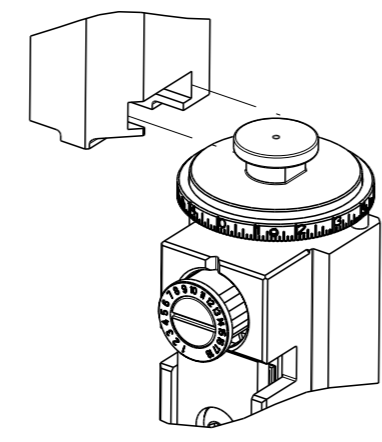


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151697-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151697-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151697-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151697-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151697-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.32 mm [.170]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.5 MM SYST., CONTACT PIN/SOCKET			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.20-5.80 mm [.205-.228 IN]		Ø 3.40 mm MAX [.134 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-18031-1		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
928987-2	928985-2		828921-1	2.1-3.0
928987-3	928985-4			
928987-4	928985-5			
928987-5				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.81+/-0.05 [0.071+/-0.002]	7.4
2.00mm2	1.71+/-0.05 [0.067+/-0.002]	8.5
1.50mm2	1.57+/-0.05 [0.062+/-0.002]	9.9

- 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.
- 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.
- WHEN USING TERMINAL 928985 USE ITEM 264 DIMENSION 7.62 (.300) WHEN USING TERMINAL 928987 USE ITEM 34 DIMENSION 12.70 (.500)

**\*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	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	C		ECR-19-011443	20JUL2019	TB	TE
		D		ECR-19-012953	16AUG2019	TB	RK
		E		ECR-19-019592	17DEC2019	FJ	RK
		E1		ECR-20-015910	09NOV2020	JWC	GB

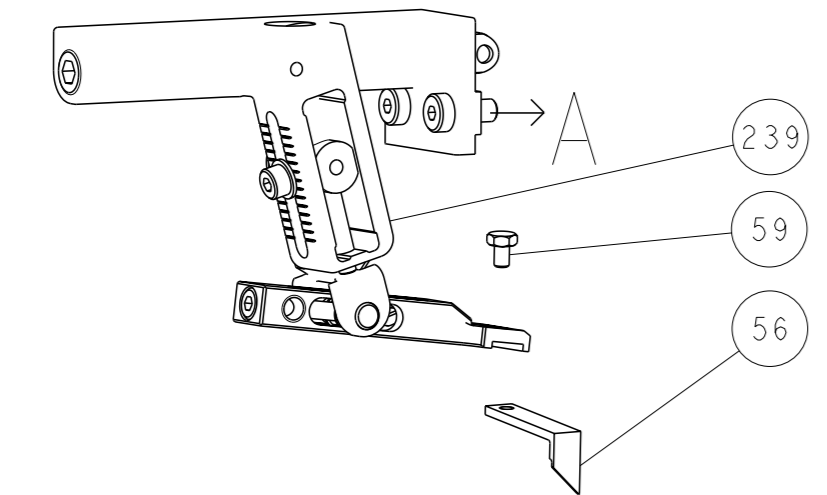
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	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	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
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1	1	1338683-8	FEED PAWL	56
	-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
	-	1	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	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1-455888-5	SPACER, CRIMPER	28
	-	1	1	1	1	1320928-6	STRIP GUIDE	24
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
	1	2	2	1	1	3-1333207-4	ANVIL, COMBINATION .110	8
	-	1	1	1	1	6-240641-4	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	4-1633965-2	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-8	SPACER, CRIMPER	2
	1	2	2	1	1	3-456408-9	CRIMPER, WIRE PREMIUM	1

