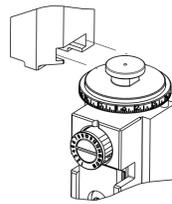


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151853-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151853-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151853-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	6.10 mm [.240]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: PRONER TERMINAL PRONER CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 8mm NG1 CAPACITE 3 A 6mm	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE $\phi$
5.95-5.97 mm [.234-.235 IN]	
TERMINAL APPLICATION SPECIFICATION	PRONER SPEC -

TE TERMINAL	PRONER TERMINAL	TE SEAL	PRONER SEAL	SEAL INSULATION DIAMETER RANGE
1544227-1	2398-D-001	1544316-1		$\phi$ 3.20-4.10

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.10 +/- 0.05 [.122 +/- .002]	5.8
5.00mm2	3.00 +/- 0.05 [.118 +/- .002]	6.9
4.00mm2	2.72 +/- 0.05 [.107 +/- .002]	9.5
3.00mm2	2.54 +/- 0.05 [.100 +/- .002]	11.4

- 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.
- GRIND TO LENGTH AT ASSEMBLY.

**\*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
		C	10MAR2017	MZ	KZ
		D	16NOV2018	TB	CT
		E	01MAR2021	JAH	RR
		F	29MAR2021	JWC	TE

-	1	1	1803078-1	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-3	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	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1-690438-0	FRONT STRIP GUIDE	96	
-	1	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1	455888-8	SPACER, CRIMPER	82	
	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-6	DEPRESSOR, WIRE	70	
-	1	1	2119943-1	WASHER, SPACER	69	
-	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	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57	
-	1	1	1338683-8	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1803583-3	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33	
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-4	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-4	STRIP GUIDE	24	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	2	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	2119805-2	SHEAR HOLDER, FRONT	10
	-	1	1	318059-4	FLOATING SHEAR, FRONT	9
	1	2	1	6-1633620-4	ANVIL, COMBINATION	8
-	1	1	240641-1	SPACER	7	
-	-	-	-	-	6	
-	1	1	2-2119781-7	DEPRESSOR, SHEAR	5	
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4	
	1	2	1	1803209-7	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1-455888-7	SPACER, CRIMPER	2	
	1	2	1	1-1633738-7	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO	

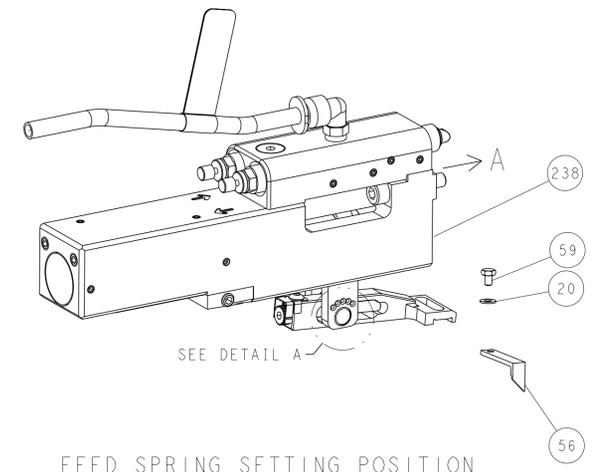
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		DATE:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	OWN	DATE	CHK	DATE
	ANGLES	FINISH		APVD		Y. YIN	14JAN2013	G. BAILEY	14JAN2013
MATERIAL				PRODUCT SPEC		TE Connectivity Harrisburg, PA 17105-3608			
				APPLICATION SPEC		Ocean Side Feed Applicator			
				WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
						A1	00779	2151853	
						Customer Accessible Production Drawing		SCALE	SHEET
						1:2		1	OF 4
								REV	F

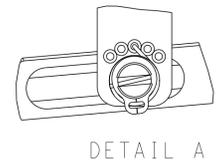
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

