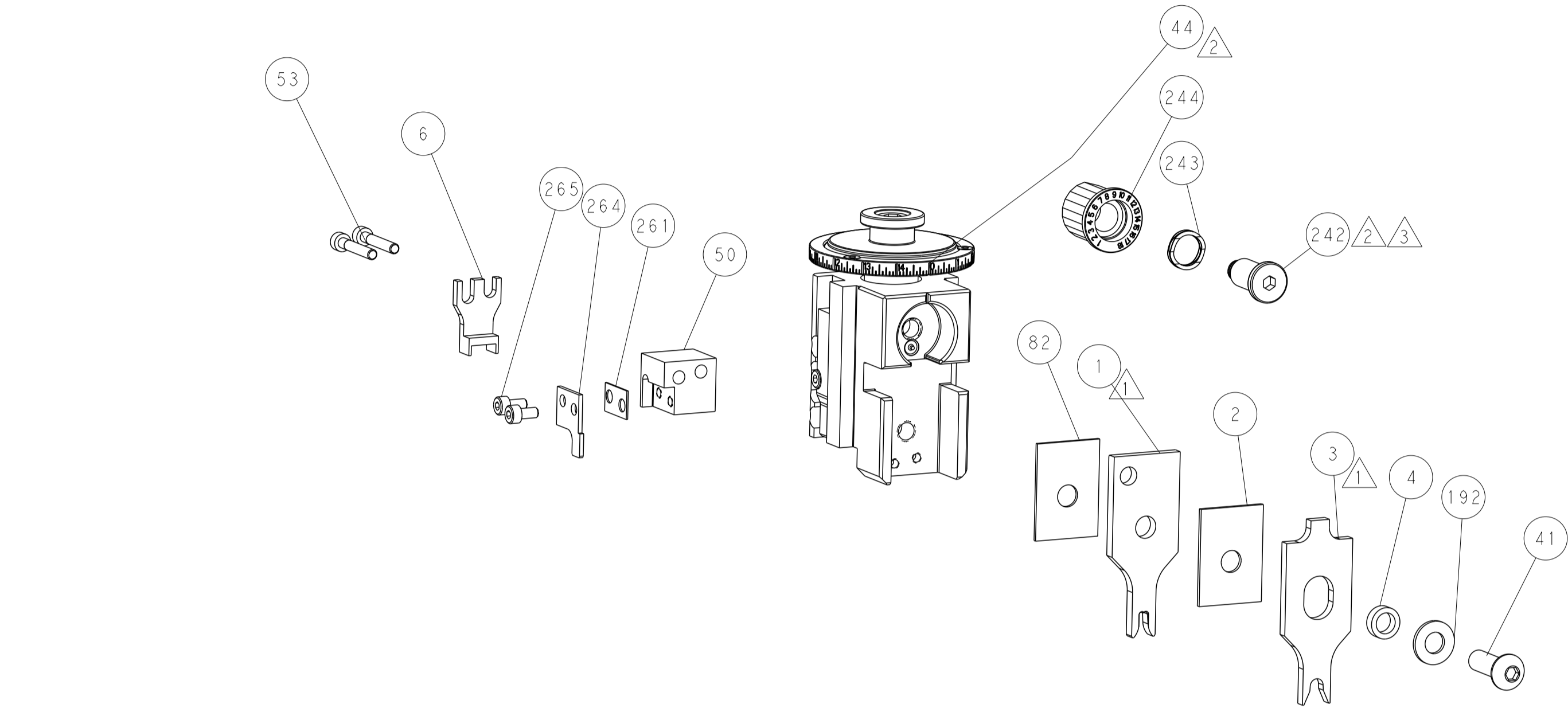
PNEUMATIC



FