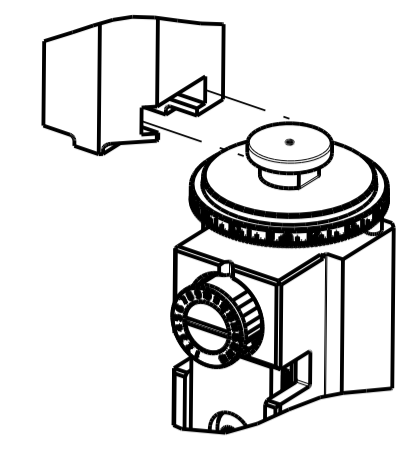


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151322-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151322-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151322-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151322-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151322-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	5.84 mm [.230]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DIA 4MM SOCKET CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.30 mm [.185-.209 IN]		Ø1.00-4.00 mm [.039-.157 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
962952-1	962952-2	963243-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.60 +/- 0.05 [.063 +/- .002]	8.3
0.75mm2	1.52 +/- 0.05 [.060 +/- .002]	9.3
0.50mm2	1.40 +/- 0.05 [.055 +/- .002]	10.5

- 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 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.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

***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	CHK
		A	RELEASED	31JAN2012	LG GB
		B	ECR-19-000981	21JAN2019	MZ CT
		C	ECR-21-003294	17MAR2021	FJ TE
		D	ECR-21-005578	19MAY2021	FZ RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	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	18023-1	SCR, SKT HD CAP M3 X 5.0	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	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	1-2119791-6	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	1-1752356-7	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	2844992-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-5	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	2	2	2	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	3-1633711-9	ANVIL, COMBINATION	8
-	1	1	1	1	240641-4	SPACER	7	
-	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5	
-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1803018-2	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-8	SPACER, CRIMPER	2	
-	1	2	2	1	1	1-456404-8	CRIMPER, WIRE PREMIUM	1

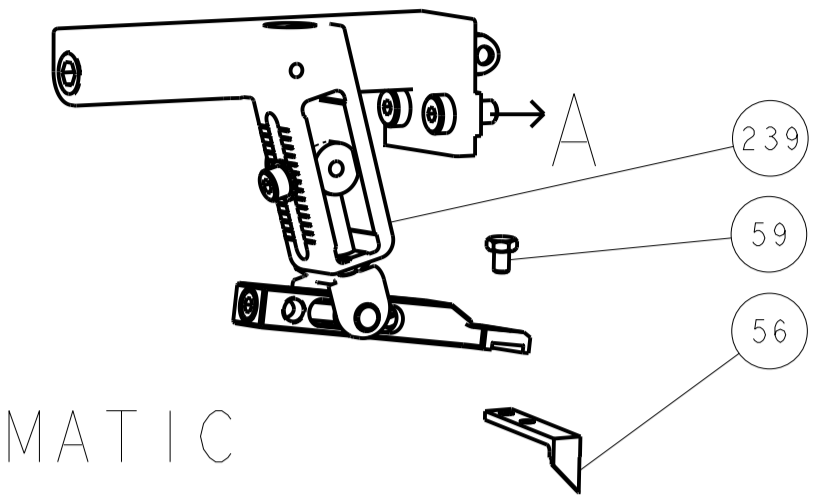
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

