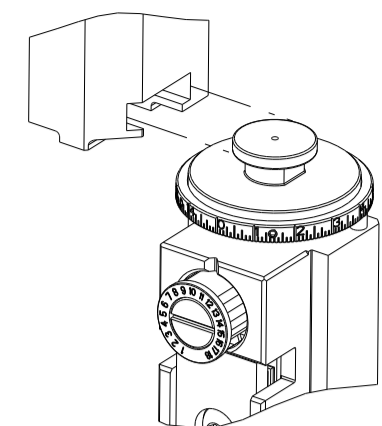


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151811-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151811-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151811-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

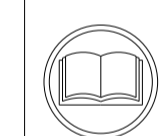


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE TERMINAL M4			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-6.00 mm [.217-.236 IN]		Ø3.10-4.20 mm [.122-.165 IN]	
TERMINAL APPLICATION SPECIFICATION	114-101016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2050216-1	2050216-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.57+/-0.05 [.101+/- .002]	6.2
2.00mm2	2.43+/-0.05 [.096+/- .002]	7.8
1.50mm2	2.33+/-0.05 [.092+/- .002]	8.9



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
- 6. 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	APVD
		C		ECR-18-004642	28MAR2018	FL	TE
		D		ECR-19-006357	19APR2019	FJ	TE
		E		ECR-20-008425	12JUN2020	FZ	TE
		F		ECR-22-161993	22DEC2022	FZ	JAH

-	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	2844940-2	AIR FEED MODULE	238
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	230
	1	1	2-1752354-0	STANDOFF,HOLD-DOWN	180
-	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1633782-3	FENCE	78
-	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
-	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	1338683-8	FEED PAWL	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-2	HOLDDOWN, TERMINAL	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	2	2	4-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	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
-	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	1803095-6	FLOATING SHEAR, FRONT	9
	1	2	1-1633932-9	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-3	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
	1	2	1-1803457-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
	1	2	2-456411-9	CRIMPER, WIRE PREMIUM	1

