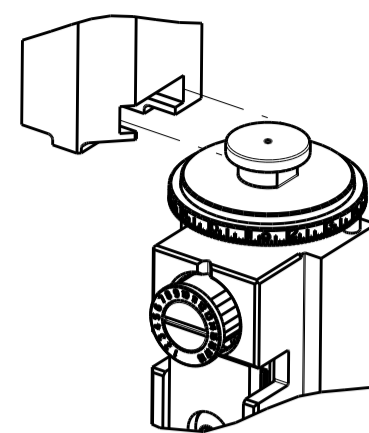


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2151983-1 | E | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2151983-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151983-1 | E | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2151983-2 | E | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151983-7 | C | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

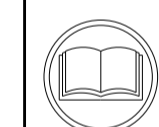


| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.10 mm [.043] | F |
| INSUL | 1.40 mm [.055] | F |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION | |
|---|------------------------------|
| TERMINAL NAME: TERMINAL | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE |
| 2.00-2.50 mm [.079-.098 IN] | Ø0.80-1.50 mm [.031-.059 IN] |
| TERMINAL APPLICATION SPECIFICATION ATAD-PO514-283 Rev 1 | |
| TERMINALS APPLIED | |
| TE TERMINAL | HIROSE TERMINAL |
| 2113350-1 | GT8-2428SCF |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|---------------------------------|--------------------------------|
| 24 AWG | 0.64 +/- 0.04 [.0252 +/- .0016] | 7.2 |
| 26 AWG | 0.60 +/- 0.04 [.0236 +/- .0016] | 7.6 |
| 28 AWG | 0.58 +/- 0.04 [.0228 +/- .0016] | 7.8 |



- 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. 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)

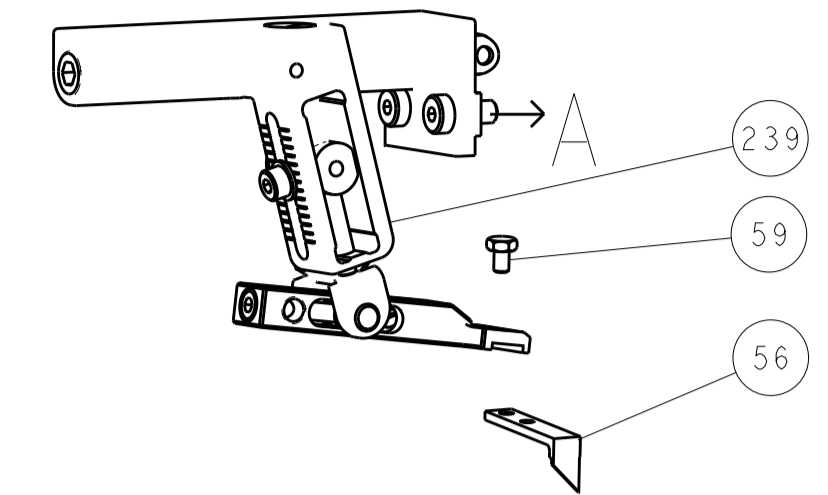
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| A | 66 | B | | ECR-15-004965 | 30MAR2015 | KH | TE |
| | | C | | ECR-15-017027 | 23NOV2015 | TT | TE |
| | | D | | ECR-16-009416 | 29JUN2016 | MEH | GB |
| | | E | | ECR-19-003815 | 11MAR2019 | FZ | YY |

| | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | 1 | - | 1 | - | 1803259-1 | BUSHING, FLANGED | 249 |
| - | 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 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | 1 | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | 1 | - | 1 | - | 2063440-1 | AIR FEED MODULE | 238 |
| - | 2 | - | 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | - | 1 | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | 1 | - | 1 | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | 1 | - | 1 | - | 2119799-1 | HOLDER, FEED FINGER, AF | 136 |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | 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 | 1803607-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | 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 | 1338685-1 | PAWL, FEED | 56 |
| - | 4 | 4 | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 |
| - | 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 | 2-1752356-6 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2 | 2 | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 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 |
| - | 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 | 1-356885-3 | STOP, SHEAR | 11 |
| - | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1 | 1 | 1803095-6 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 2 | 2 | 1 | 1803335-4 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1-2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 238011-6 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 2 | 2 | 1 | 1803326-4 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 1 | 1 | 455888-4 | SPACER, CRIMPER | 2 |
| - | 1 | 2 | 2 | 1 | 1803324-7 | CRIMPER, WIRE | 1 |
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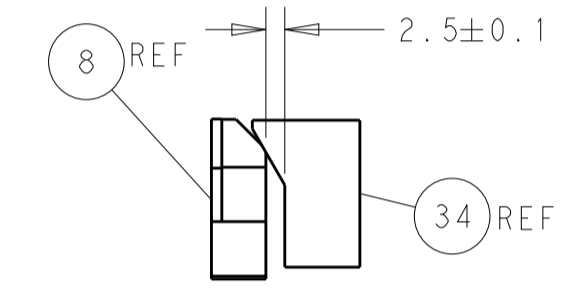
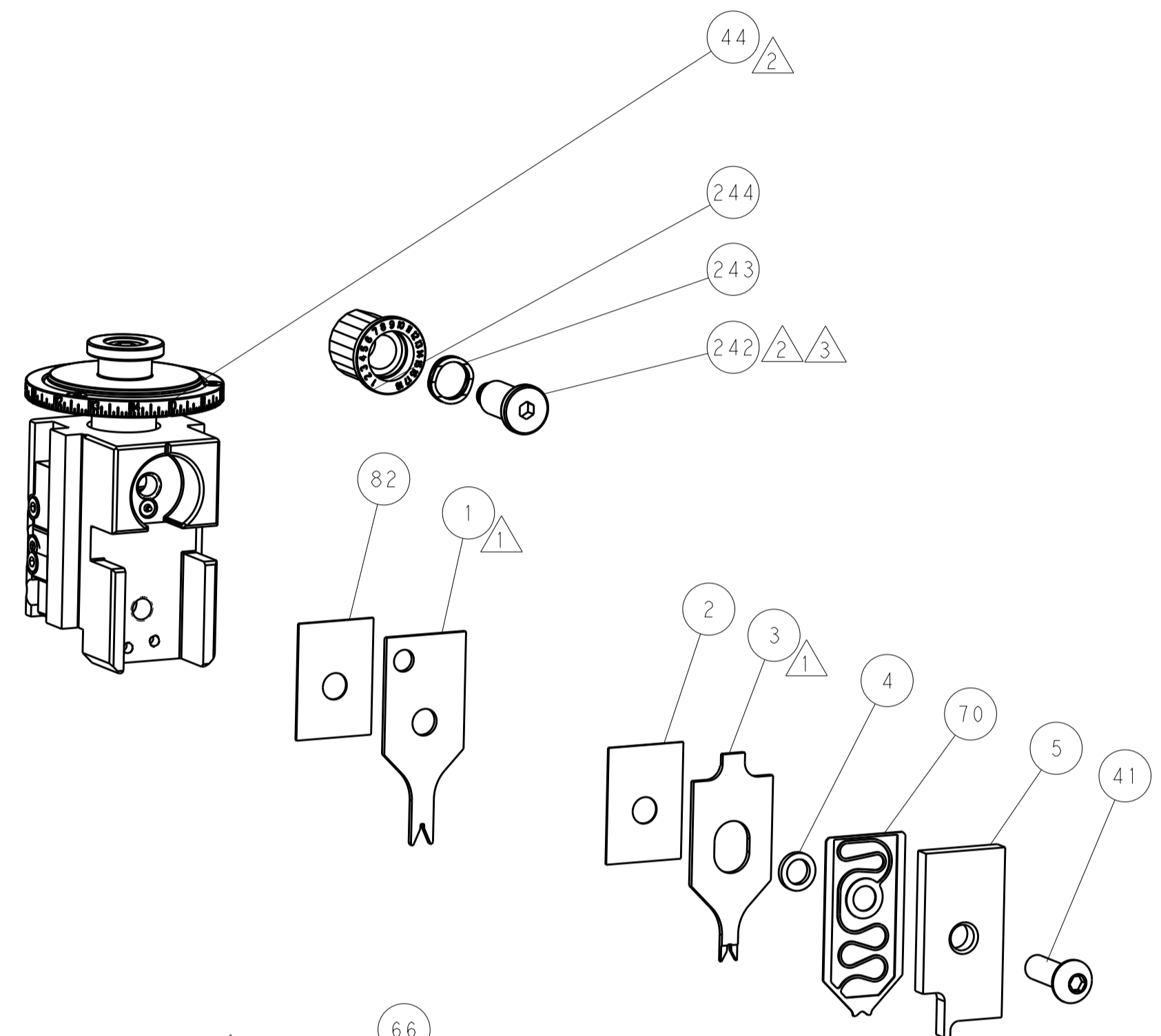
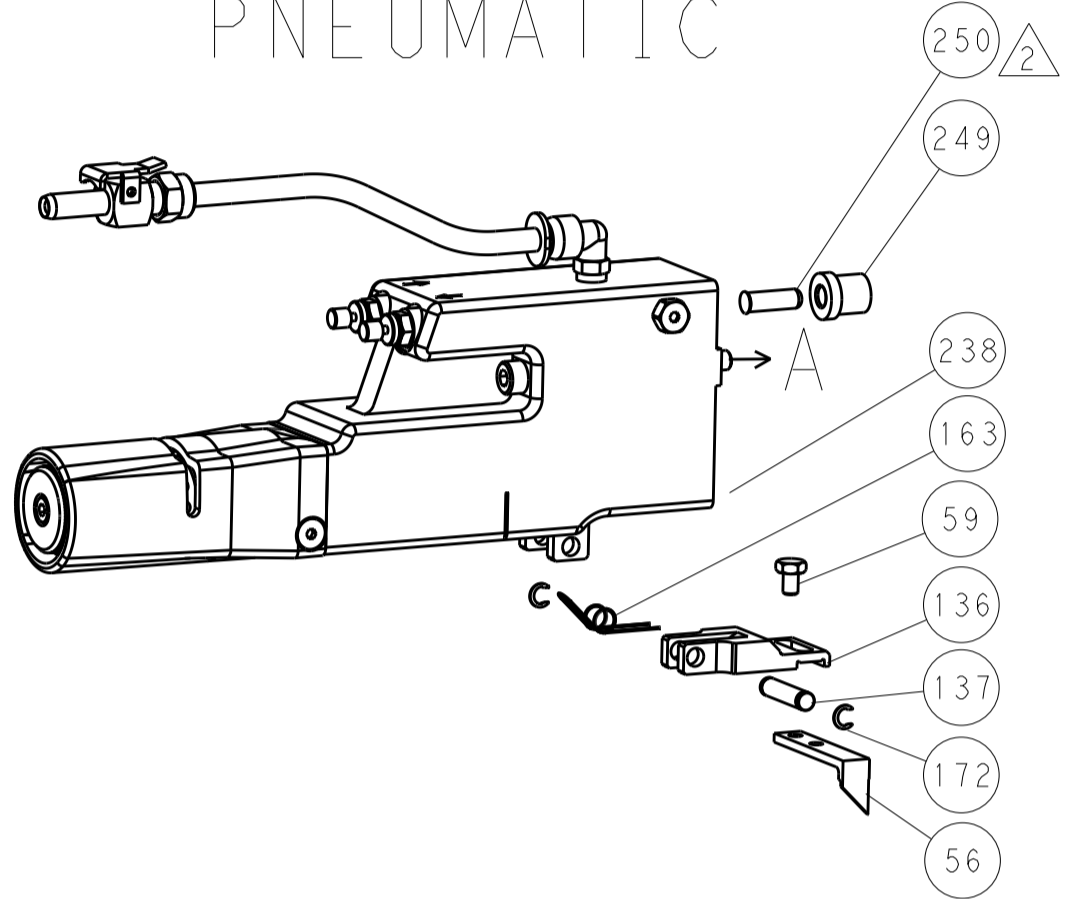
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | |
|--|---------|--|---------|---|---------|--|--|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES ± | |
| | | | | | | | |
| THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT INHERENT LIABILITY. | | | | OWN: BOB HIGMAN 14AUG2013 CHK: T. ELBIN 14AUG2013 APVD: M. CLIFFORD 14AUG2013 | | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151983 SCALE: 1:2 SHEET: 1 OF 4 REV: E | |