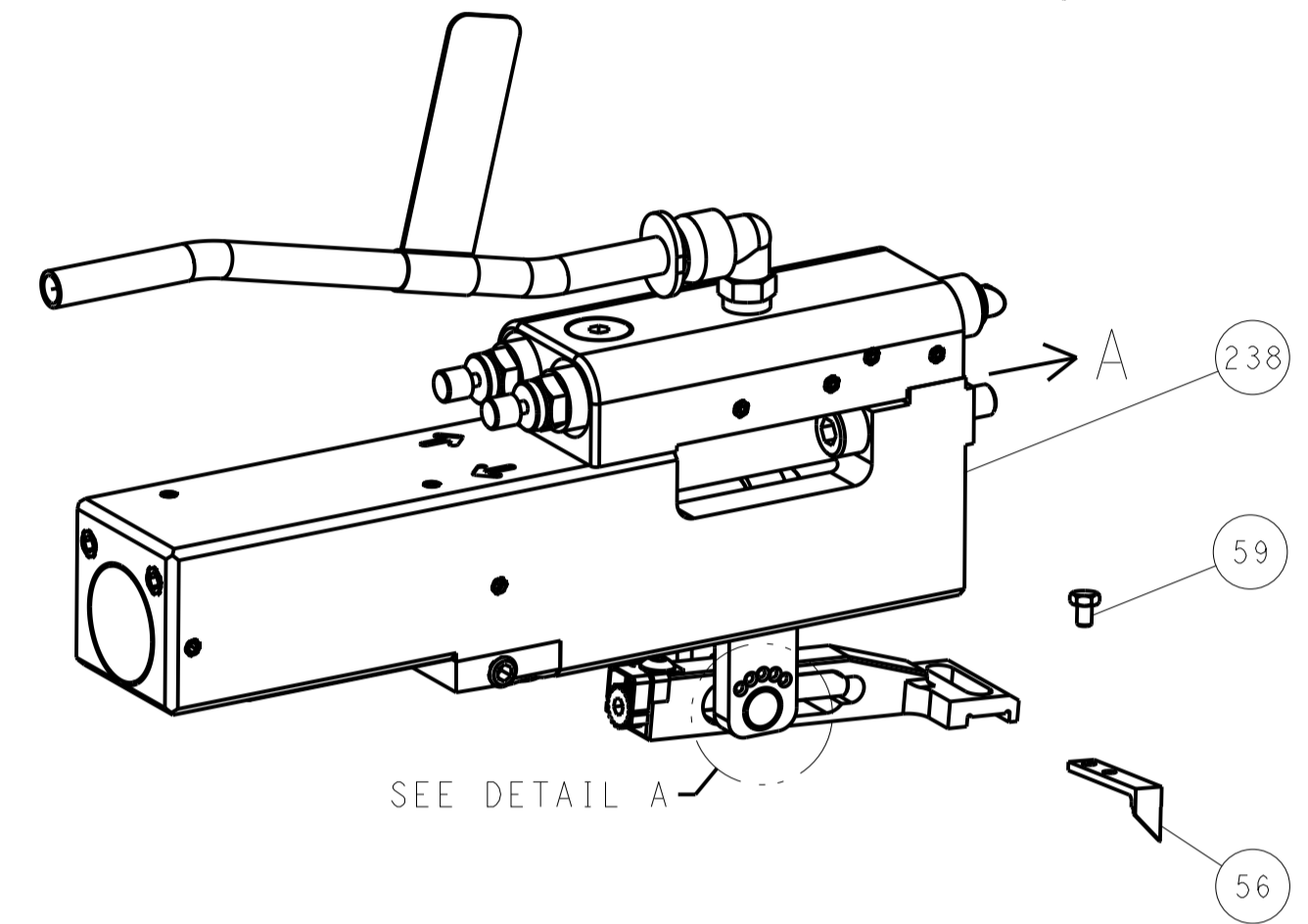
OWN	Y. YIN	30SEP2011
CHK	G. BAILEY	29SEP2011
APVD	S. XI	29SEP2011
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151322
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		
SCALE	1:2	SHEET 1 OF 4
REV	D	