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

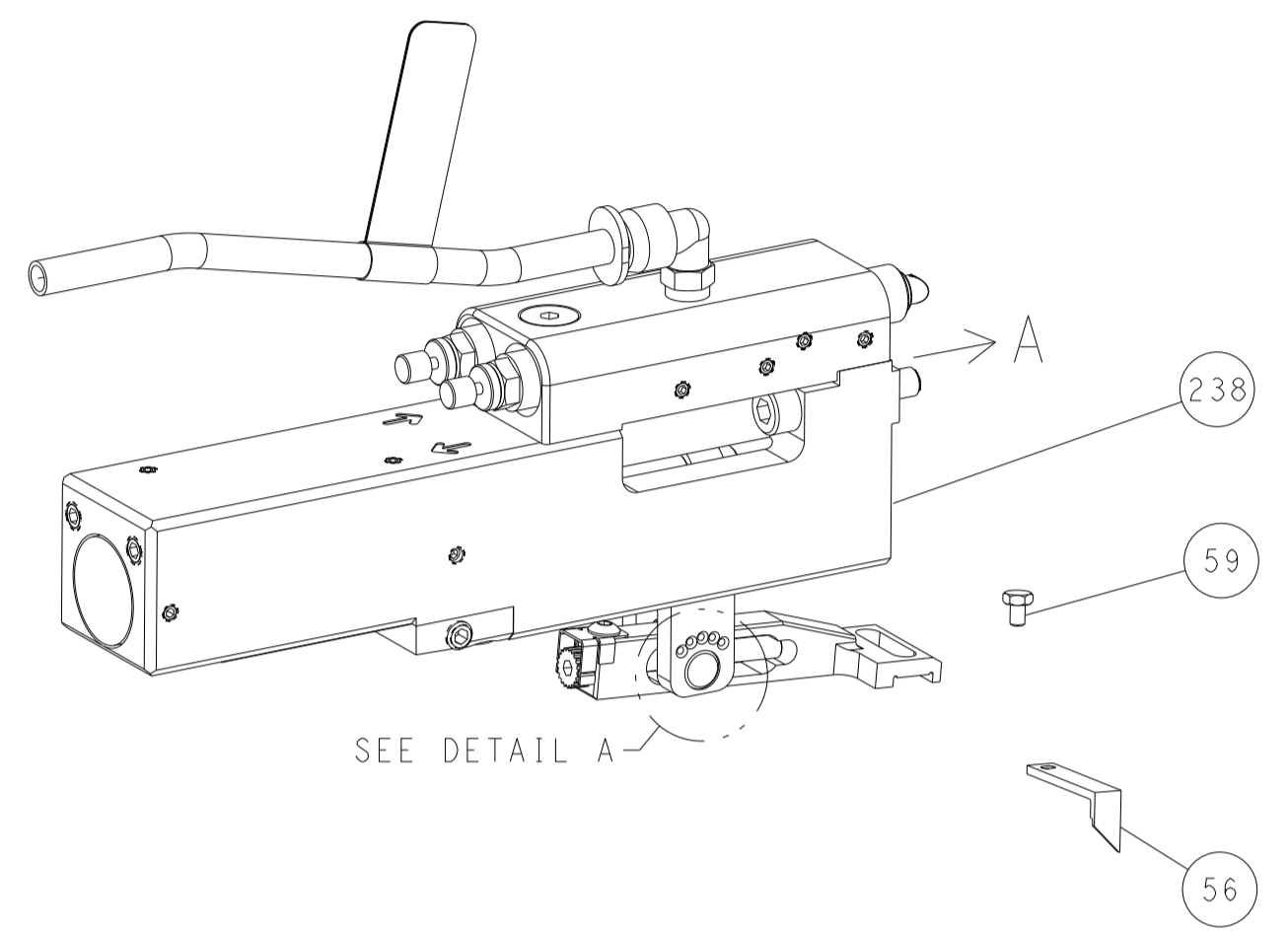
ITEM NO	PART NO	DESCRIPTION
-77-72 -2		

OWN	H. HUANG	13DEC2012
CHK	S. XI	13DEC2012
APVD	S. XI	13DEC2012
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151811
Customer Accessible Production Drawing		

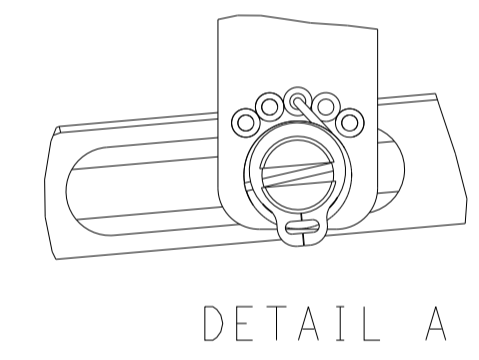
LOC		DIST		REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD		
A	66	SEE SHEET 1					