| LOC | DIST | REVISIONS | | | |
|-----|------|-------------|-------------|------|----------|
| | | P. LTM | DESCRIPTION | DATE | DWN APVD |
| - | - | SEE SHEET 1 | | | |

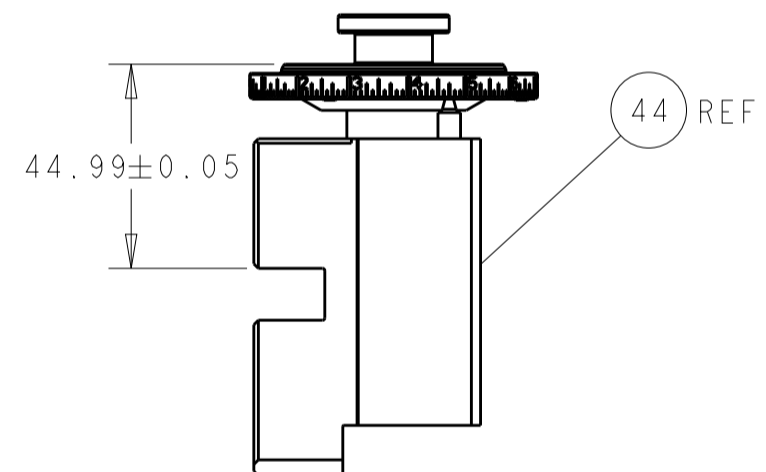
FEED TYPE MECHANICAL



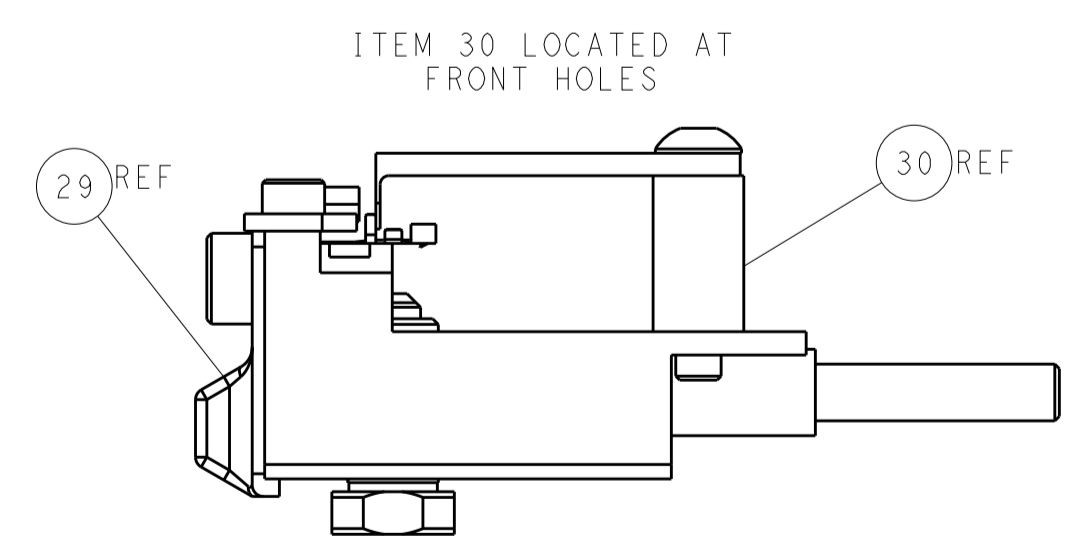
PNEUMATIC



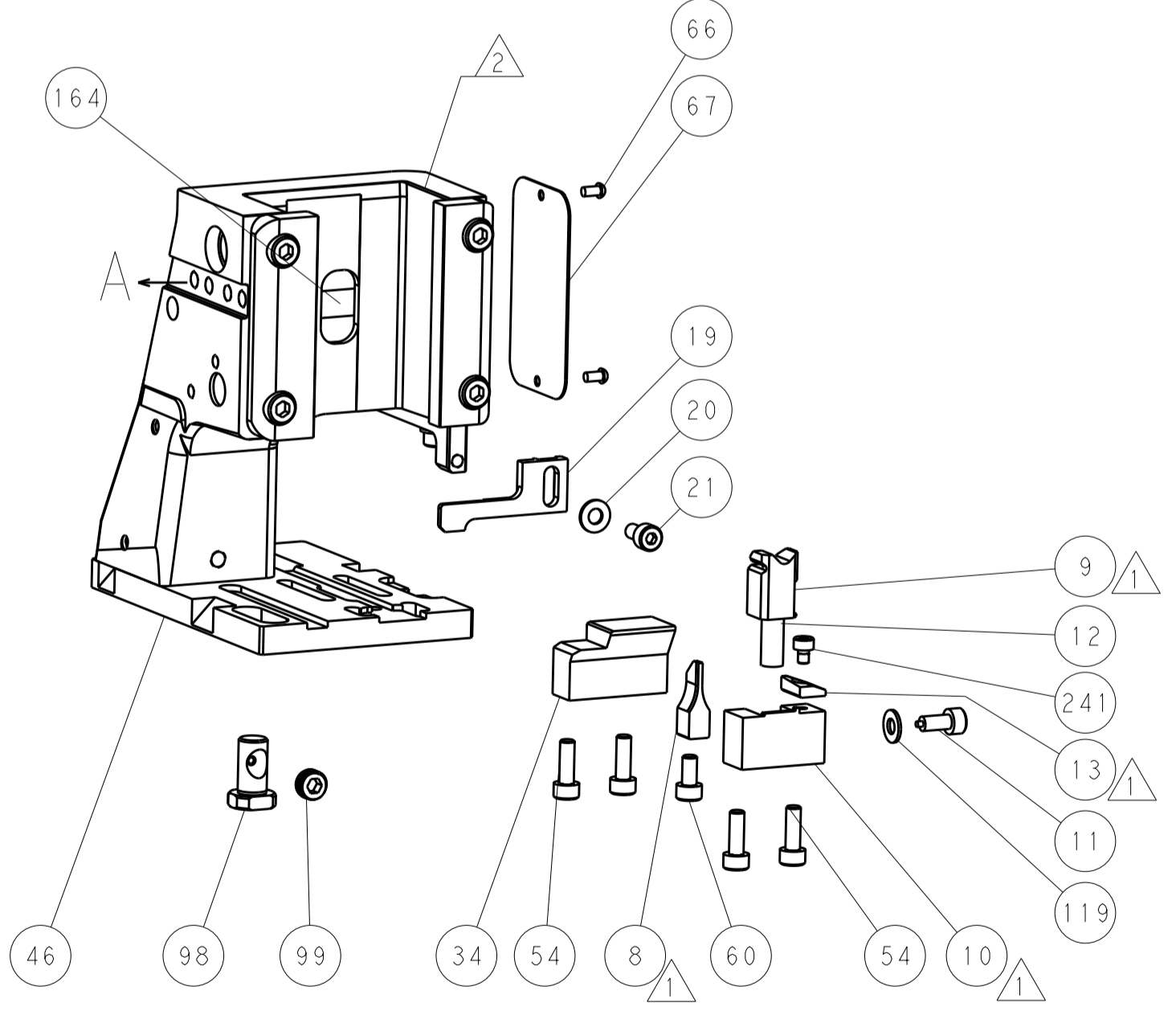
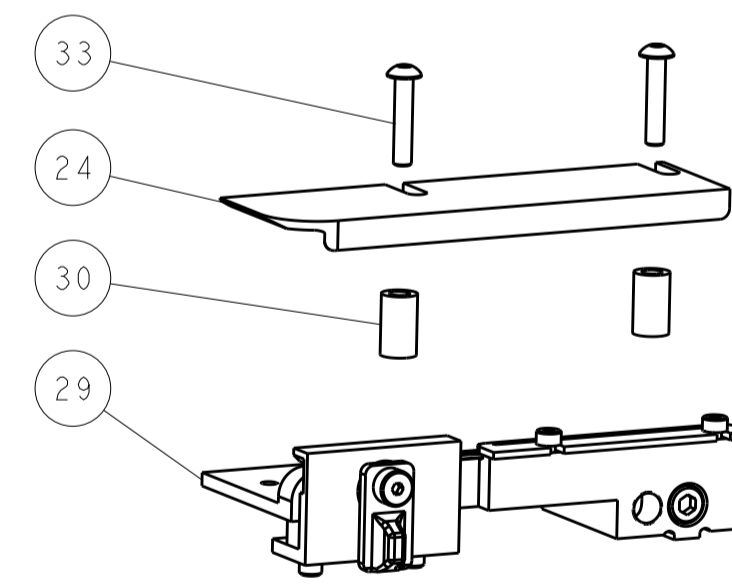
TERMINAL SUPPORT LOCATION