LOC	DIST	REV	DATE	BY	CHK	APP'D
A	66					

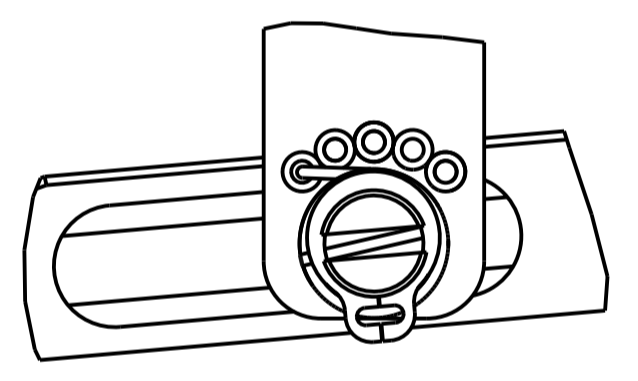
FEED TYPE MECHANICAL



PNEUMATIC

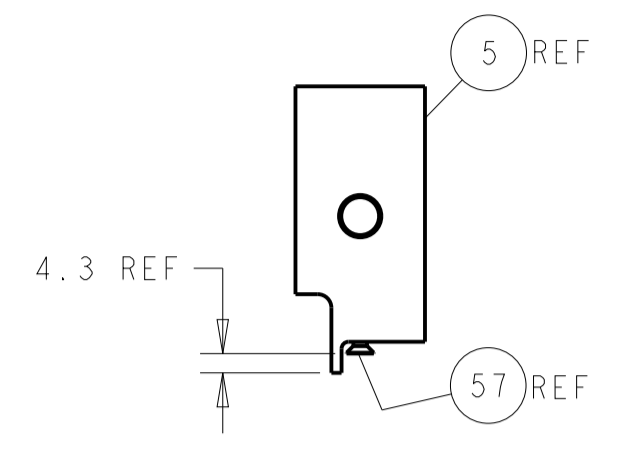
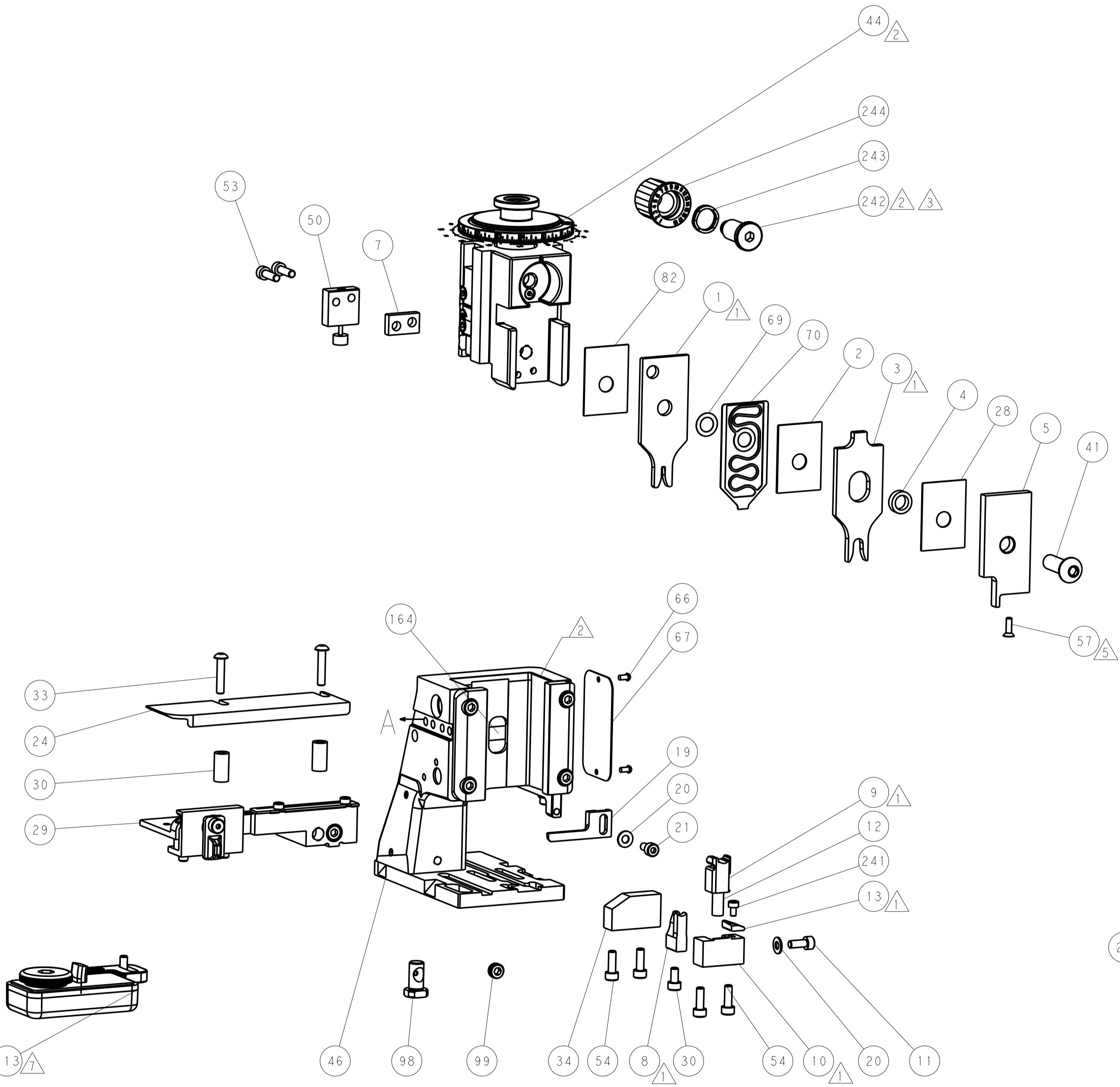
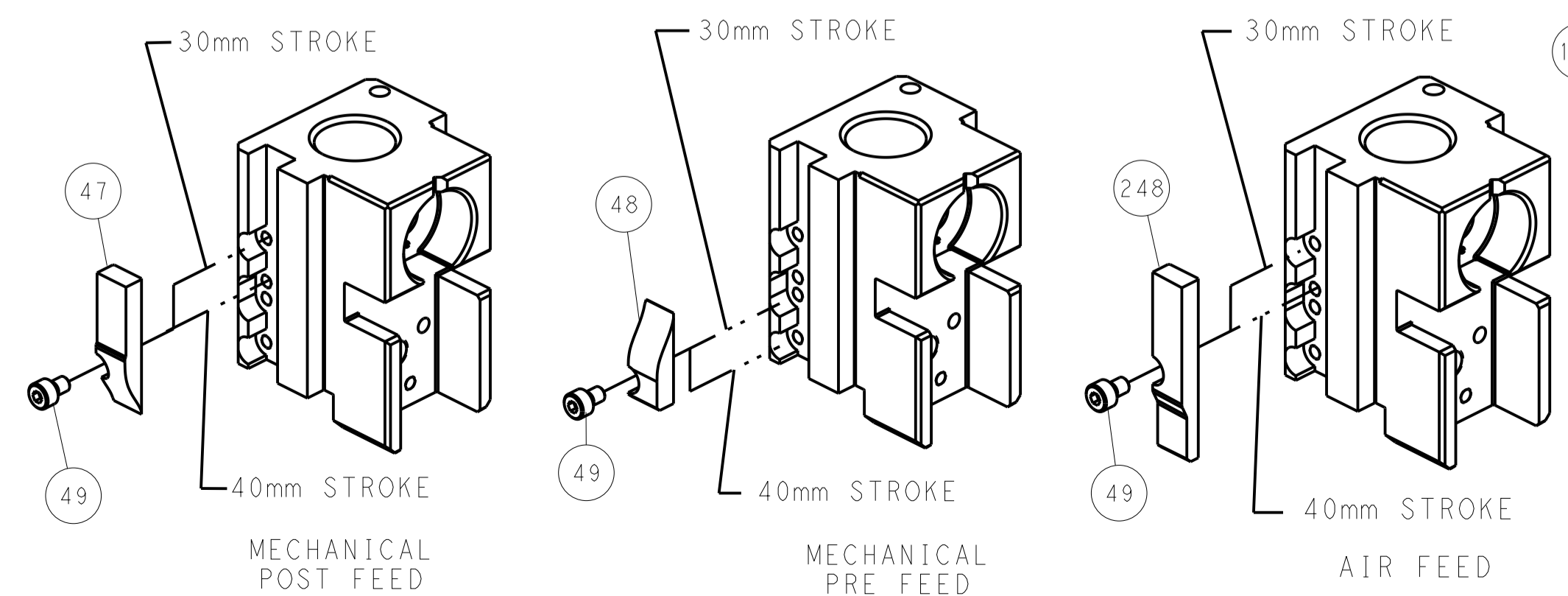