FEED TYPE

PNEUMATIC

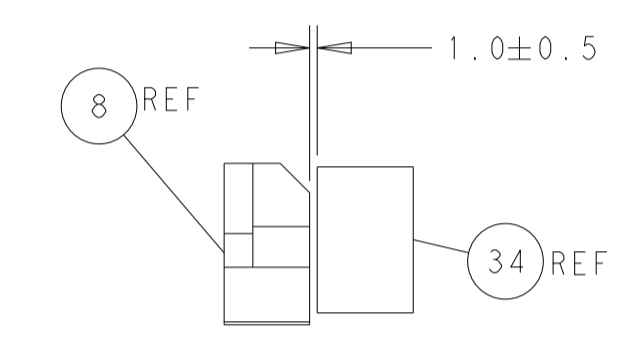
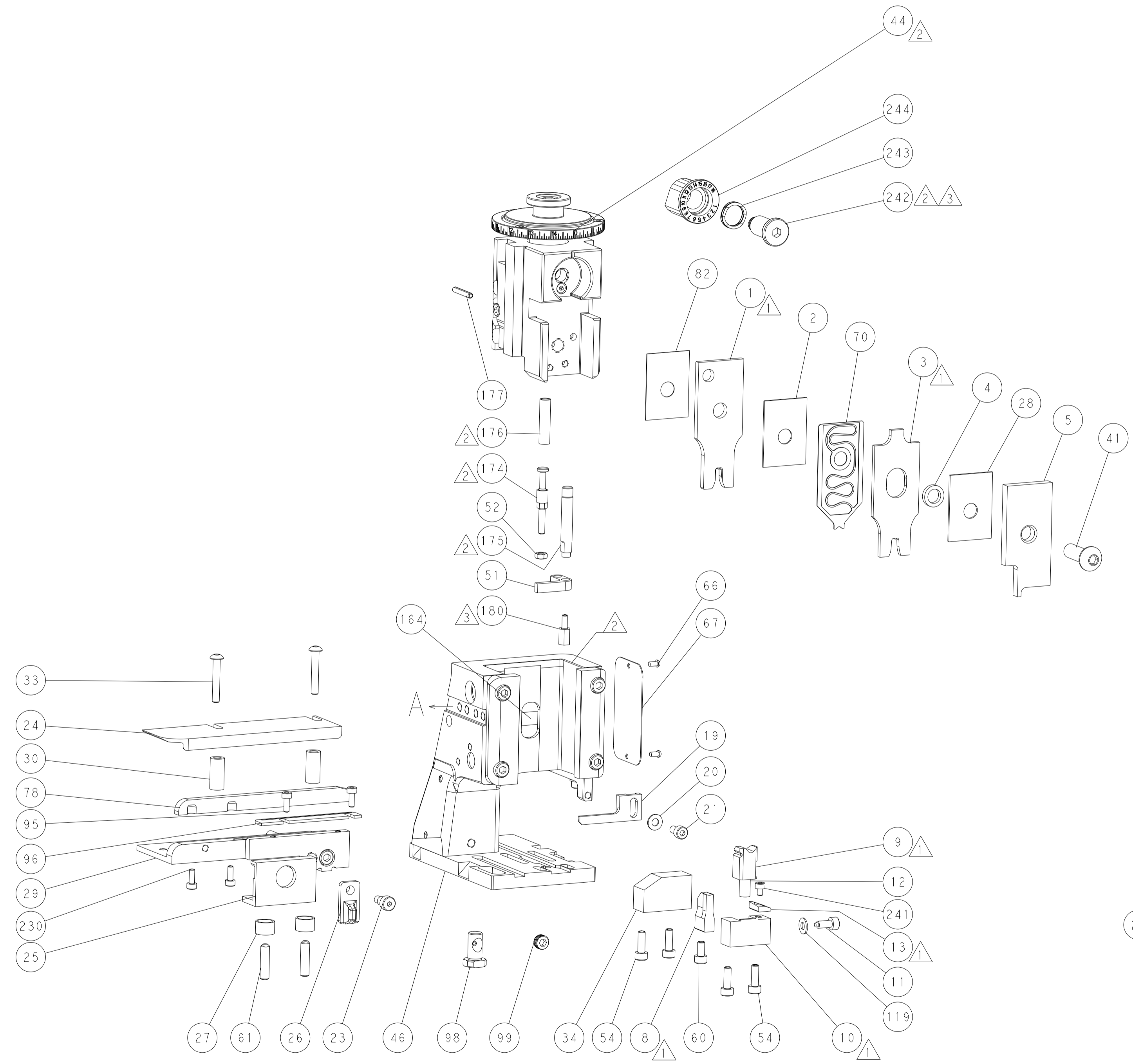
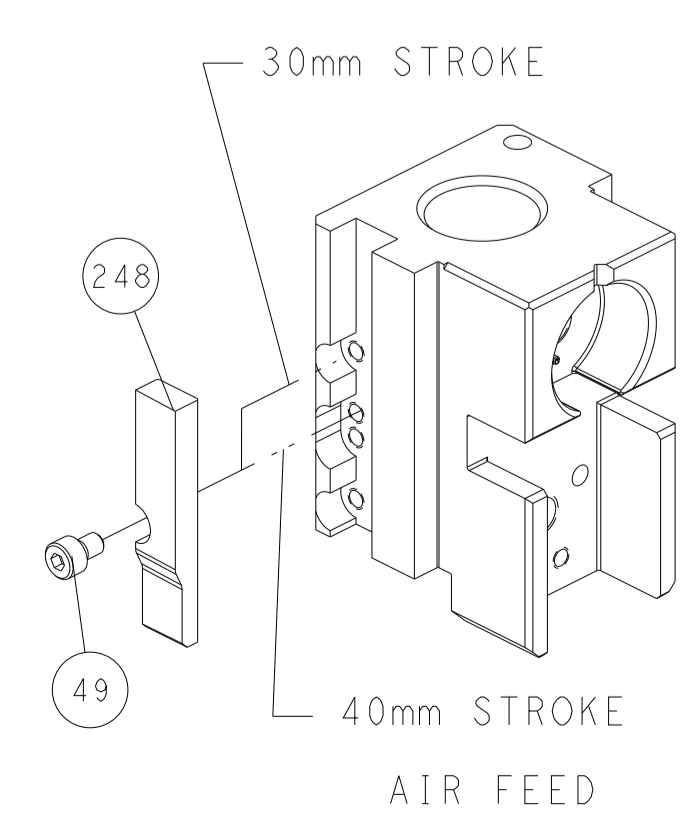