# FEED TYPE

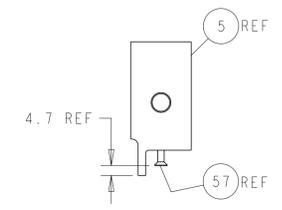
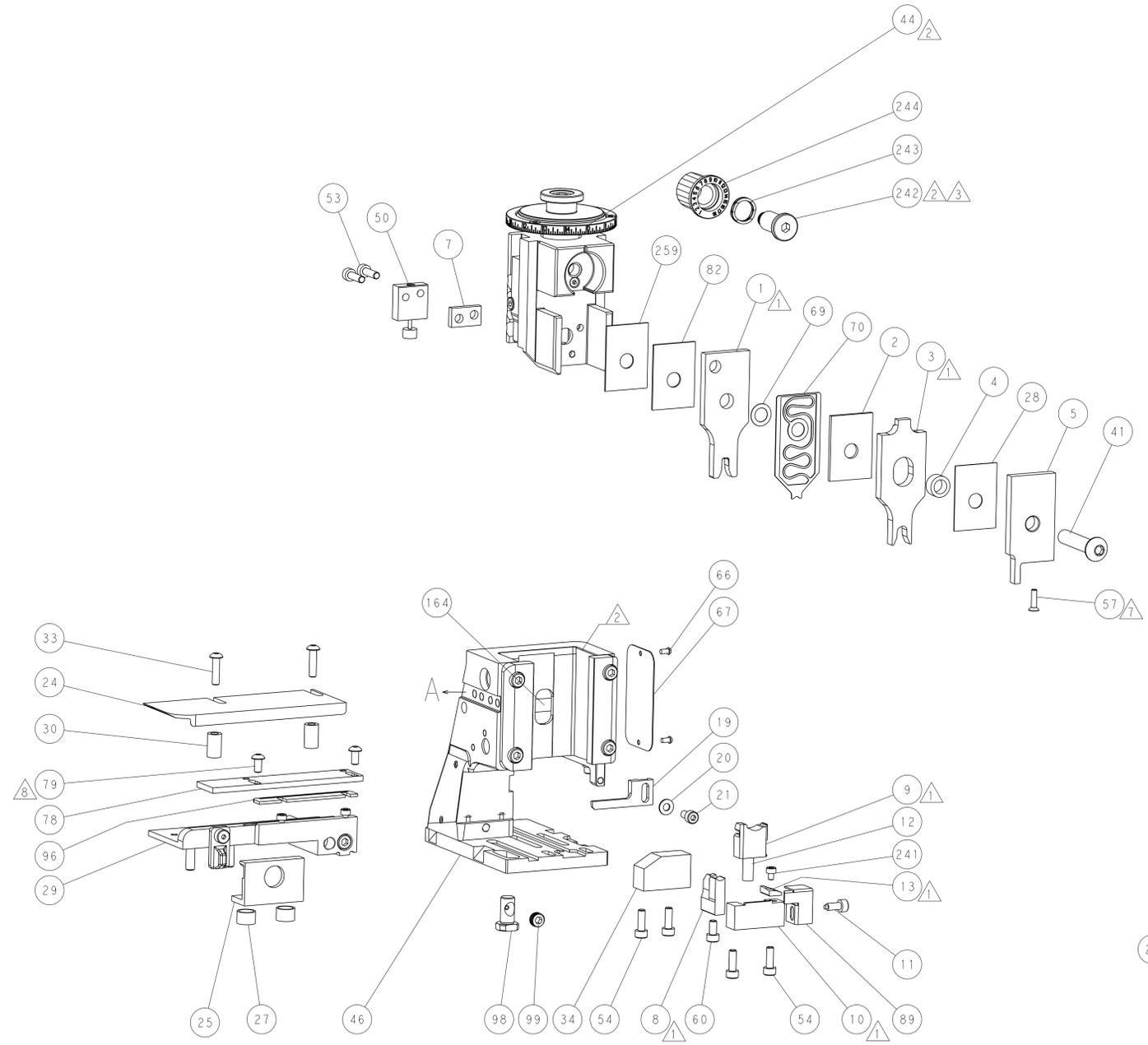
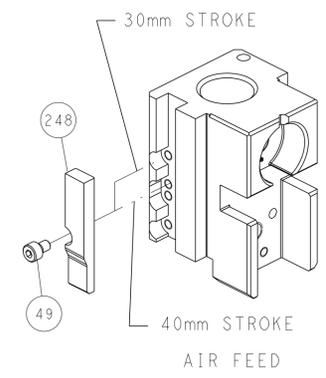
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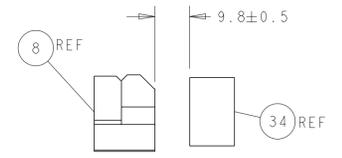
FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