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

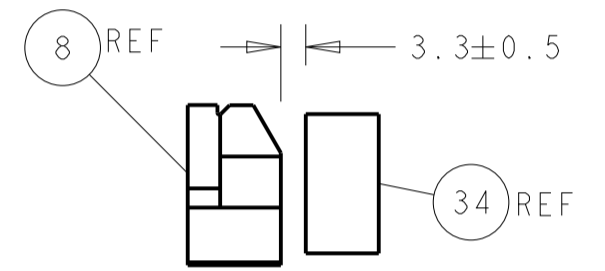


DETAIL A

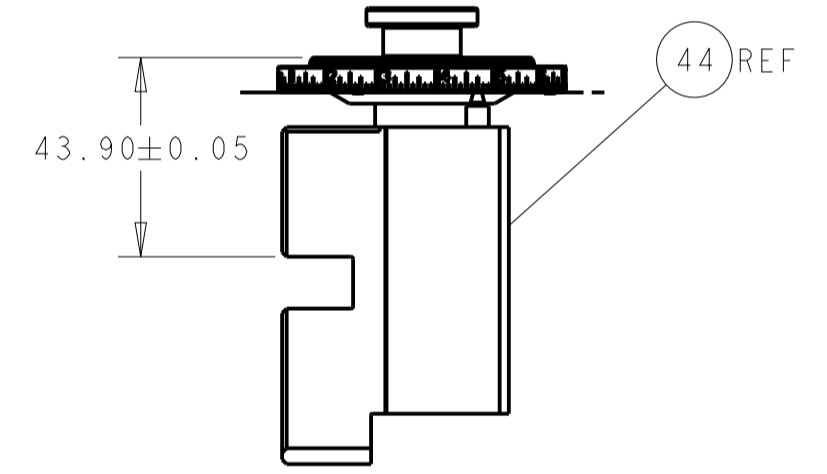
CAM POSITIONS



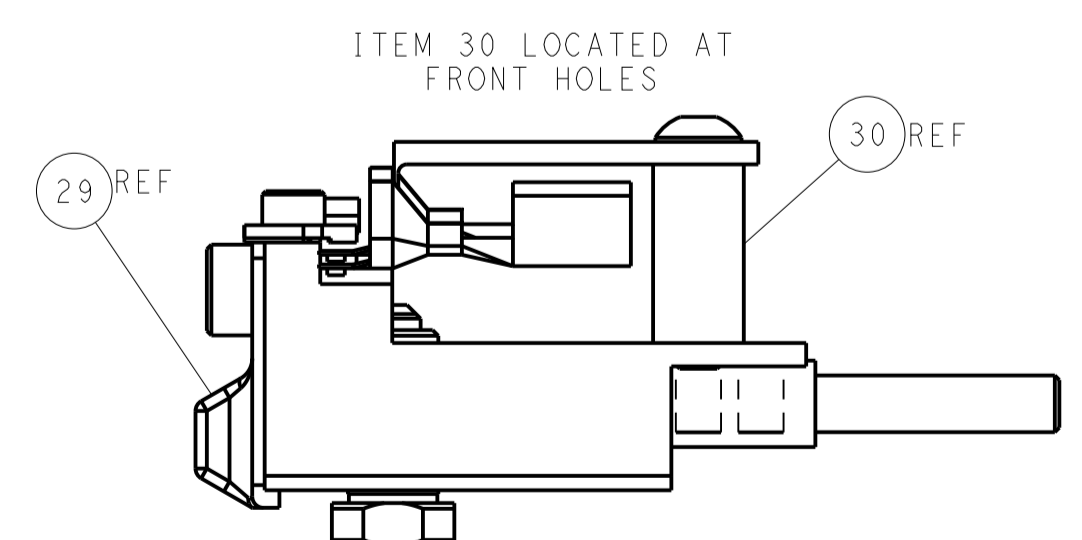
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



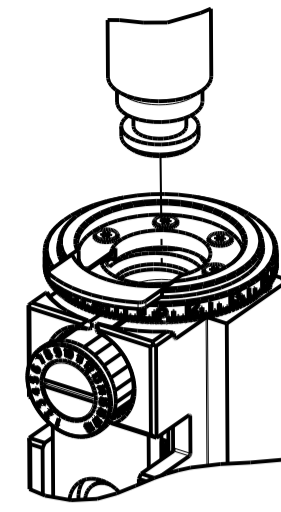
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 30SEP2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: G. BAILEY 29SEP2011		NAME: Ocean Side Feed Applicator	
				APVD: S. XI 29SEP2011		PRODUCT SPEC:	
				APVD: S. XI 29SEP2011		APPLICATION SPEC:	
				APVD: S. XI 29SEP2011		SIZE: CAGE CODE: DRAWING NO:	
				APVD: S. XI 29SEP2011		RESTRICTED TO:	
				APVD: S. XI 29SEP2011		A1 00779 ©=2151322	
				APVD: S. XI 29SEP2011		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
				APVD: S. XI 29SEP2011		SCALE: 1:2 SHEET 2 OF 4 REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151322-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151322-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151322-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