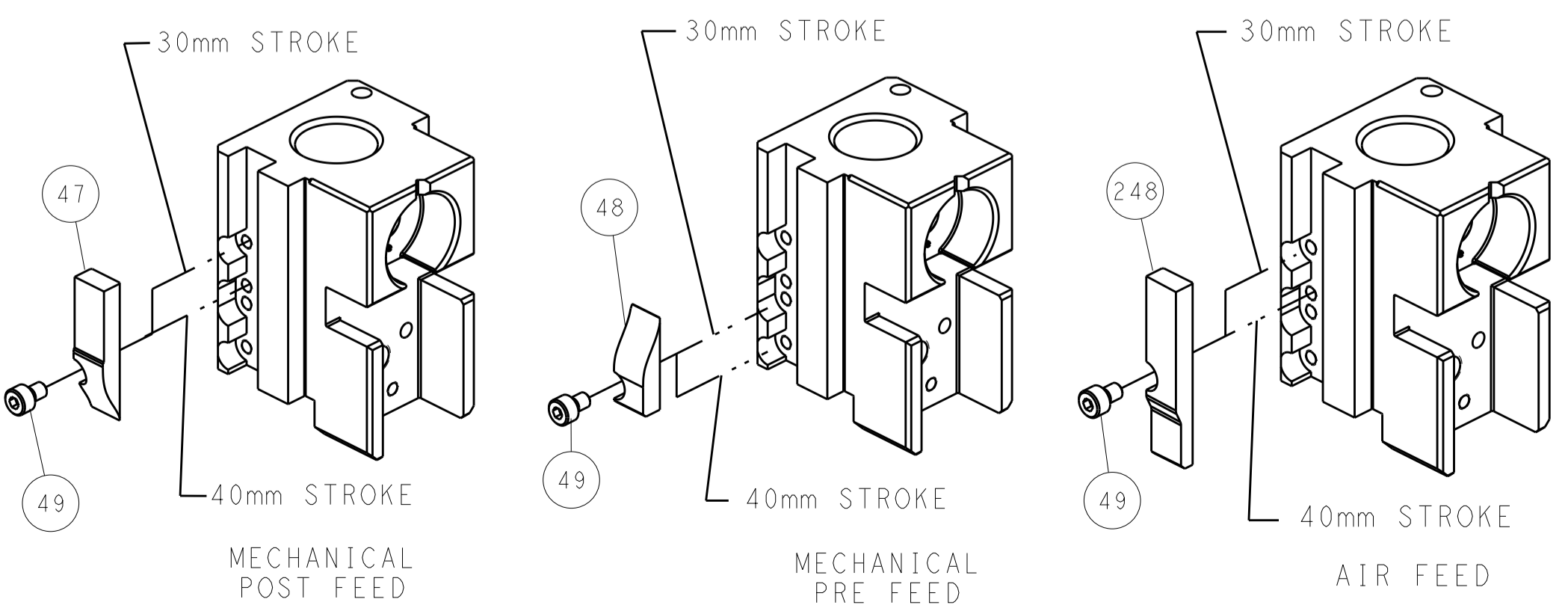
RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL