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

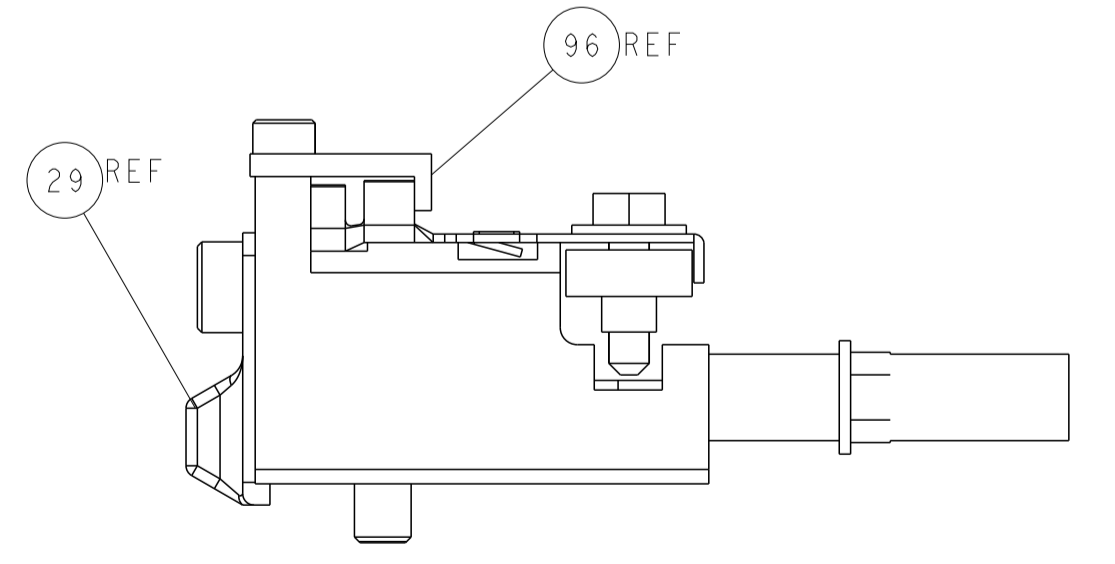