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

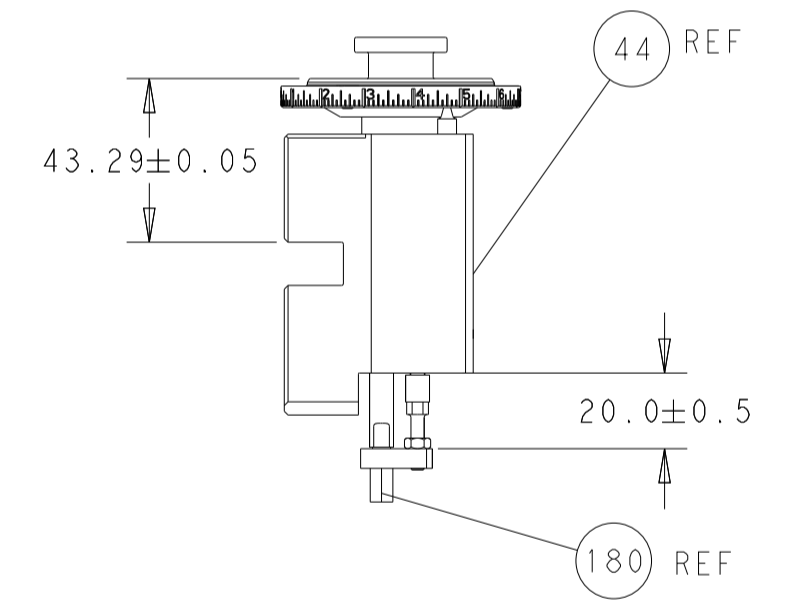


DETAIL A

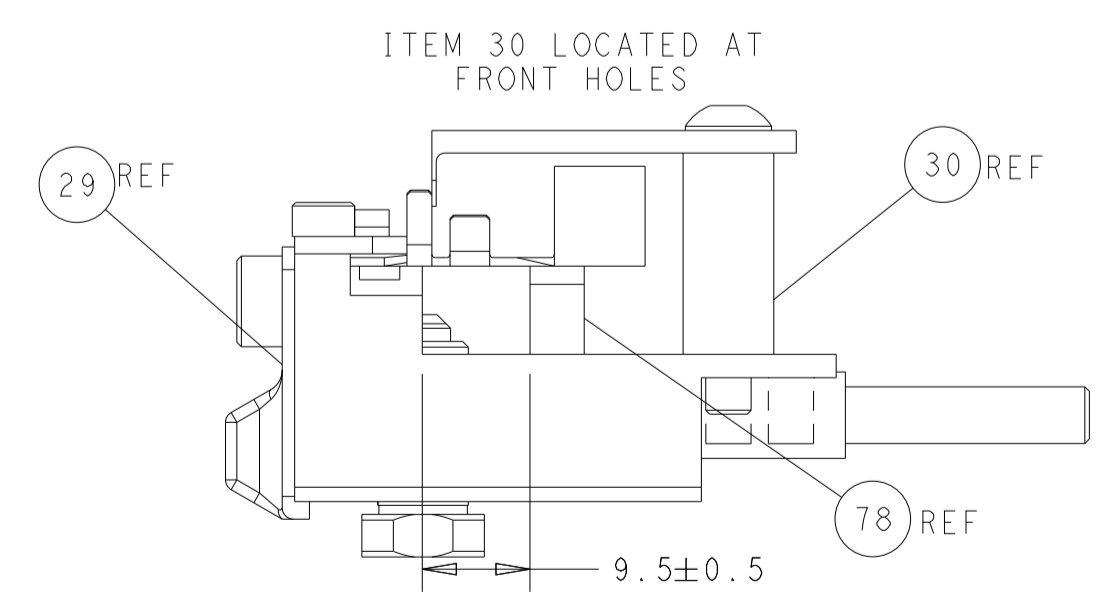
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



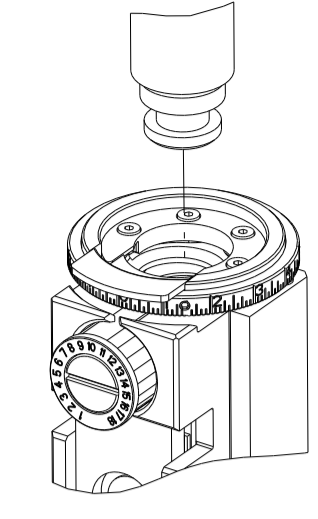
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: H. HUANG CHK: S. XI APVD: S. XI PRODUCT SPEC: 13DEC2012 APPLICATION SPEC: 13DEC2012	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151811 SCALE: 1:2 SHEET: 2 of 4 REV: F
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DATE: 13DEC2012 DRAWING NO: 2151811	TE Connectivity Harrisburg, PA 17105-3608

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151811-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151811-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [1.40]	F
INSUL	4.57 mm [1.80]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE TERMINAL M4			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-6.00 mm [1.217-.236 IN]		∅3.10-4.20 mm [1.22-.165 IN]	
TERMINAL APPLICATION SPECIFICATION	114-101016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2050216-1	2050216-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.57+/-0.05 [1.01+/-0.02]	6.2
2.00mm2	2.43+/-0.05 [1.096+/-0.02]	7.8
1.50mm2	2.33+/-0.05 [1.092+/-0.02]	8.9



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
- 6. 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.