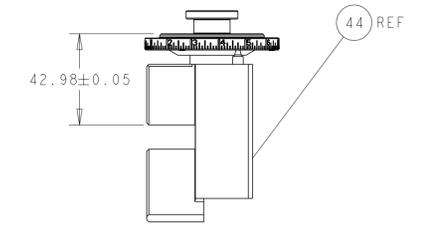
# CAM POSITION



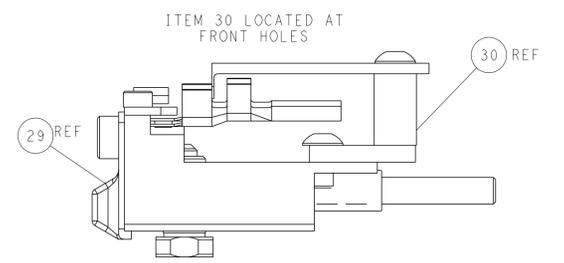
SHEAR DEPRESSOR DETAIL



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)

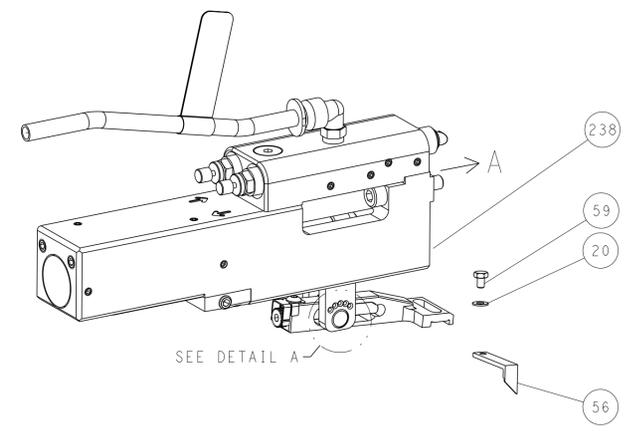
<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN 14JAN2013 CHK: G. BAILEY 14JAN2013 APVD: S. YI 14JAN2013	TE Connectivity Harrisburg, PA 17105-3608
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: 2151853 RESTRICTED TO: F	SCALE: 1:2 SHEET: 2 of 4 REV: F
MATERIAL:		WEIGHT:	
Customer Accessible Production Drawing			