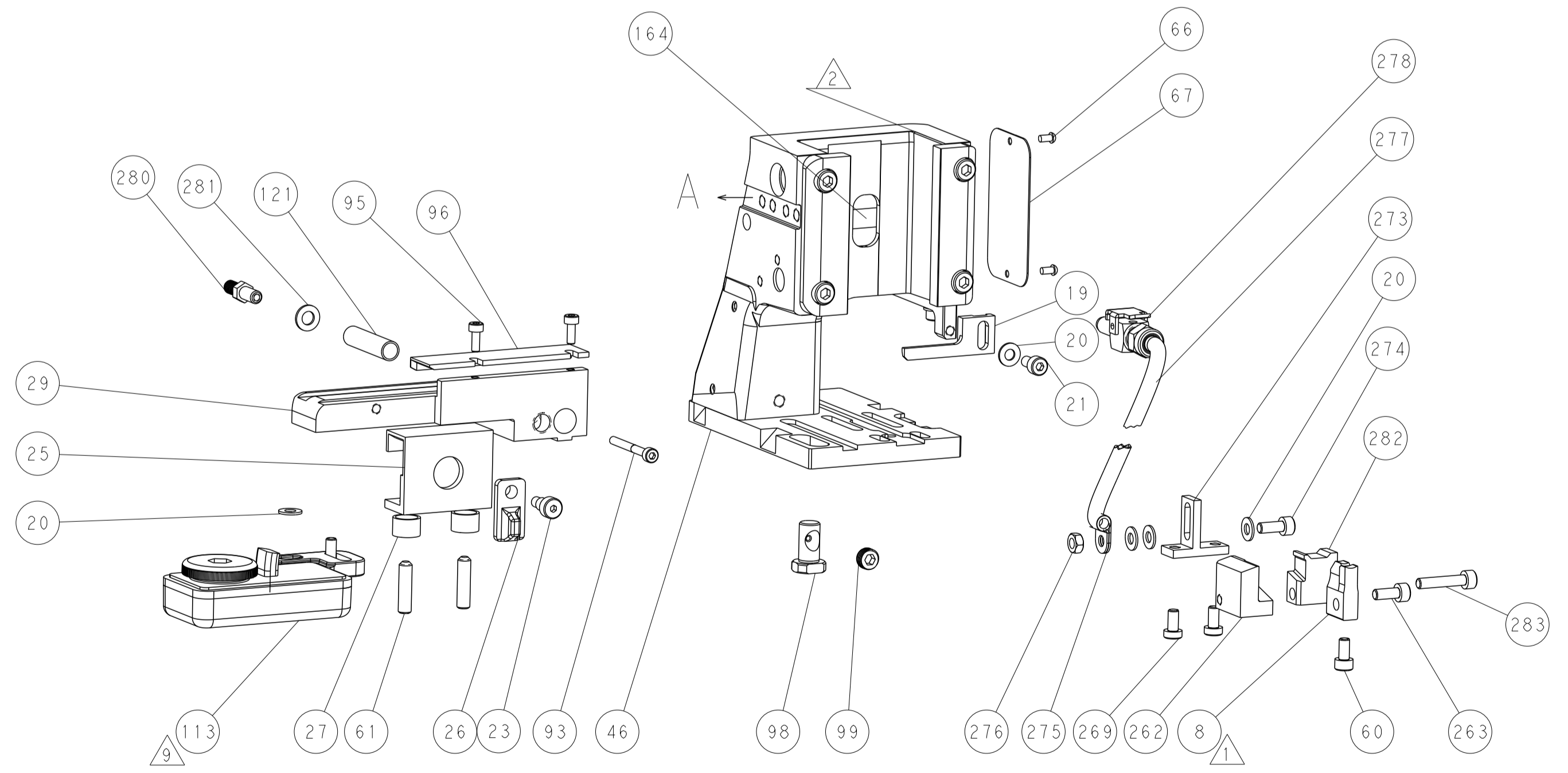
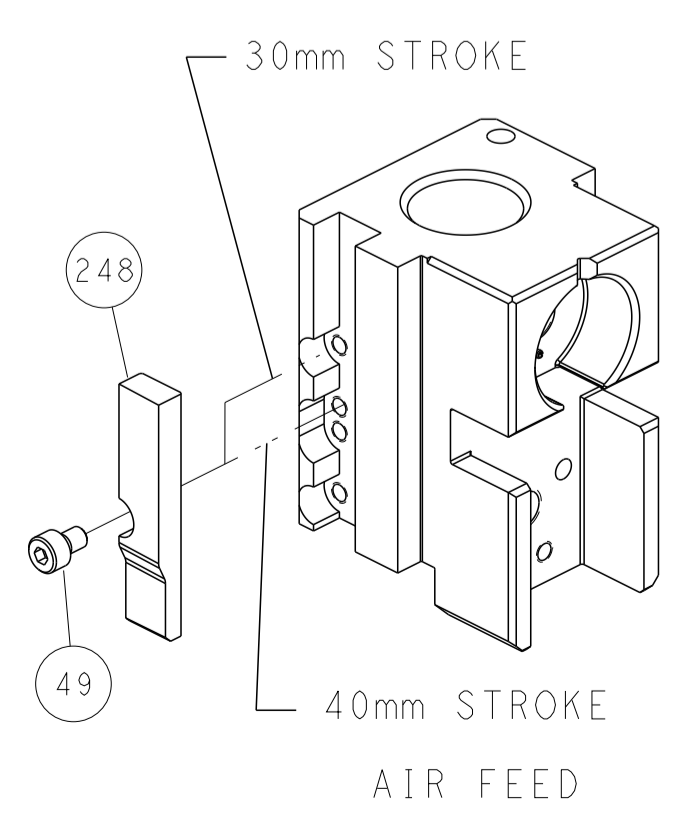