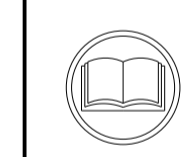
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	5.84 mm [.230]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DIA 4MM SOCKET CONTACT			
WIRE STRIP LENGTH 4.70-5.30 mm [1.85-.209 IN]		INSULATION DIAMETER RANGE Ø1.00-4.00 mm [.039-.157 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	Ø1.4-2.1mm
962952-1	962952-2	963243-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.60+/-0.05 [1.063+/-0.002]	8.3
0.75mm ²	1.52+/-0.05 [1.060+/-0.002]	9.3
0.50mm ²	1.40+/-0.05 [1.055+/-0.002]	10.5



- 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 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.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

***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.

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

LOC	DIST	REV	DATE	BY	APPV
A	66				

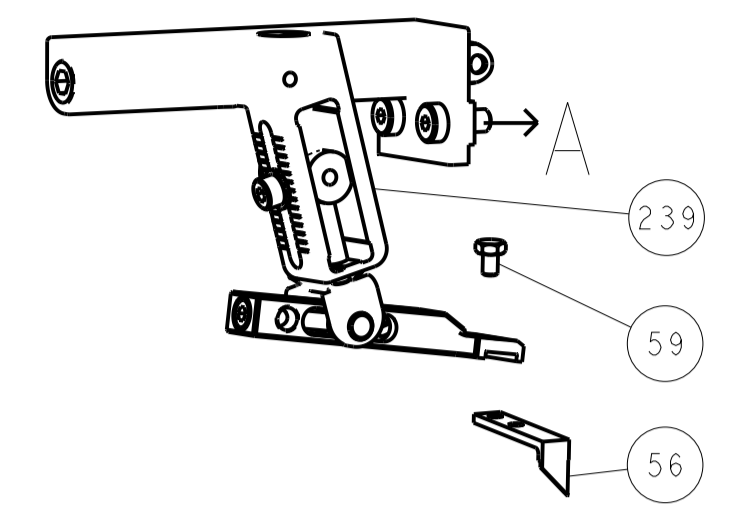
REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1 1	2119082-4			244
-	1 1	2079764-1			243
-	1 1	2119083-1			242
-	1 1	18023-1			239
-	- 1	2119580-1			231
-	1 -	2844940-1			238
-	REF REF	994970-2			164
-	1 -	2119641-2			151
-	1 1	2168083-8			144
-	4 4	2168083-9			143
-	- 1	2119653-2			142
-	1 1	1-1803583-0			141
-	1 1	1803516-1			140
-	1 1	2119955-1			113
-	1 1	2844908-1			99
-	1 1	2844907-1			98
-	1 1	455888-5			82
-	1 1	1803607-3			71
-	1 1	1-2119791-6			70
-	1 1	2119943-1			69
-	1 1	2119740-1			67
-	2 2	2168078-1			66
-	1 1	5-18022-5			59
-	1 1	985575-3			57
-	1 1	1338685-1			56
-	2 2	2-2168083-5			53
-	1 1	1803382-6			50
-	1 2	18023-9			49
-	- 1	2119652-1			48
-	1 1	1803602-1			41
-	1 1	1-1752356-7			34
-	2 2	2079383-5			33
-	2 2	3-2844962-2			30
-	1 1	2844992-2			29
-	1 1	455888-5			28
-	1 1	1320928-2			24
-	1 1	2168083-2			21
-	2 2	1-18028-2			20
-	1 1	2119533-1			19
-	1 1	2119806-1			13
-	1 1	3-22280-3			12
-	1 1	1-2168083-0			11
-	1 1	2119805-1			10
-	1 1	318707-1			9
1 1 1	1	3-1633711-9			8
-	1 1	240641-4			7
-	1 1	2119781-5			5
-	1 1	4-238011-5			4
1 1 1	1	1803018-2			3
-	1 1	455888-8			2
1 1 1	1	1-456404-8			1