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

LOC	DIST	REVISIONS					
A	66	P	LTN	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	2844940-2	AIR FEED MODULE	238	
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	230	
	-	1	2-1752354-0	STANDOFF, HOLD-DOWN	180
-	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	1-690438-0	FRONT STRIP GUIDE	96	
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	455888-4	SPACER, CRIMPER	82	
-	1	1633782-3	FENCE	78	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1338683-8	FEED PAWL	56	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1901681-2	HOLDDOWN, TERMINAL	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1752356-3	SUPPORT, TERMINAL	34	
-	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33	
-	2	4-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-3	ASSEMBLY, STRIP GUIDE	29	
-	1	1-455888-0	SPACER, CRIMPER	28	
-	2	22283-1	SPRING, COMPRESSION	27	
-	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	240792-1	DRAG, TERMINAL	25	
-	1	1320928-2	STRIP GUIDE	24	
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	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	1803095-6	FLOATING SHEAR, FRONT	9
	1	1	1-1633932-9	ANVIL, COMBINATION	8
-	-	-	-	7	
-	-	-	-	6	
-	1	1-2119757-3	DEPRESSOR, SHEAR	5	
-	1	238011-4	BLOCK, CRIMPER SPACER	4	
	1	1	4-1803457-0	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-8	SPACER, CRIMPER	2	
	1	1	2-456411-9	CRIMPER, WIRE PREMIUM	1

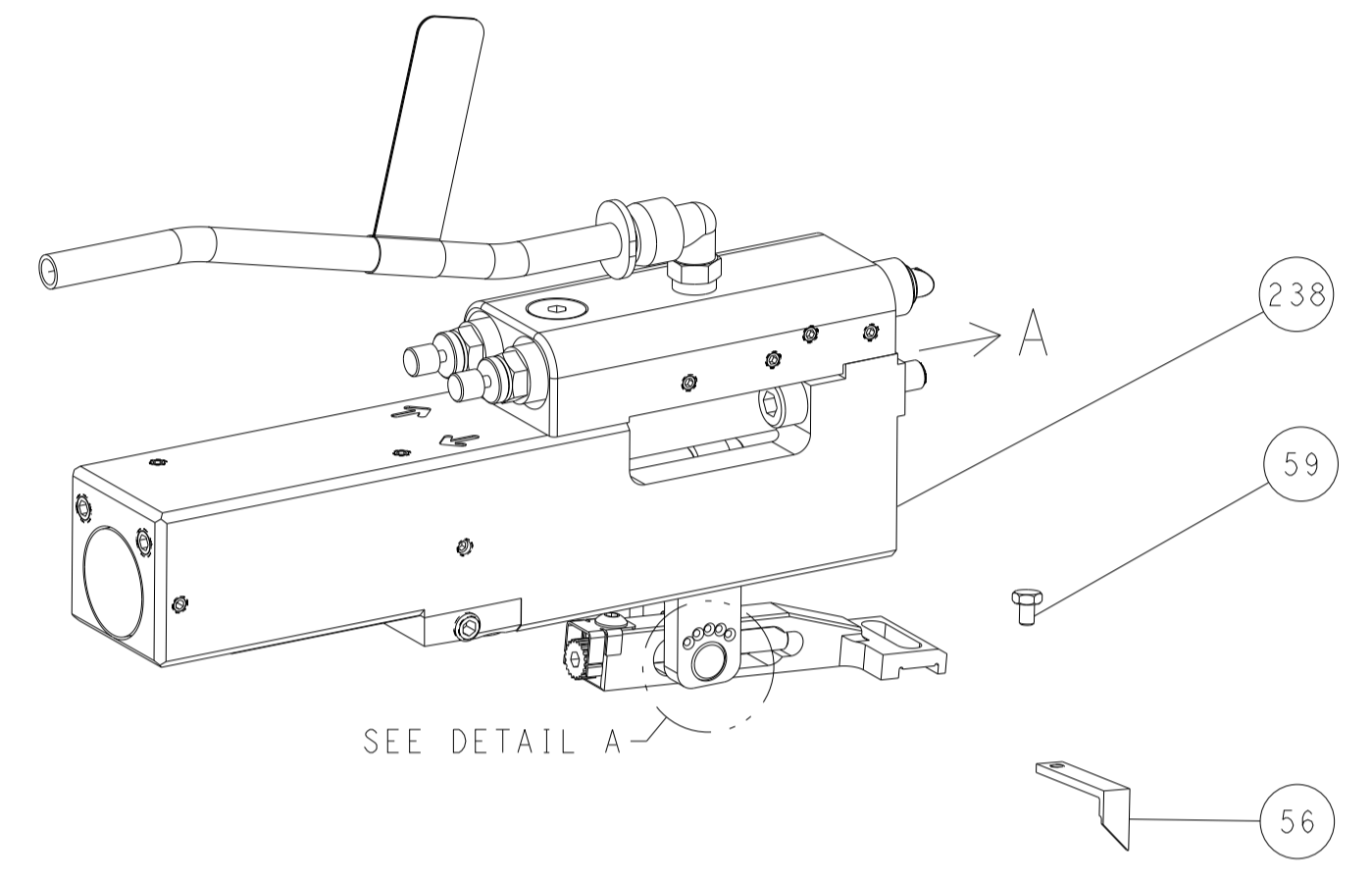
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL				WEIGHT			