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

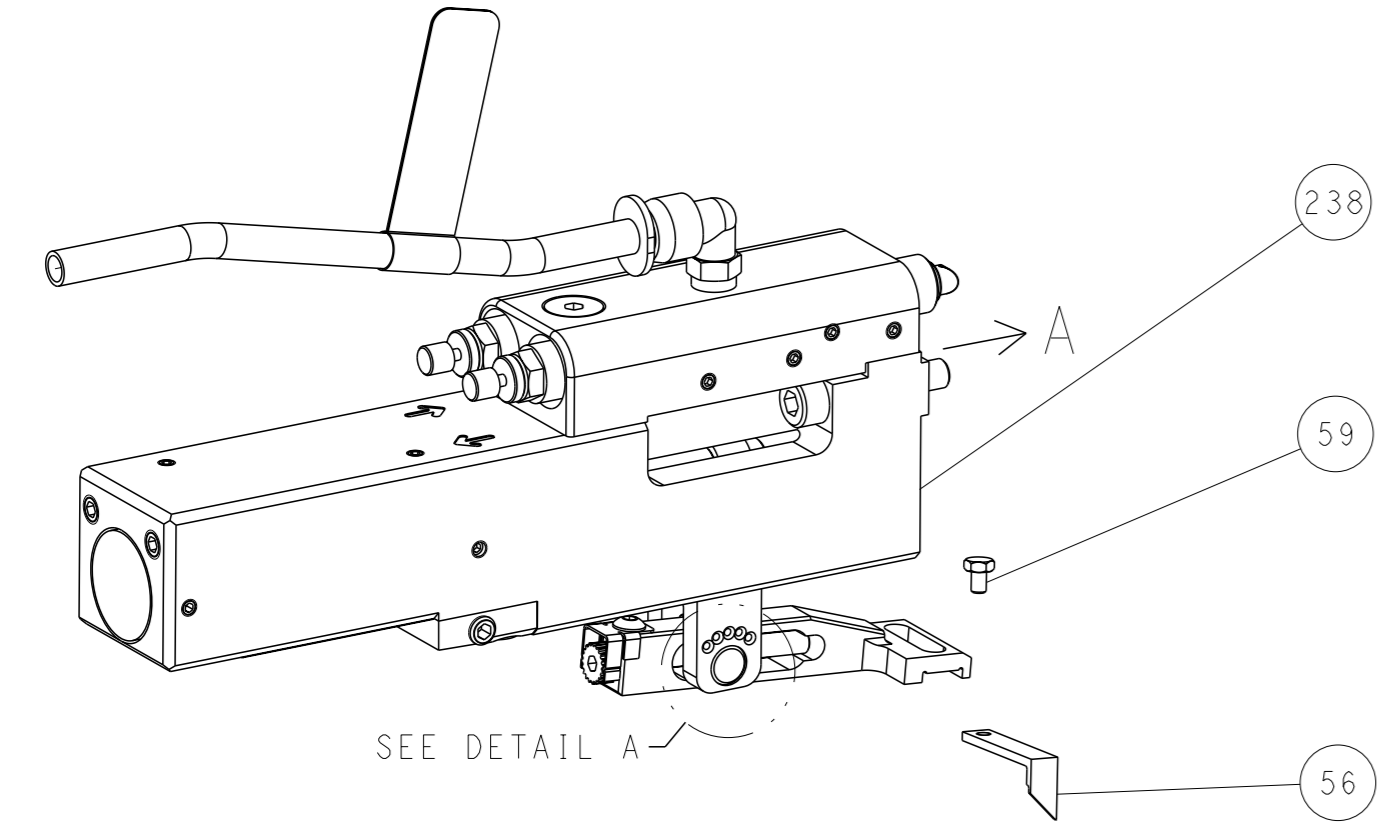
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	3 PLC ±	4 PLC ±	ANGLES ±	L. ZHANG	L. ZHANG	31 JUL 2012	APPLICATOR INSTRUCTIONS 408-35042	
MATERIAL	FINISH	WEIGHT	SCALE	CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	SHEET	REV
			1:2	A1		00779	1	E1