DETAIL A



RAM SET-UP

CAM POSITION



FEED TRACK POSITION
GUIDE BY WIRE BARREL

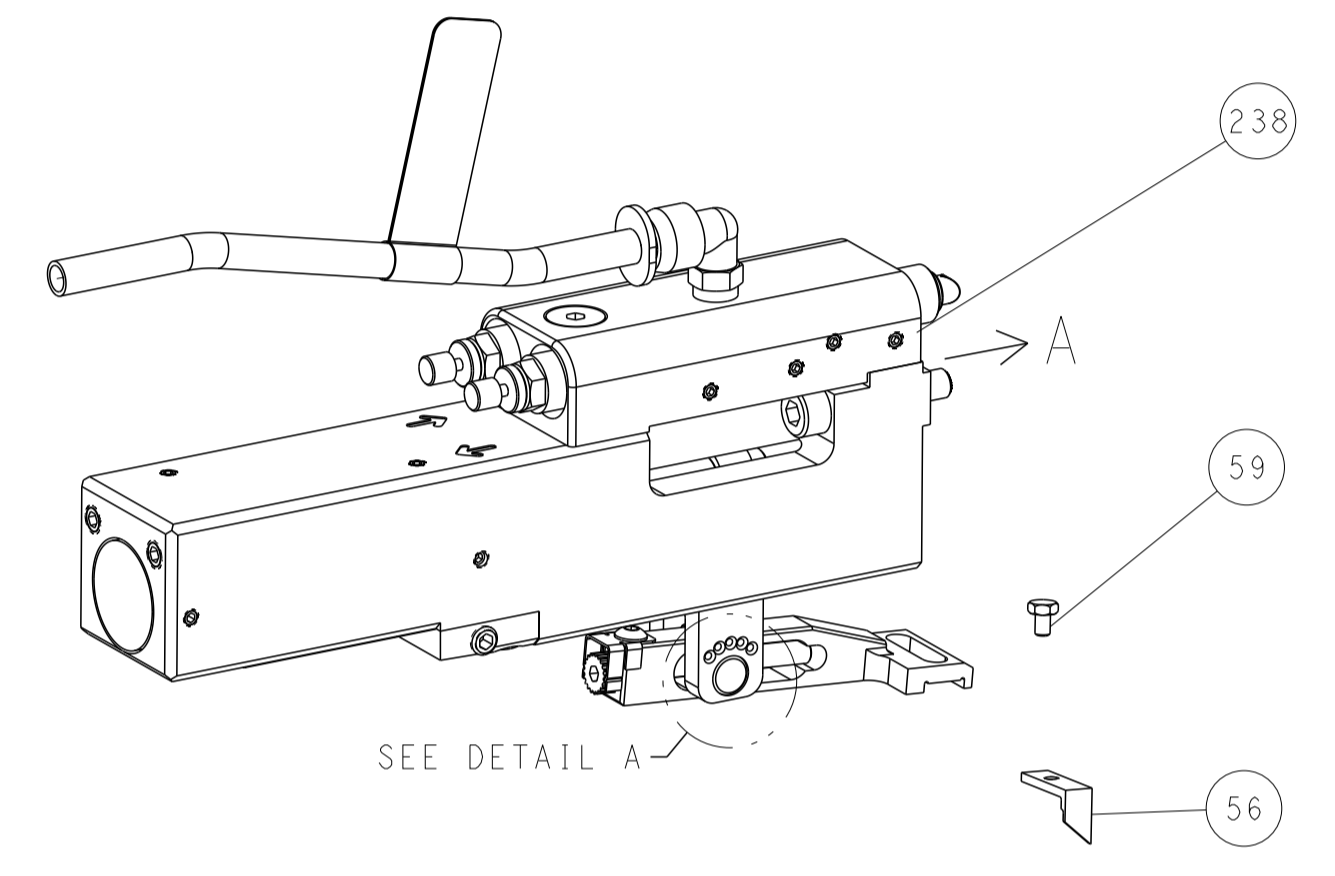
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:2 SHEET: 2 OF 4 REV: E	TE Connectivity Harrisburg, PA 17105-3608	Customer Accessible Production Drawing

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

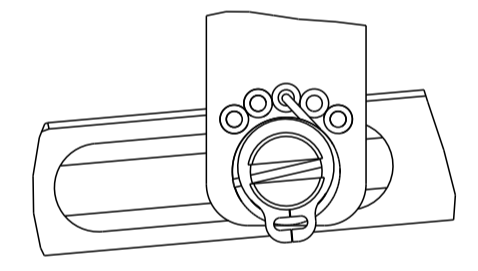
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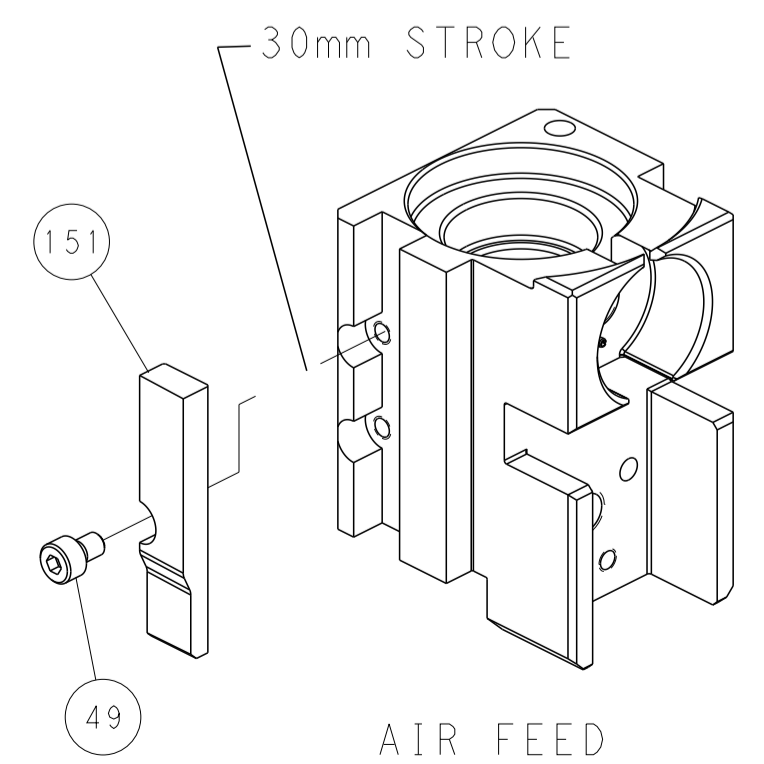
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