CHK	H. HUANG	13DEC2012
CHK	S. XI	13DEC2012
APVD	S. XI	13DEC2012
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	A1	00779
CAGE CODE		
DRAWING NO		2151811
SCALE	1:2	
SHEET	3	OF 4
REV	F	

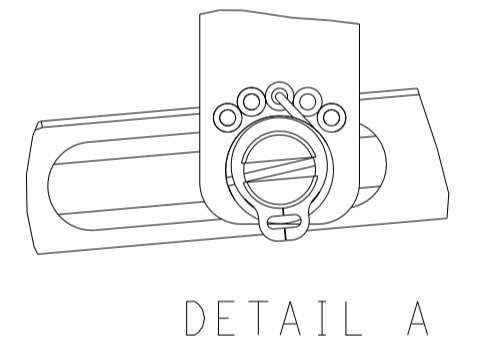
LOC		DIST		REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD		
A	66	SEE SHEET 1					

FEED TYPE

PNEUMATIC

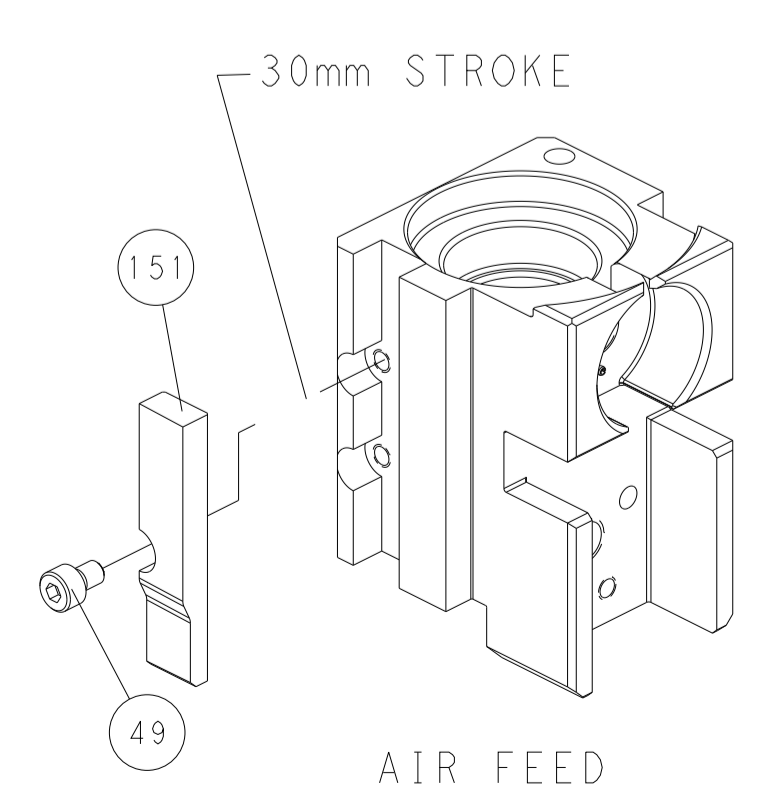


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

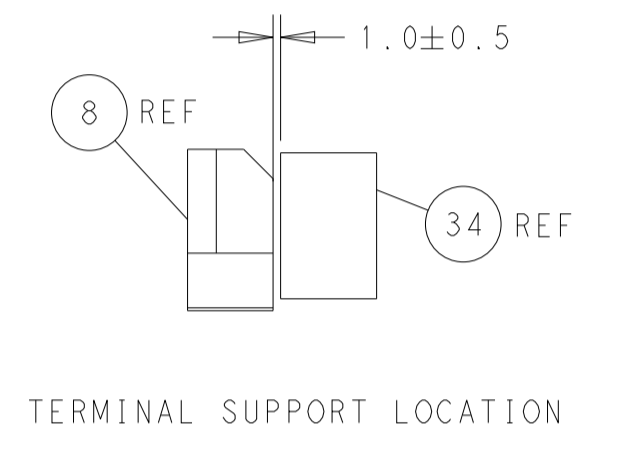
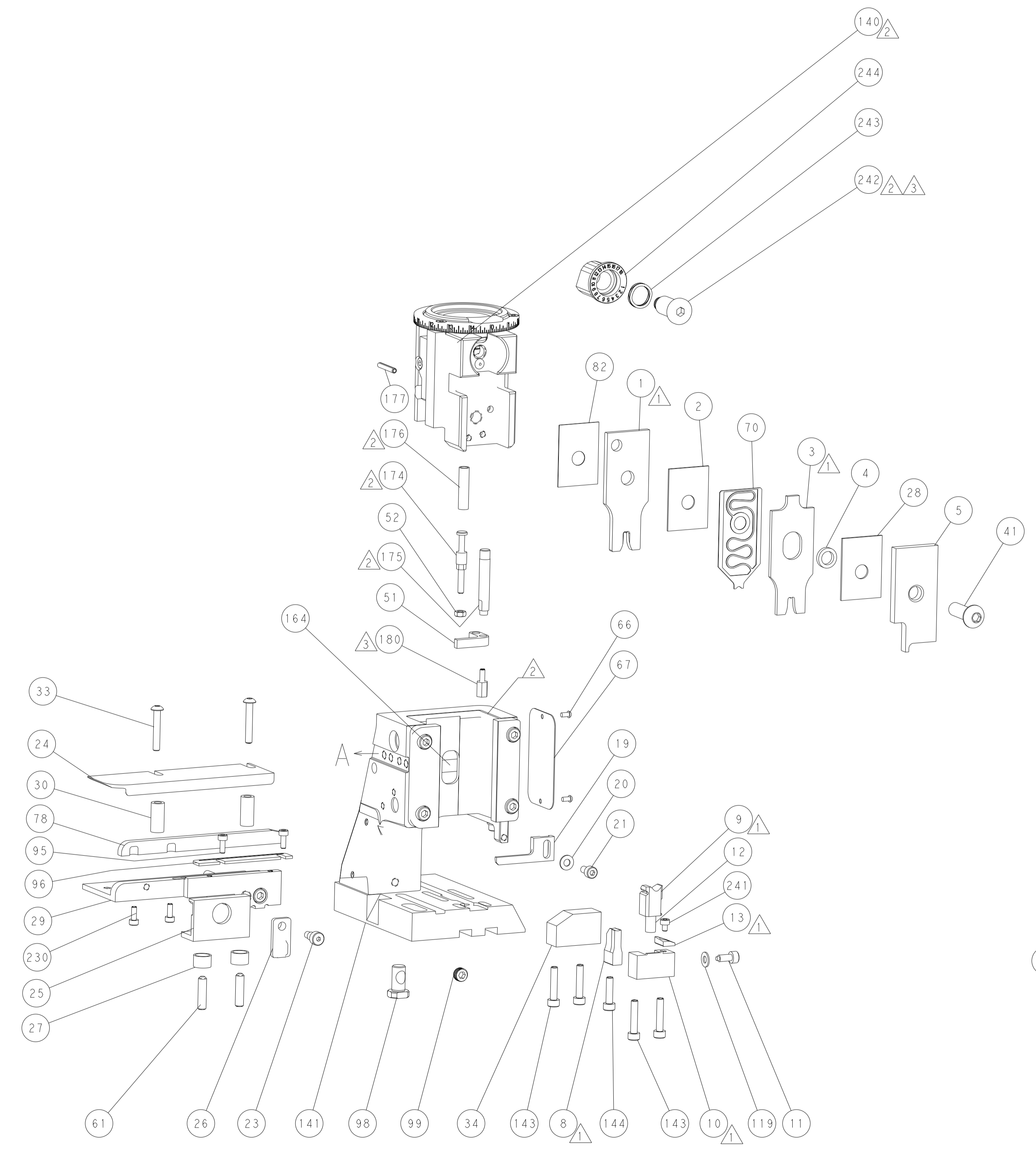