CAM POSITIONS

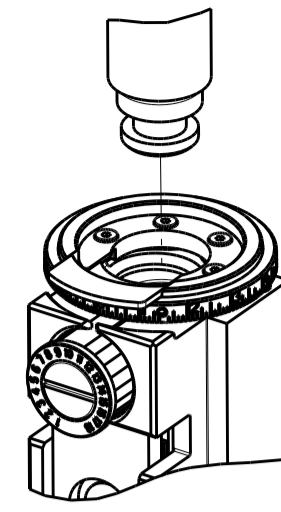


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | |
|--|--|--|---|
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| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2151983 | WEIGHT Customer Accessible Production Drawing | RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV E |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2151983-1 | E | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151983-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151983-7 | C | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.10 mm [.043] | F |
| INSUL | 1.40 mm [.055] | F |

APPLICATOR INSTRUCTIONS
408-35042

| | |
|--|---|
| TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION | |
| TERMINAL NAME: TERMINAL | |
| WIRE STRIP LENGTH 2.00-2.50 mm [.079-.098 IN] | INSULATION DIAMETER RANGE Ø0.80-1.50 mm [.031-.059 IN] |
| TERMINAL APPLICATION SPECIFICATION ATAD-P0514-283 Rev 1 | |
| TERMINALS APPLIED | |
| TE TERMINAL 2113350-1 | HIROSE TERMINAL GT8-2428SCF |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|------------------------------|--------------------------------|
| 24 AWG | 0.64+/-0.04 [.0252+/- .0016] | 7.2 |
| 26 AWG | 0.60+/-0.04 [.0232+/- .0016] | 7.6 |
| 28 AWG | 0.58+/-0.04 [.0228+/- .0016] | 7.8 |



- 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. 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)