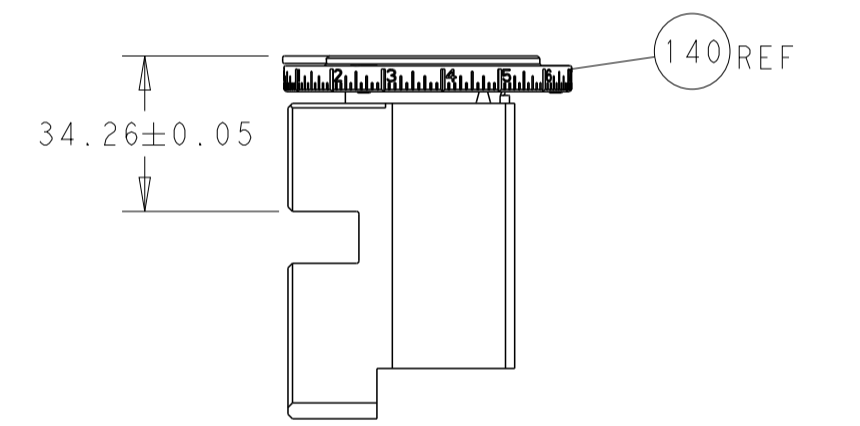
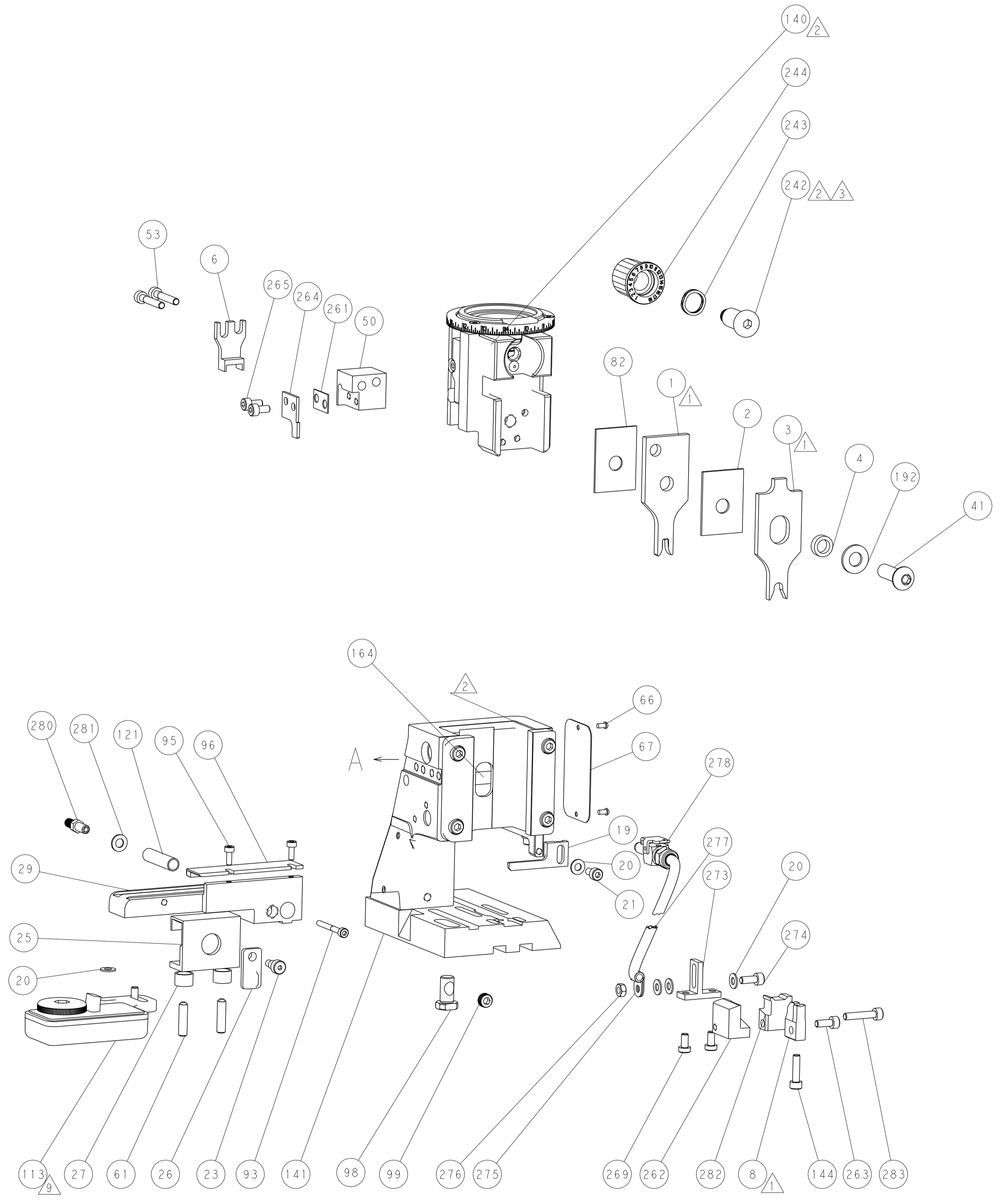