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

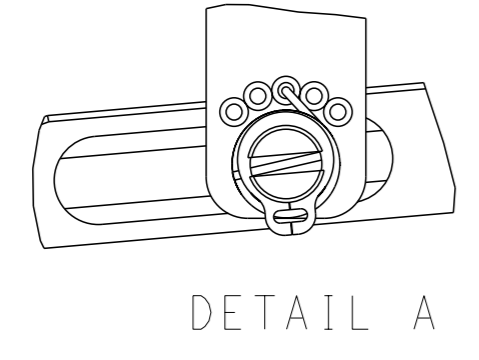
# FEED TYPE MECHANICAL



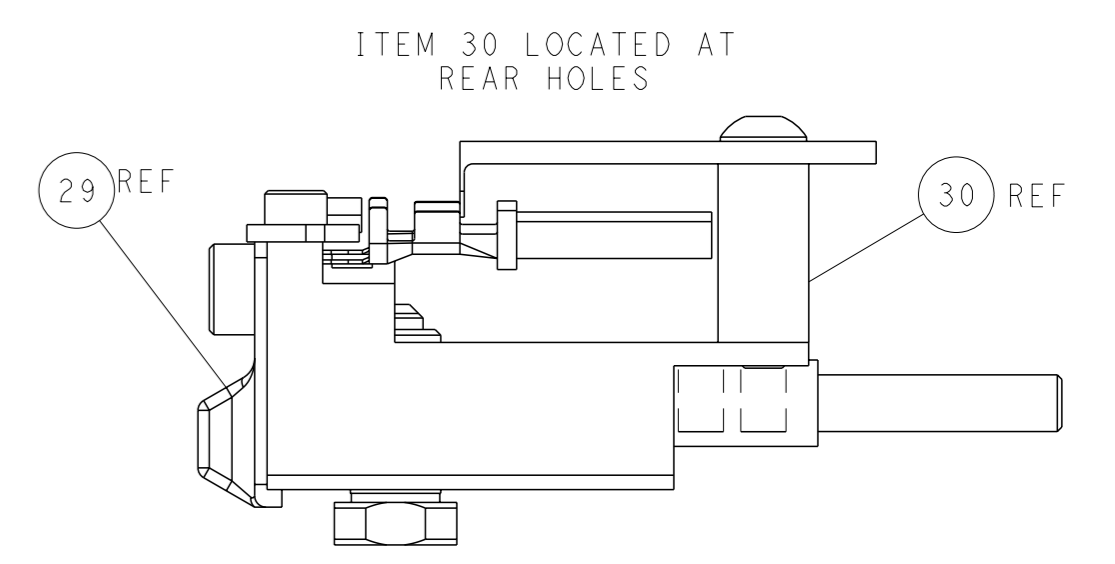
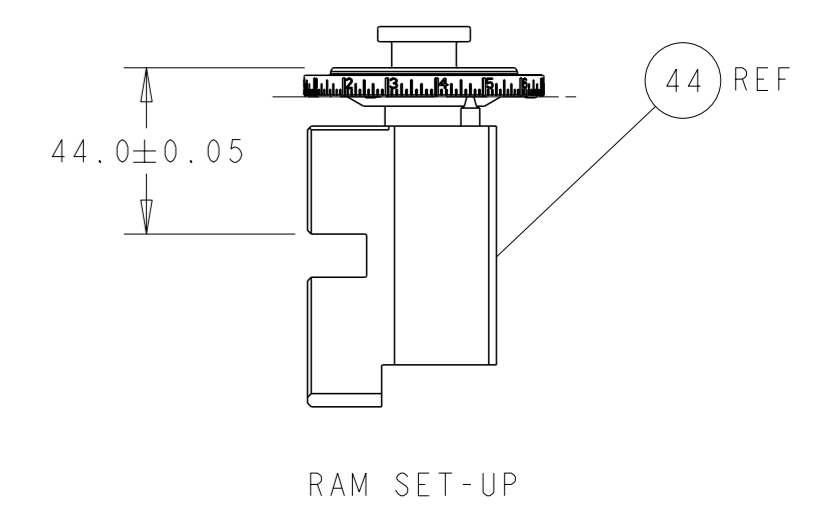