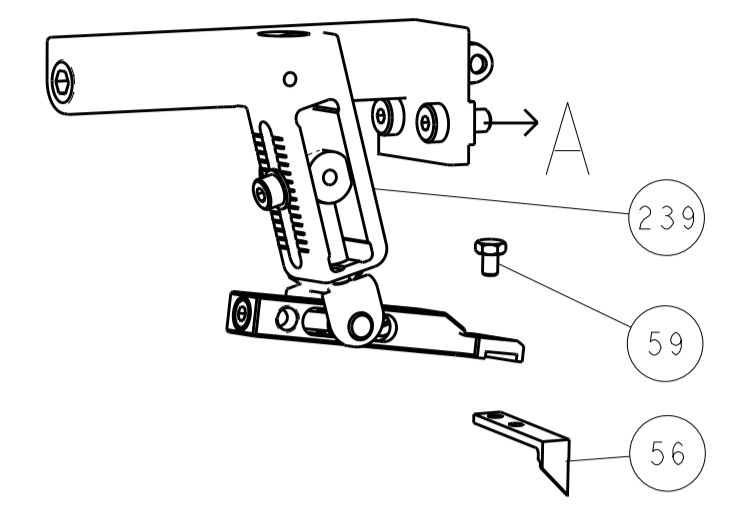
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| REV | DATE | DESCRIPTION | DATE | BY | APPV |
|-----|------|-------------|------|----|------|
| - | - | SEE SHEET 1 | - | - | - |
| - | 1 | 2119640-1 | | | 250 |
| - | 1 | 1803259-1 | | | 249 |
| - | 1 | 2119082-4 | | | 244 |
| - | 1 | 2079764-1 | | | 243 |
| - | 1 | 2119083-1 | | | 242 |
| - | 1 | 7-18023-7 | | | 241 |
| - | - | 2119580-1 | | | 239 |
| - | 1 | 2063440-1 | | | 238 |
| - | 2 | 21045-3 | | | 172 |
| - | REF | 994970-2 | | | 164 |
| - | 1 | 240638-1 | | | 163 |
| - | 1 | 2119641-2 | | | 151 |
| - | 1 | 2168083-8 | | | 144 |
| - | 4 | 2168083-9 | | | 143 |
| - | - | 2119653-2 | | | 142 |
| - | 1 | 1-1803583-0 | | | 141 |
| - | 1 | 1803516-1 | | | 140 |
| - | 1 | 3-23627-7 | | | 137 |
| - | 1 | 2119799-1 | | | 136 |
| - | 1 | 1-18028-2 | | | 119 |
| - | 1 | 2844908-1 | | | 99 |
| - | 1 | 2844907-1 | | | 98 |
| - | 1 | 455888-5 | | | 82 |
| - | 1 | 1803607-1 | | | 71 |
| - | 1 | 2119791-9 | | | 70 |
| - | 1 | 2119740-1 | | | 67 |
| - | 2 | 2168078-1 | | | 66 |
| - | 1 | 5-18022-5 | | | 59 |
| - | 1 | 1338685-1 | | | 56 |
| - | 1 | 18023-9 | | | 49 |
| - | - | 2119652-1 | | | 48 |
| - | 1 | 1803602-1 | | | 41 |
| - | 1 | 2-1752356-6 | | | 34 |
| - | 2 | 2079383-5 | | | 33 |
| - | 2 | 2-2844962-4 | | | 30 |
| - | 1 | 2844992-1 | | | 29 |
| - | 1 | 1320928-2 | | | 24 |
| - | 1 | 2168083-2 | | | 21 |
| - | 1 | 1-18028-2 | | | 20 |
| - | 1 | 2119533-1 | | | 19 |
| - | 1 | 2119806-1 | | | 13 |
| - | 1 | 3-22280-3 | | | 12 |
| - | 1 | 1-356885-3 | | | 11 |
| - | 1 | 2119805-1 | | | 10 |
| - | 1 | 1803095-6 | | | 9 |
| - | 1 | 1803335-4 | | | 8 |
| - | - | - | | | 7 |
| - | - | - | | | 6 |
| - | 1 | 1-2119757-8 | | | 5 |
| - | 1 | 238011-6 | | | 4 |
| - | 1 | 1803326-4 | | | 3 |
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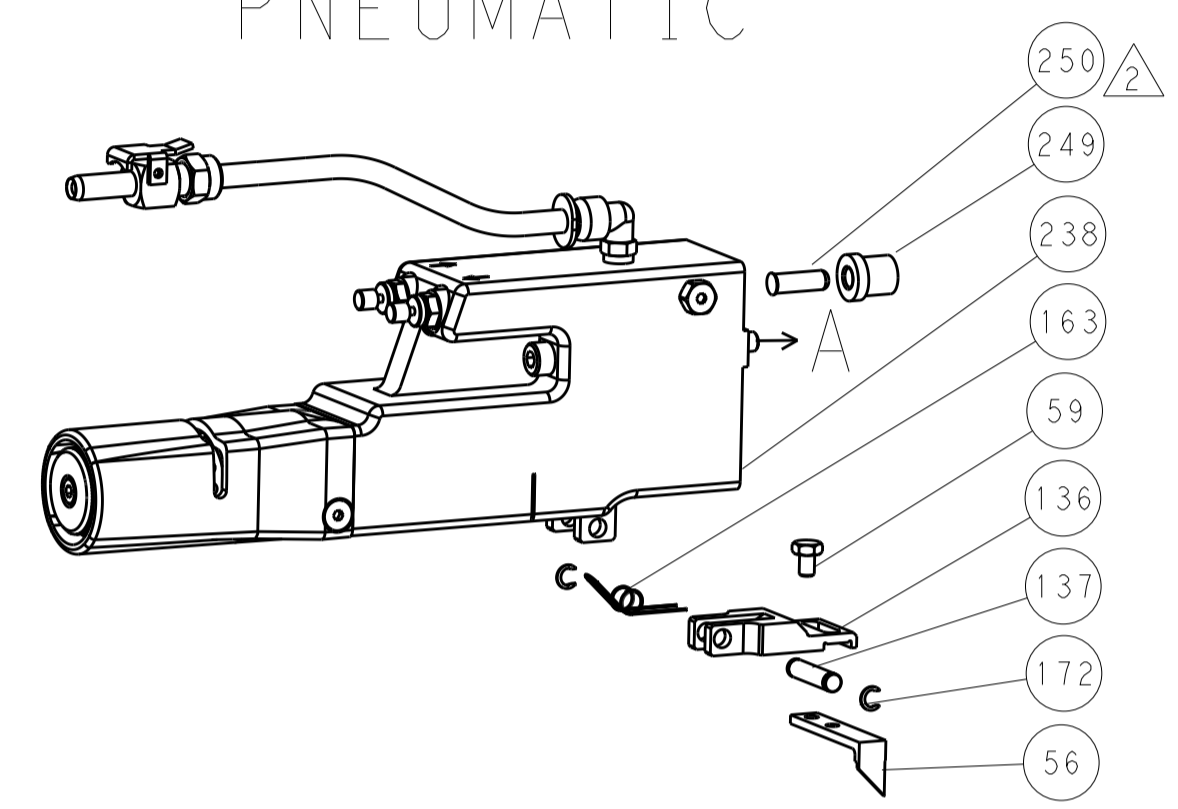
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| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: BOB HIGMAN 14AUG2013 | | CHK: T. ELBIN 14AUG2013 | | APVD: M. CLIFFORD 14AUG2013 | | NAME: Ocean Side Feed Applicator | |
| 0 PLC ± | | 1 PLC ± | | 2 PLC ± | | 3 PLC ± | | 4 PLC ± | | RESTRICTED TO | |
| MATERIAL: - | | FINISH: - | | WEIGHT: - | | SCALE: 1:2 | | SHEET 3 OF 4 | | REV E | |

| LOC | | DIST | | REVISIONS | | | |
|-----|-----|-------------|------|-----------|------|--|--|
| P | LTN | DESCRIPTION | DATE | DMN | APVD | | |
| - | - | SEE SHEET 1 | - | - | - | | |