DETAIL A

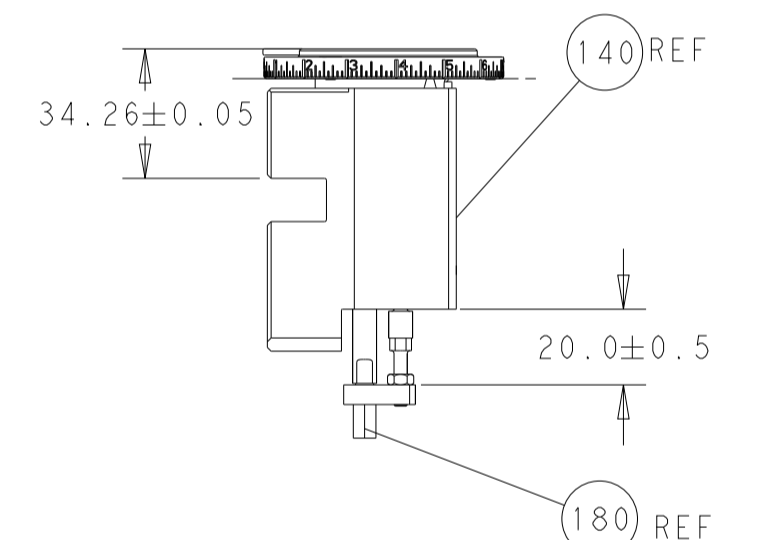
CAM POSITION



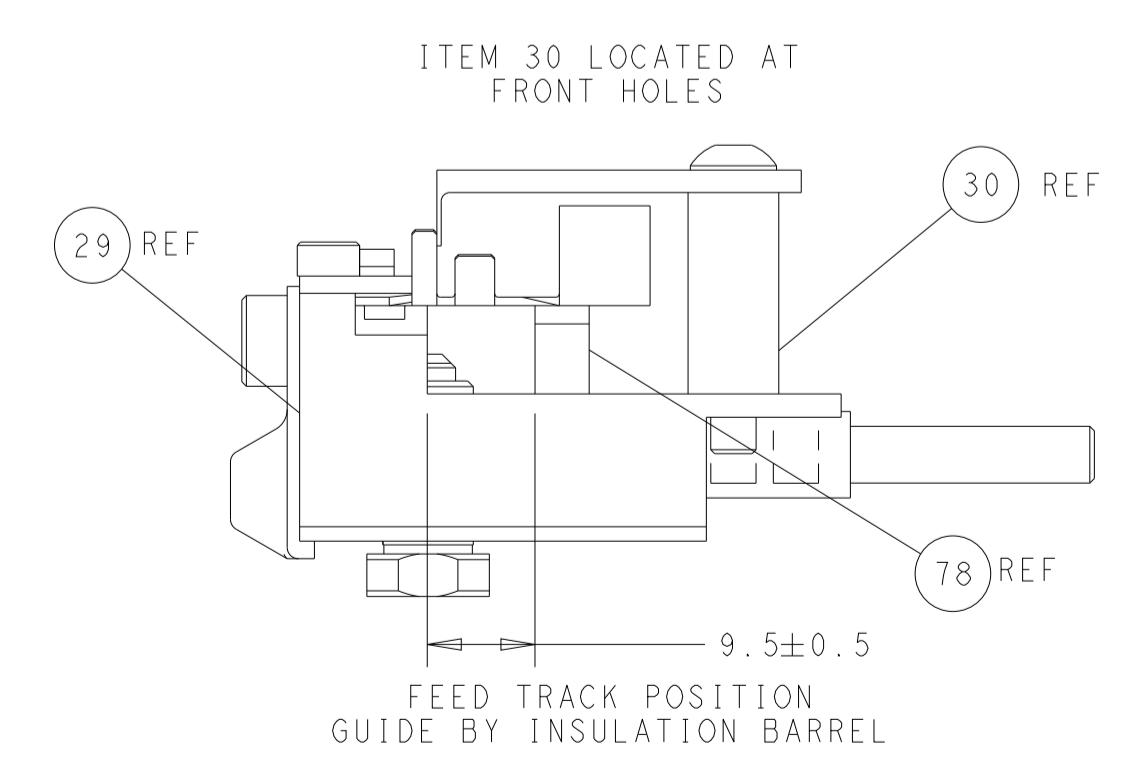
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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: H. HUANG 13DEC2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK: S. XI 13DEC2012	NAME: Ocean Side Feed Applicator	SIZE: A1	CAGE CODE: 00779
MATERIAL:				APVD: S. XI 13DEC2012	DRAWING NO: 2151811	SCALE: 1:2	SHEET 4 OF 4
Customer Accessible Production Drawing				RESTRICTED TO: F			