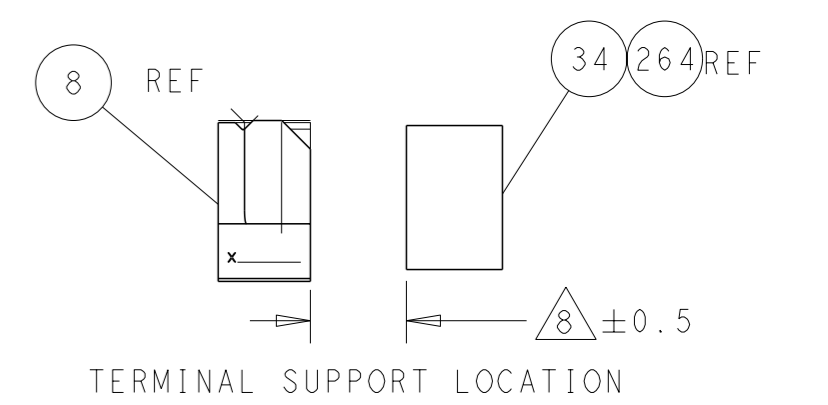
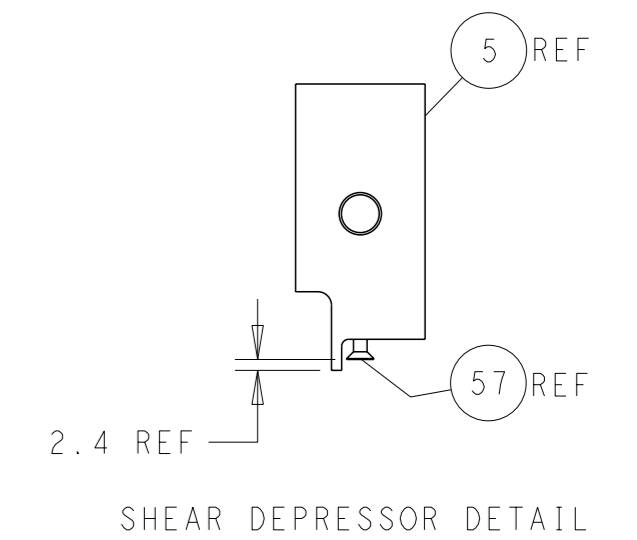
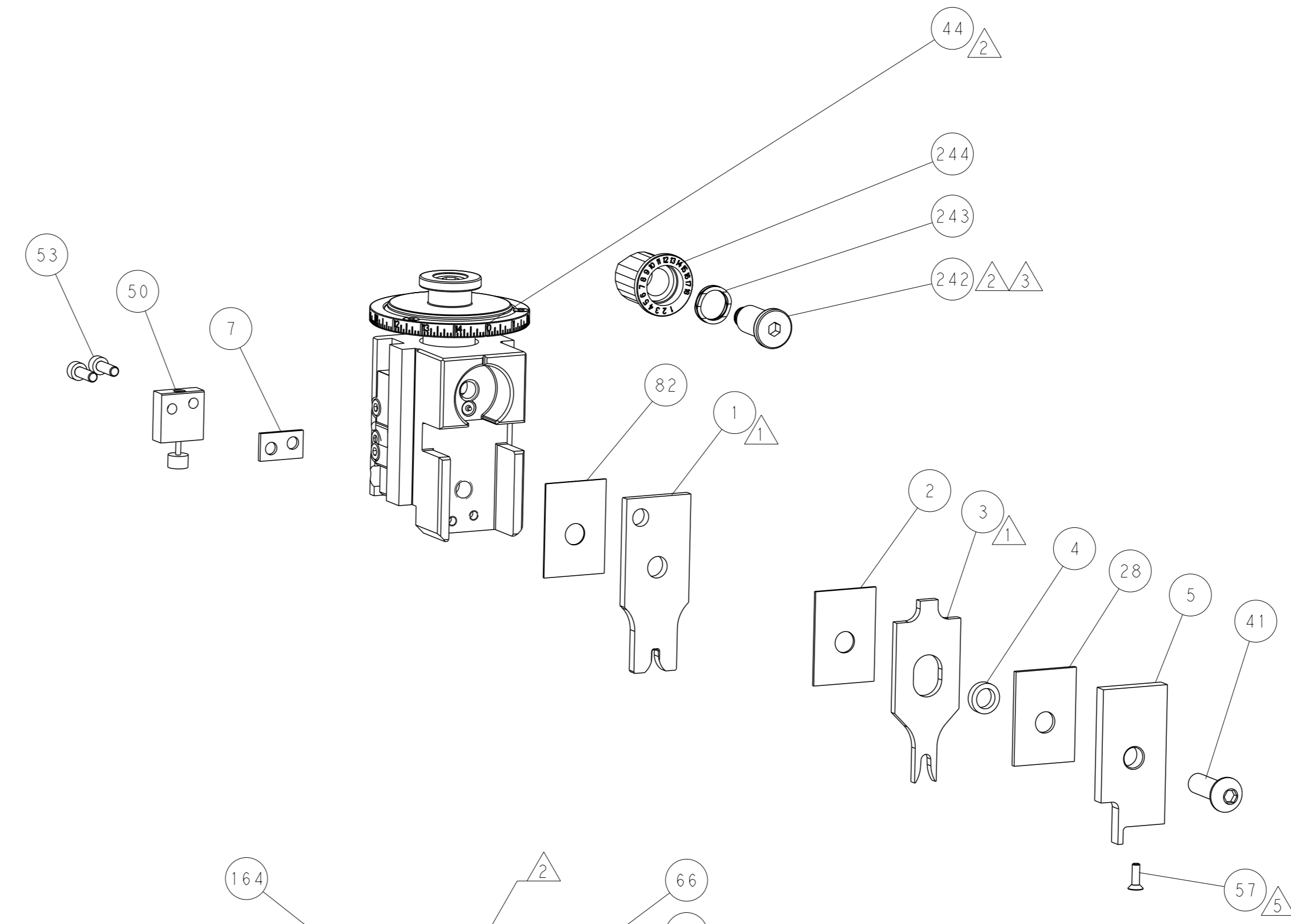
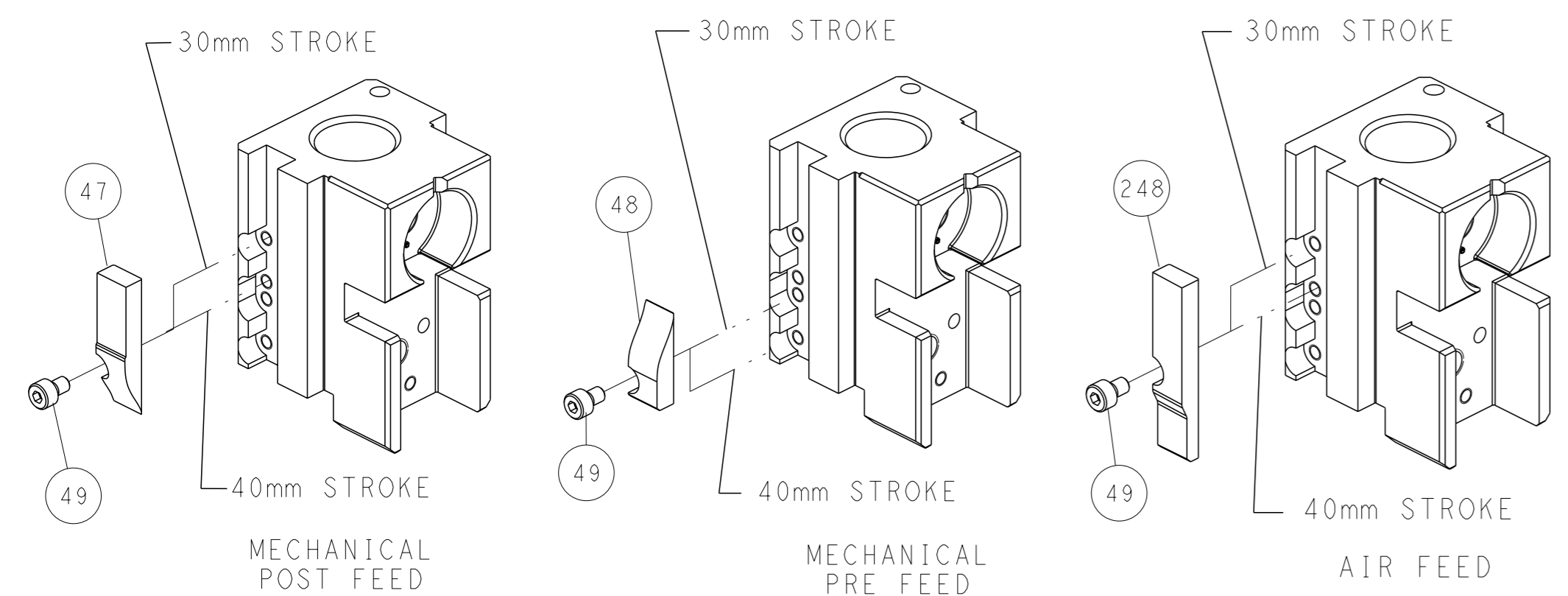
## PNEUMATIC