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

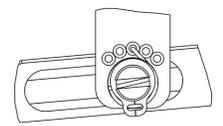
# FEED TYPE

## PNEUMATIC



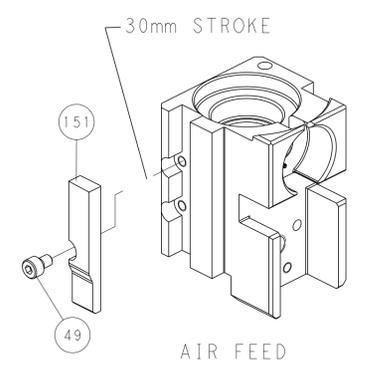
SEE DETAIL A

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

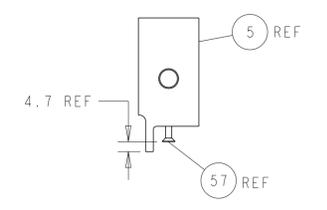
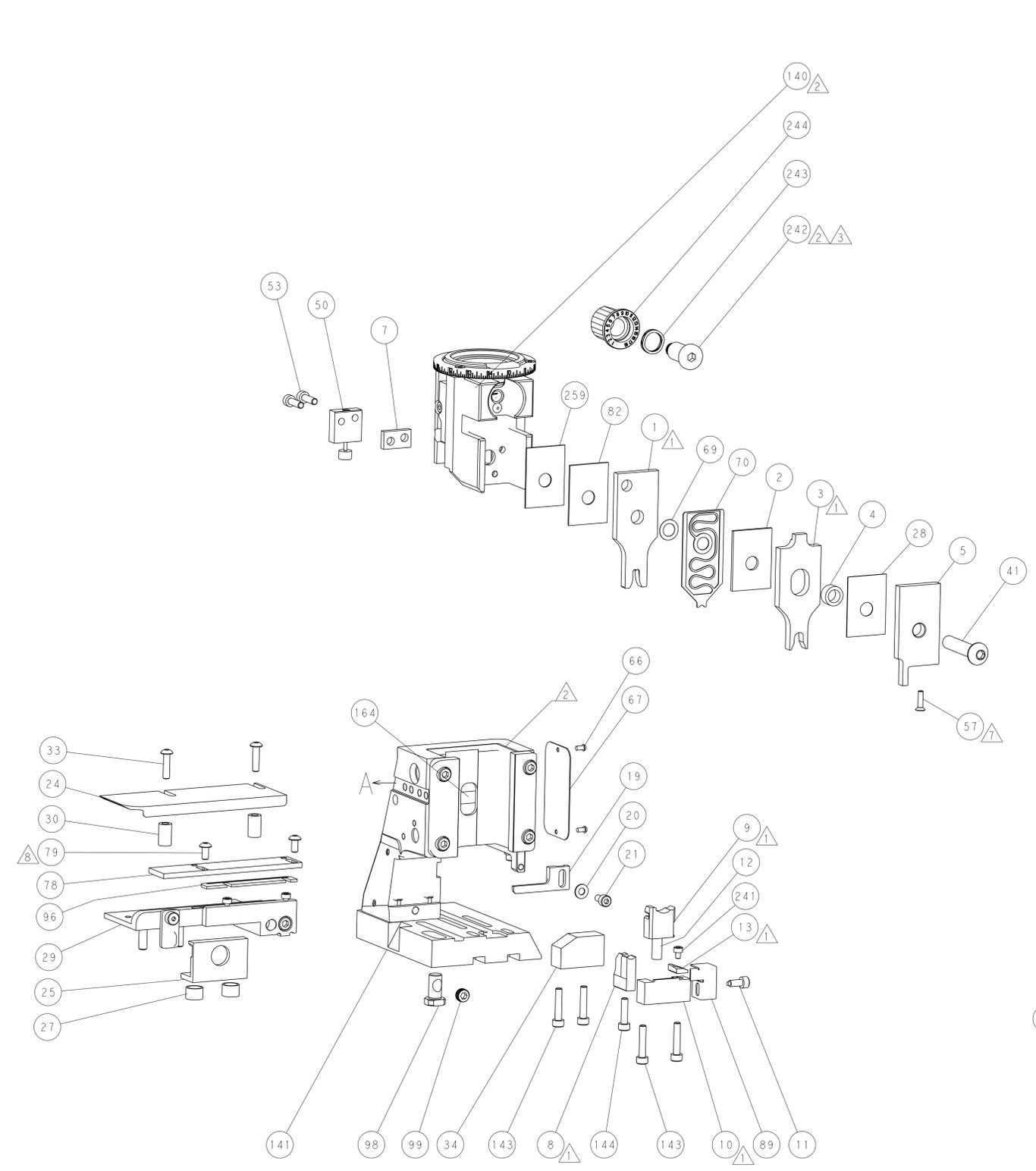


DETAIL A

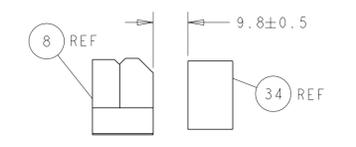
## CAM POSITION



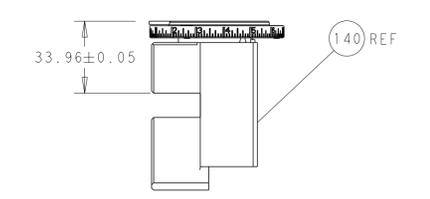
AIR FEED



SHEAR DEPRESSOR DETAIL

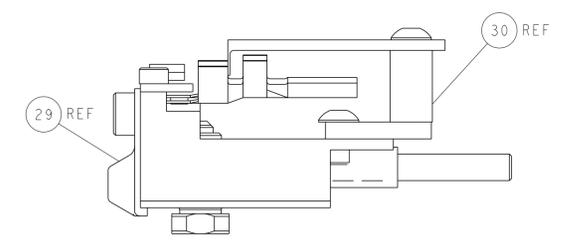


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN 14JAN2013 CHK: G. BAILEY 14JAN2013 APVD: S. XI 14JAN2013	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 PRODUCT SPEC APPLICATION SPEC SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151853 WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SHEET 4 OF 4 REV F