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

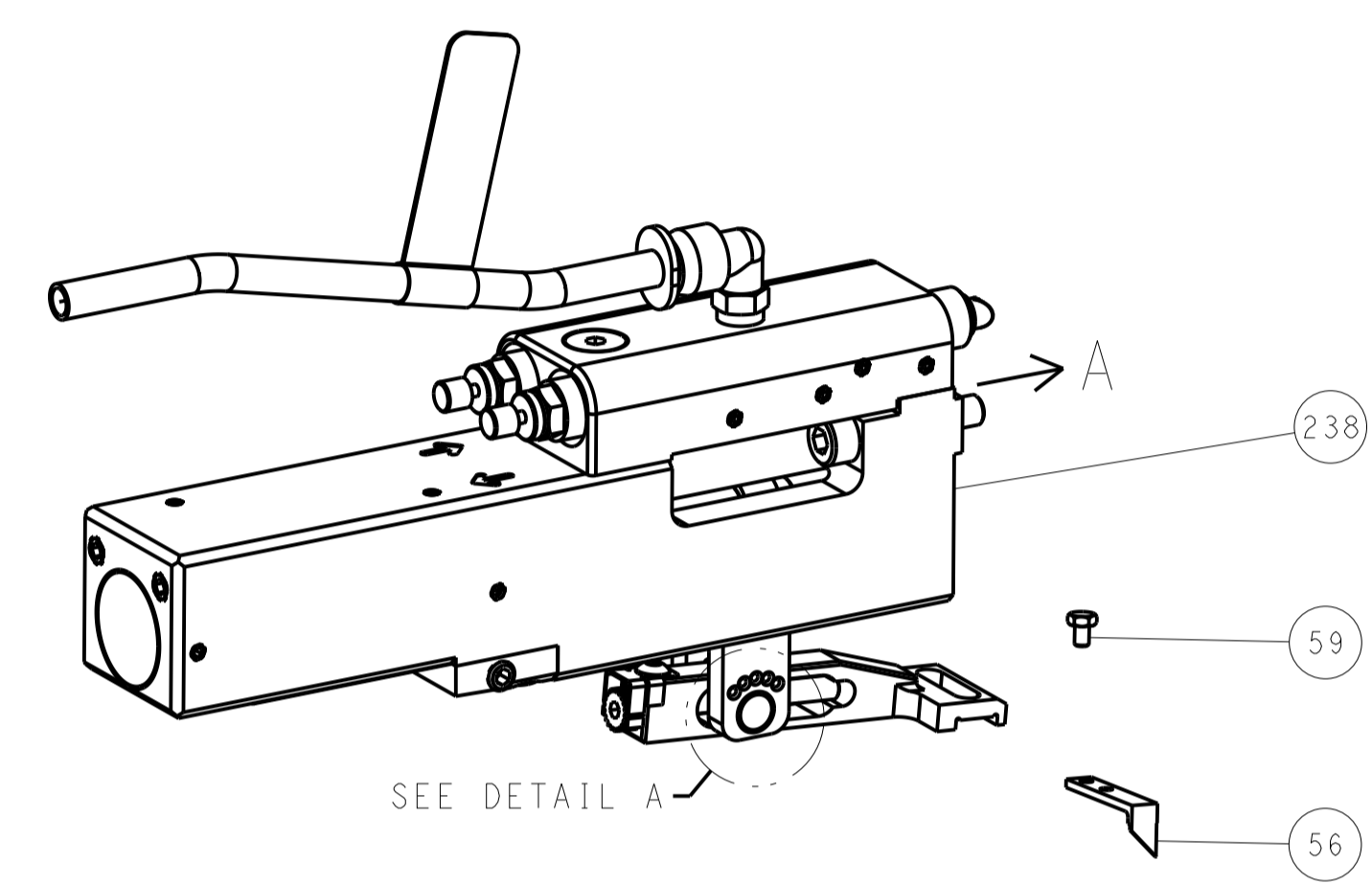
DATE	30SEP2011	CHK	G.BAILEY	DATE	29SEP2011
APPV	S.XI	DATE	29SEP2011	NAME	
PRODUCT SPEC		APPLICATION SPEC		SIZE	A1
SCALE	1:2	SHEET	3 OF 4	REV	D