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



# CAM POSITIONS

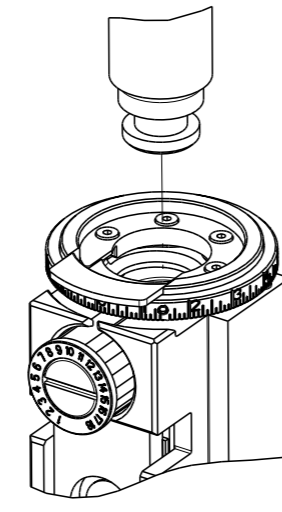


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: L. ZHANG 31 JUL 2012 CHK: L. ZHANG 31 JUL 2012 APVD: S. XI 31 JUL 2012	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: 2151697 WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: E1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151697-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151697-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151697-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	4.32 mm (.170)	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.5 MM SYST., CONTACT PIN/SOCKET			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.20-5.80 mm (.205-.228 IN)		Ø 3.40 mm MAX (.134 IN MAX)	
TERMINAL APPLICATION SPECIFICATION	114-18031-1	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
928987-2	928985-2		828921-1	2.1-3.0
928987-3	928985-4			
928987-4	928985-5			
928987-5				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.81+/-0.05 [0.071+/-0.002]	7.4
2.00mm2	1.71+/-0.05 [0.067+/-0.002]	8.5
1.50mm2	1.57+/-0.05 [0.062+/-0.002]	9.9

- 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.
- 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.
- WHEN USING TERMINAL 928985 USE ITEM 264 DIMENSION 7.62 (.300) WHEN USING TERMINAL 928987 USE ITEM 34 DIMENSION 12.70 (.500)