DETAIL A

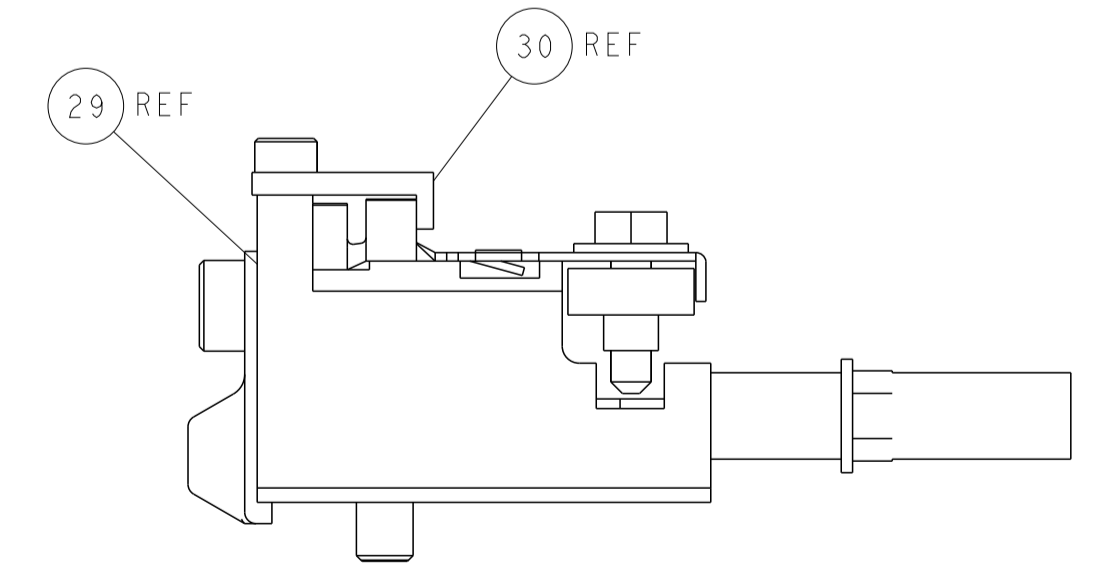
CAM POSITION



AIR FEED



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151316 SHEET 4 OF 4	RESTRICTED TO: - REV: E