LOC	DIST	REV	DATE	BY	APP'D
A	66				
		1			
		2			
		3			

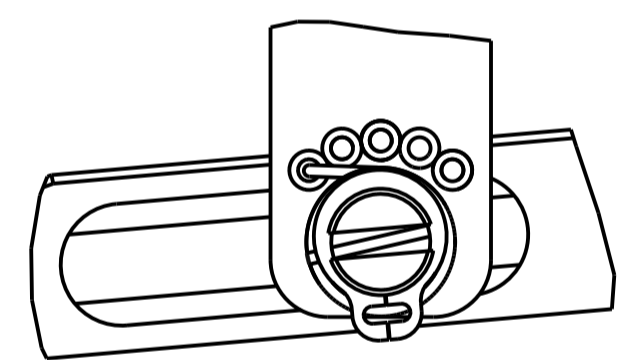
FEED TYPE MECHANICAL



PNEUMATIC

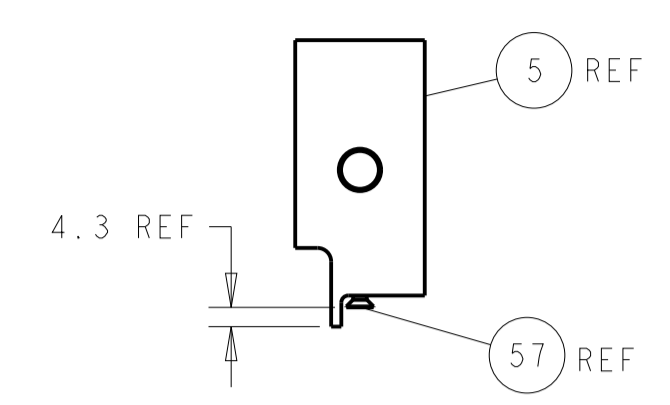
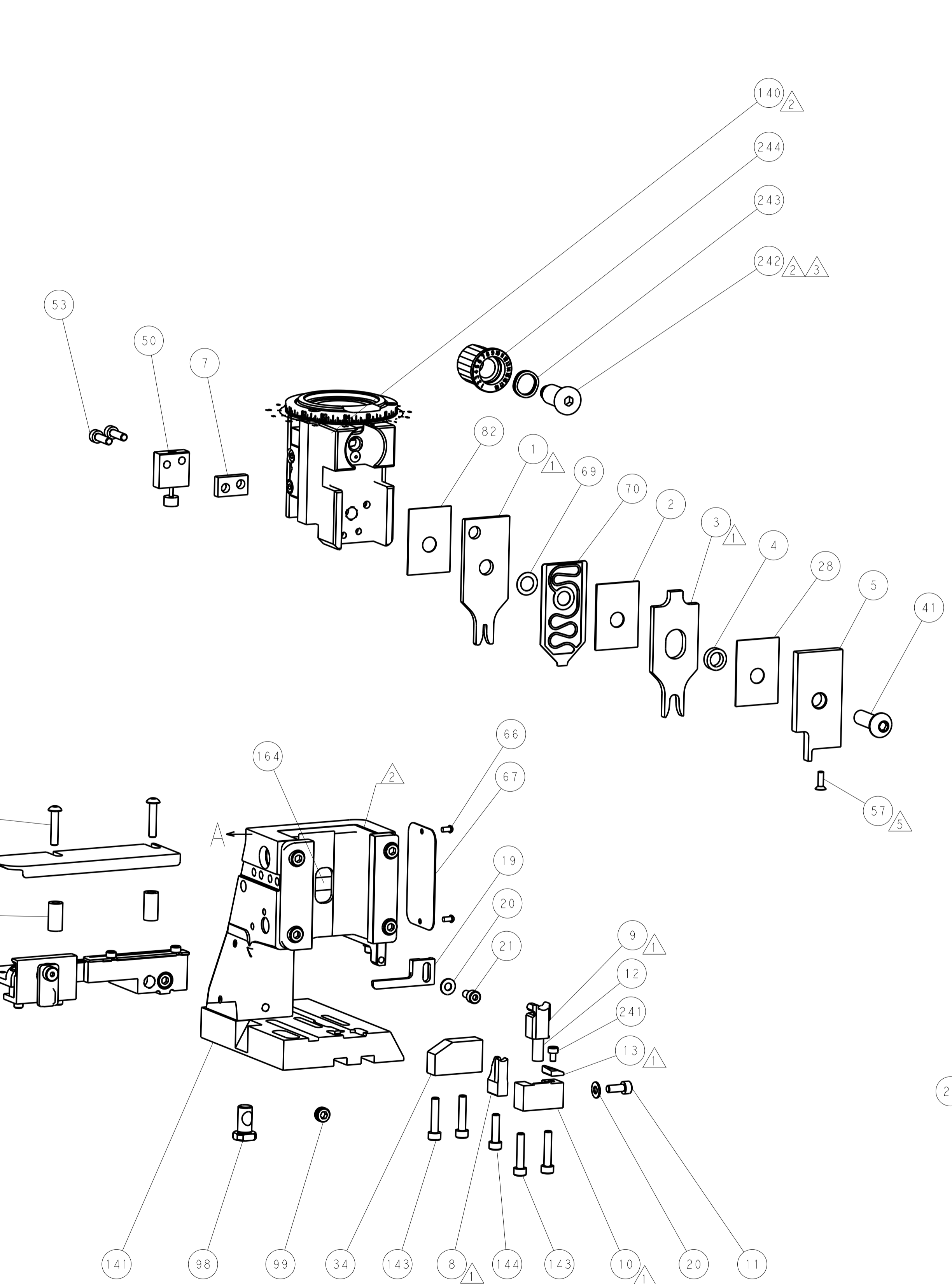
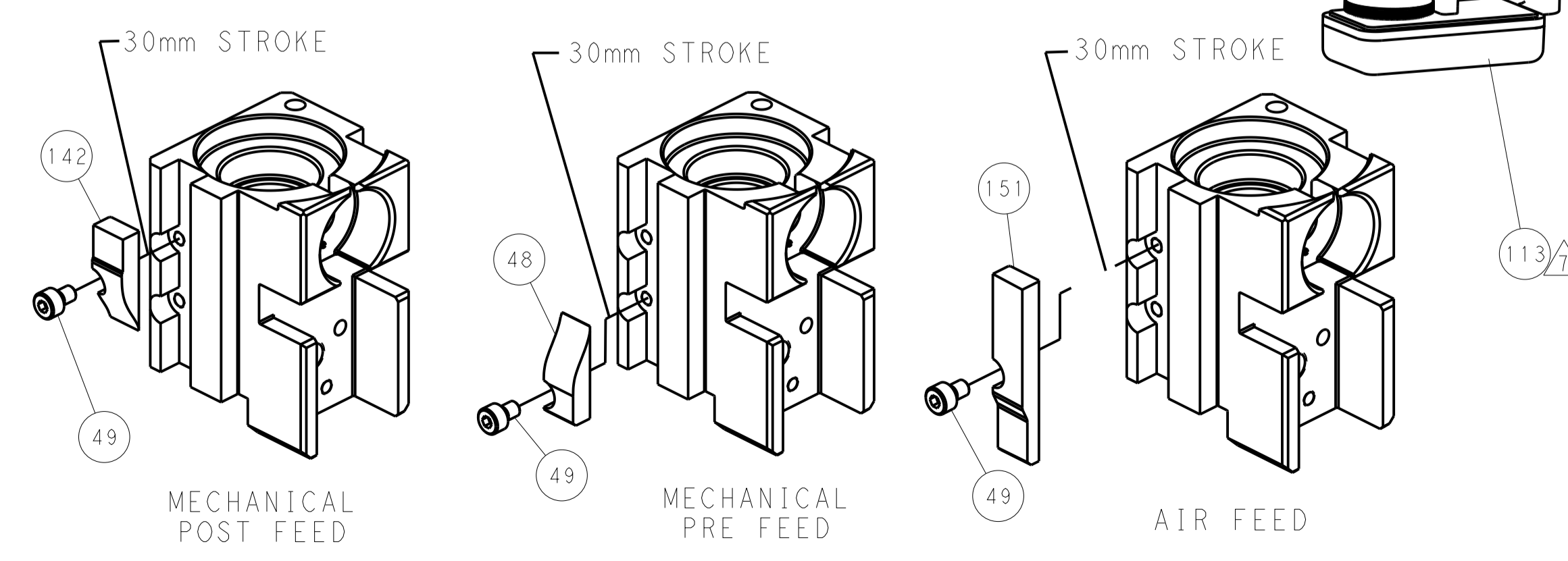