**\*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			

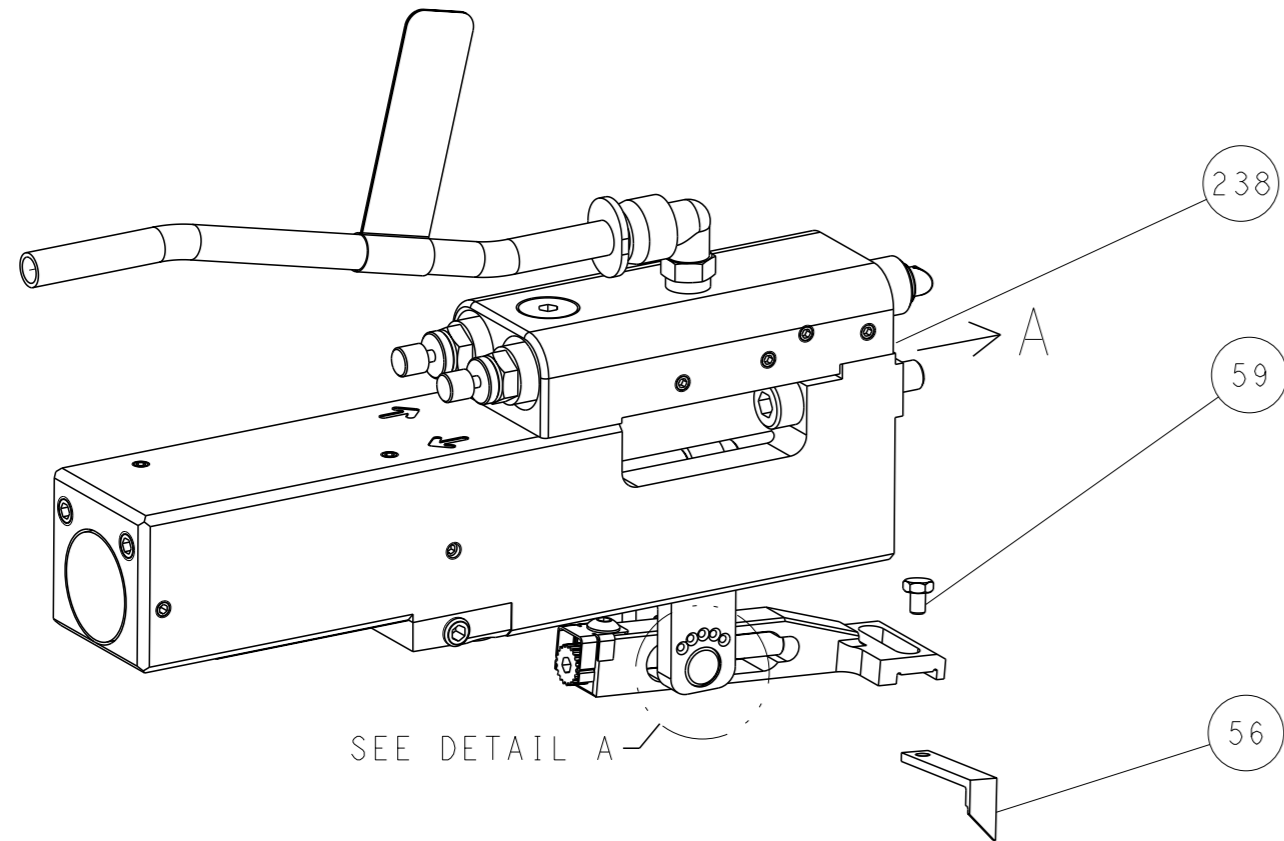
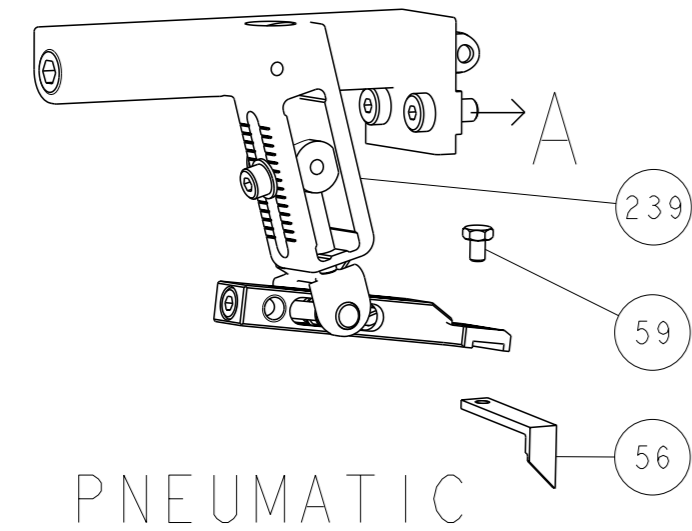
8	-	1	1	1752356-4	SUPPORT, TERMINAL	264
	-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-1	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	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
7	-	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	455888-5	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
5	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1338683-8	FEED PAWL	56
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
8	-	1	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1-455888-5	SPACER, CRIMPER	28
	-	1	1	1320928-6	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	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	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	3-1333207-4	ANVIL, COMBINATION .110	8
	-	1	1	6-240641-4	SPACER	7
	-	-	-	-	-	6
	-	1	1	2119781-5	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1	4-1633965-2	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-8	SPACER, CRIMPER	2
1	1	1	1	3-456408-9	CRIMPER, WIRE PREMIUM	1

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

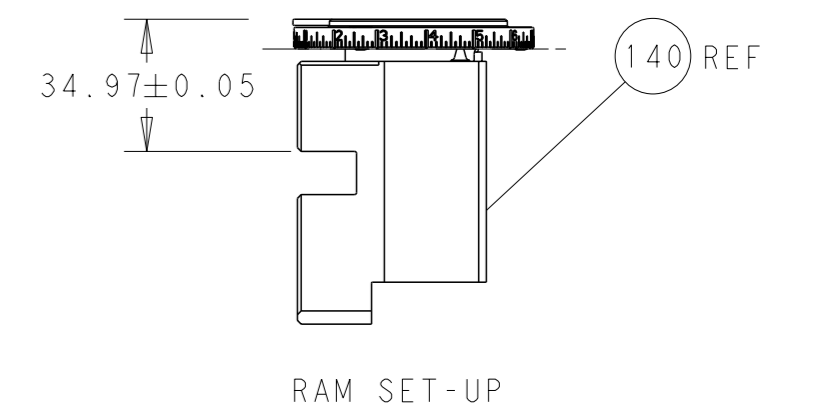
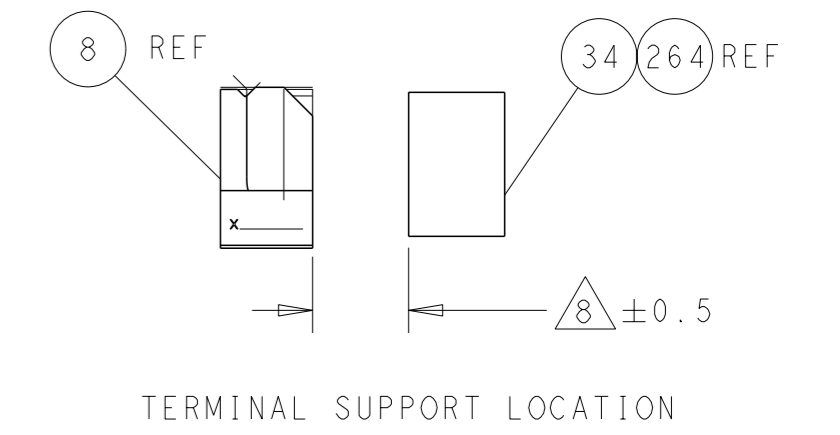
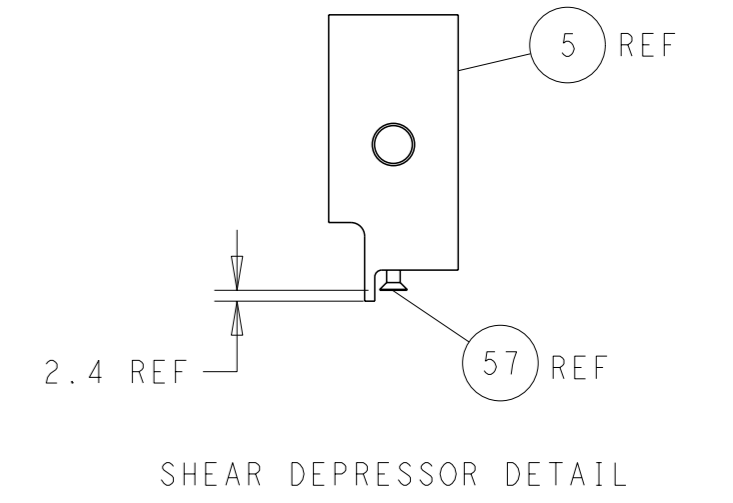
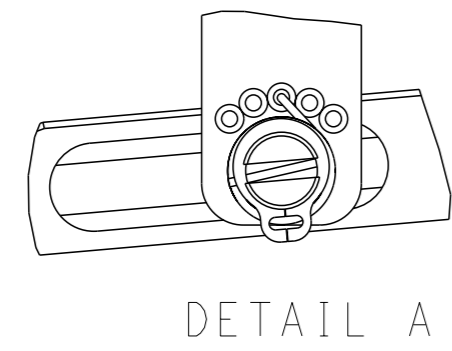
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	ANGLES	FINISH					
MATERIAL				WEIGHT		SCALE	SHEET
						1:2	3 of 4