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

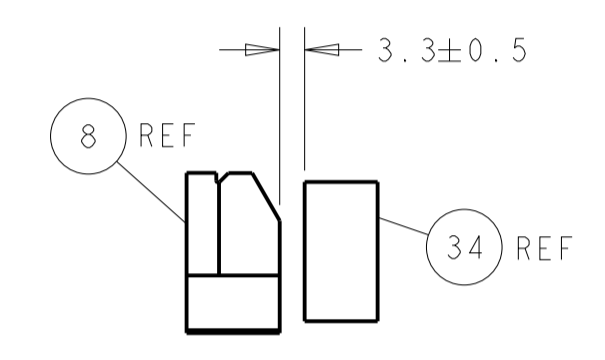


DETAIL A

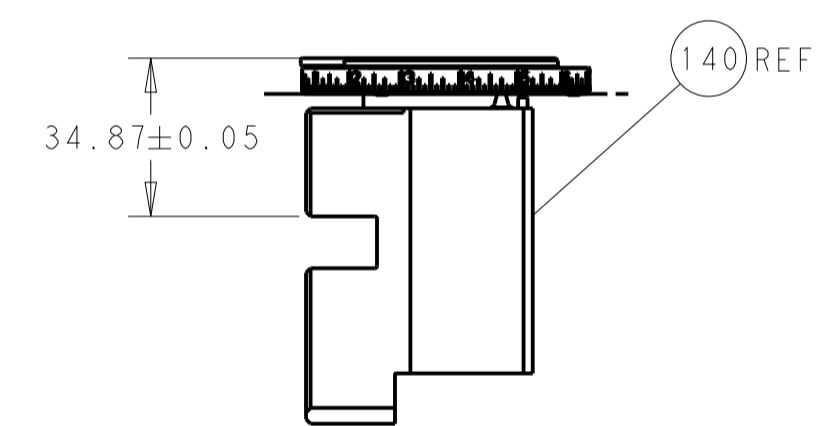
CAM POSITIONS



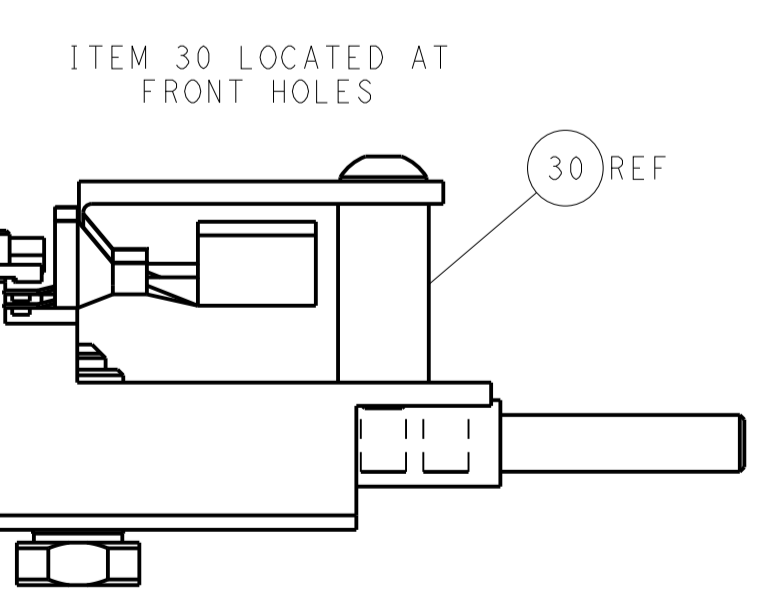
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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:		DWG: Y. YIN 30SEP2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: G. BAILEY 29SEP2011		NAME: Ocean Side Feed Applicator	
APVD: S. XI 29SEP2011		PRODUCT SPEC:		APVD: S. XI 29SEP2011		RESTRICTED TO:	
APPLICATION SPEC:		WEIGHT:		SIZE: CAGE CODE: DRAWING NO:		A 00779 C=2151322	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2		SHEET 4 OF 4		REV D	