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

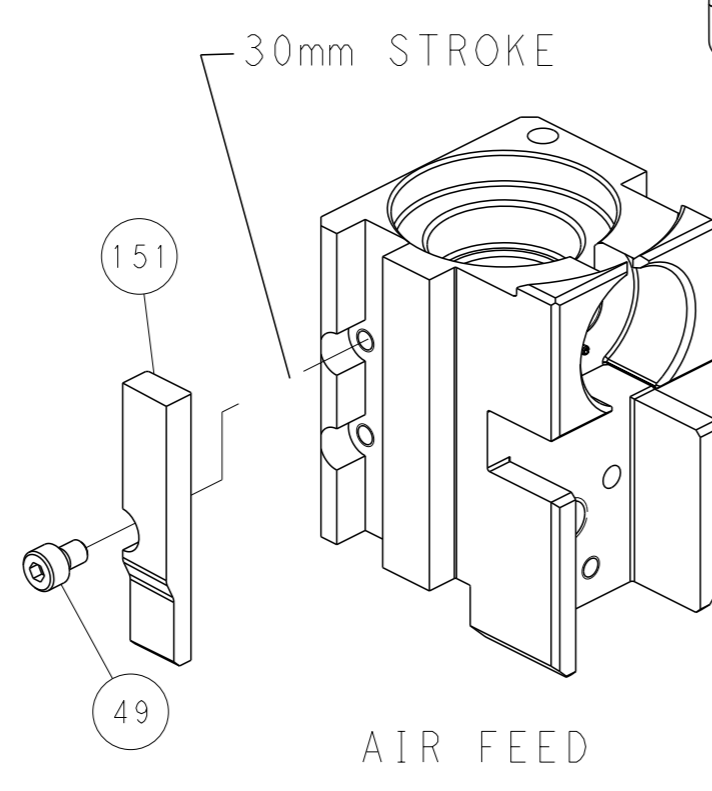
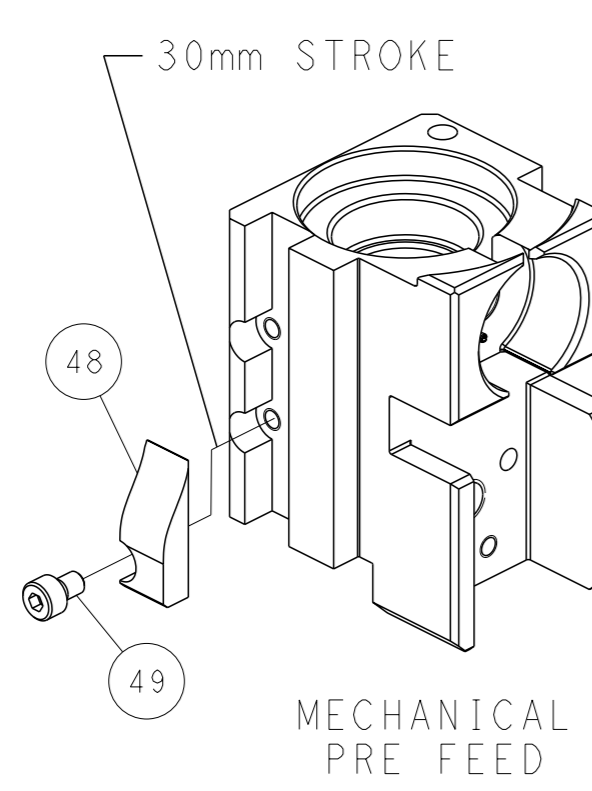
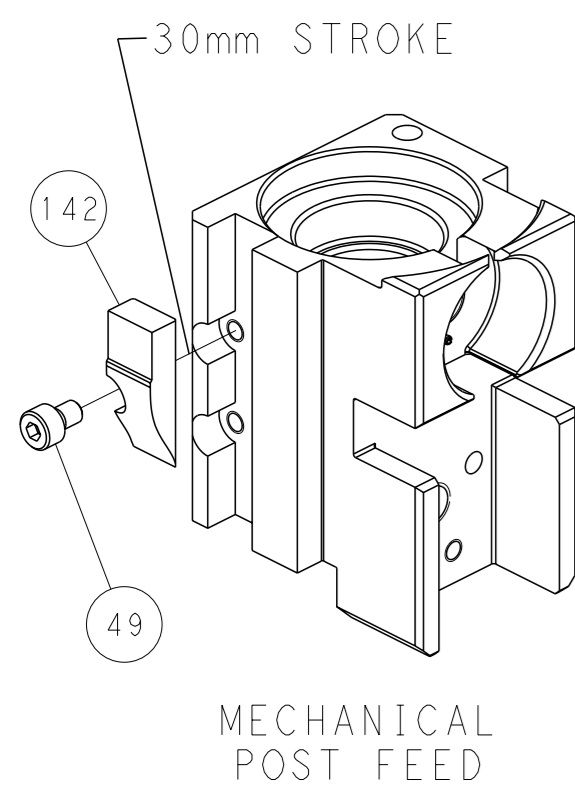
# FEED TYPE MECHANICAL



FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



# CAM POSITIONS



**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 CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN L. ZHANG 31 JUL 2012 CHK L. ZHANG 31 JUL 2012 APVD S. XI 31 JUL 2012	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 APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2151697 WEIGHT CUSTOMER ACCESSIBLE PRODUCTION DRAWING	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV E1