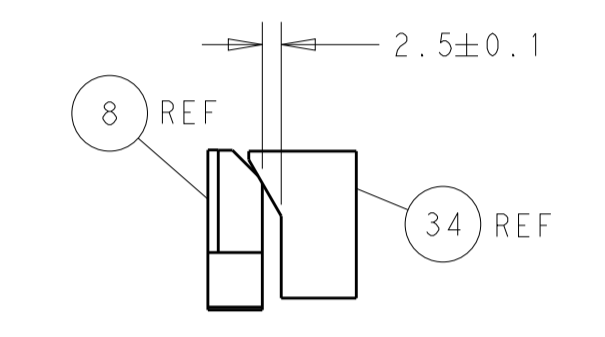
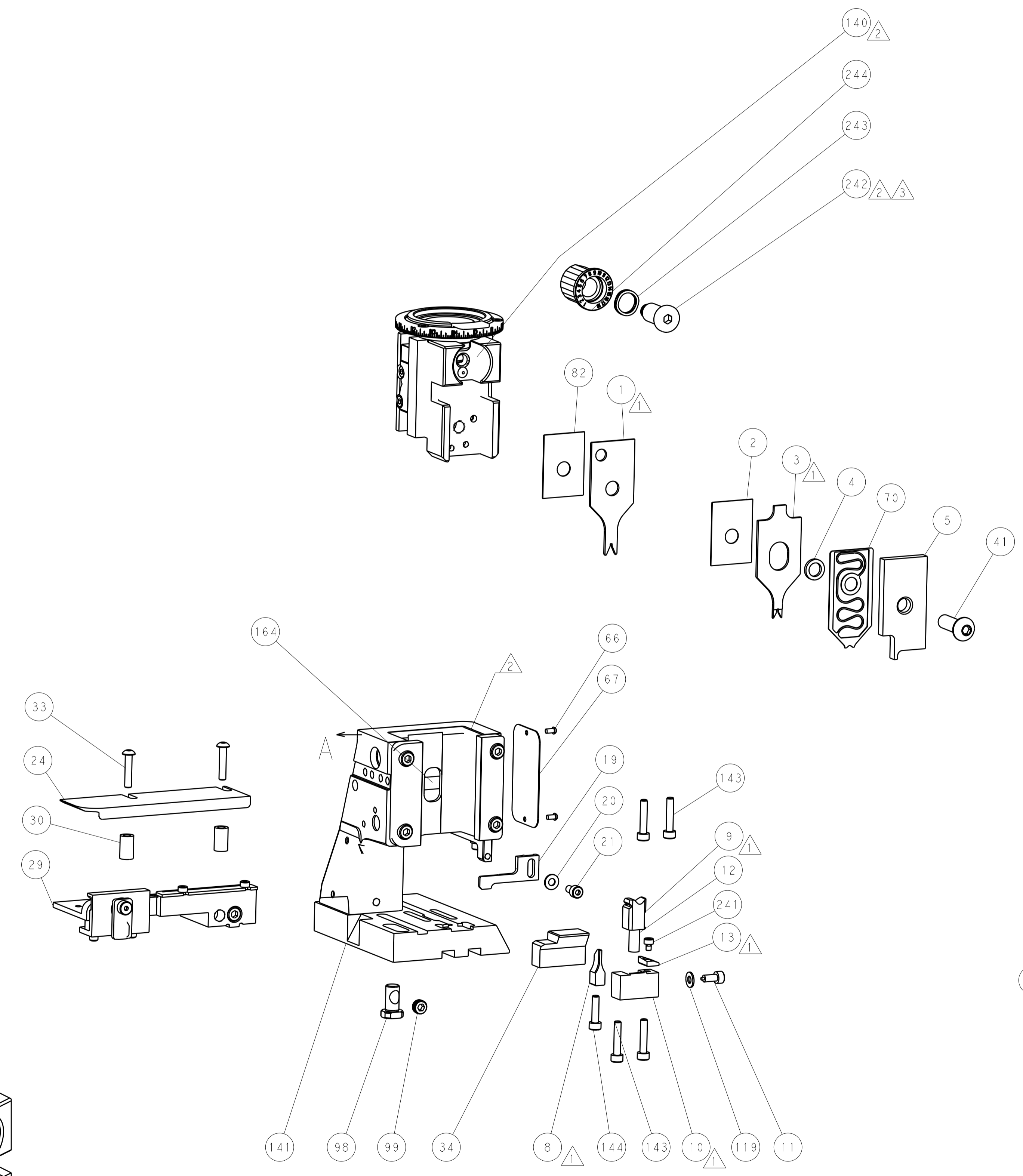
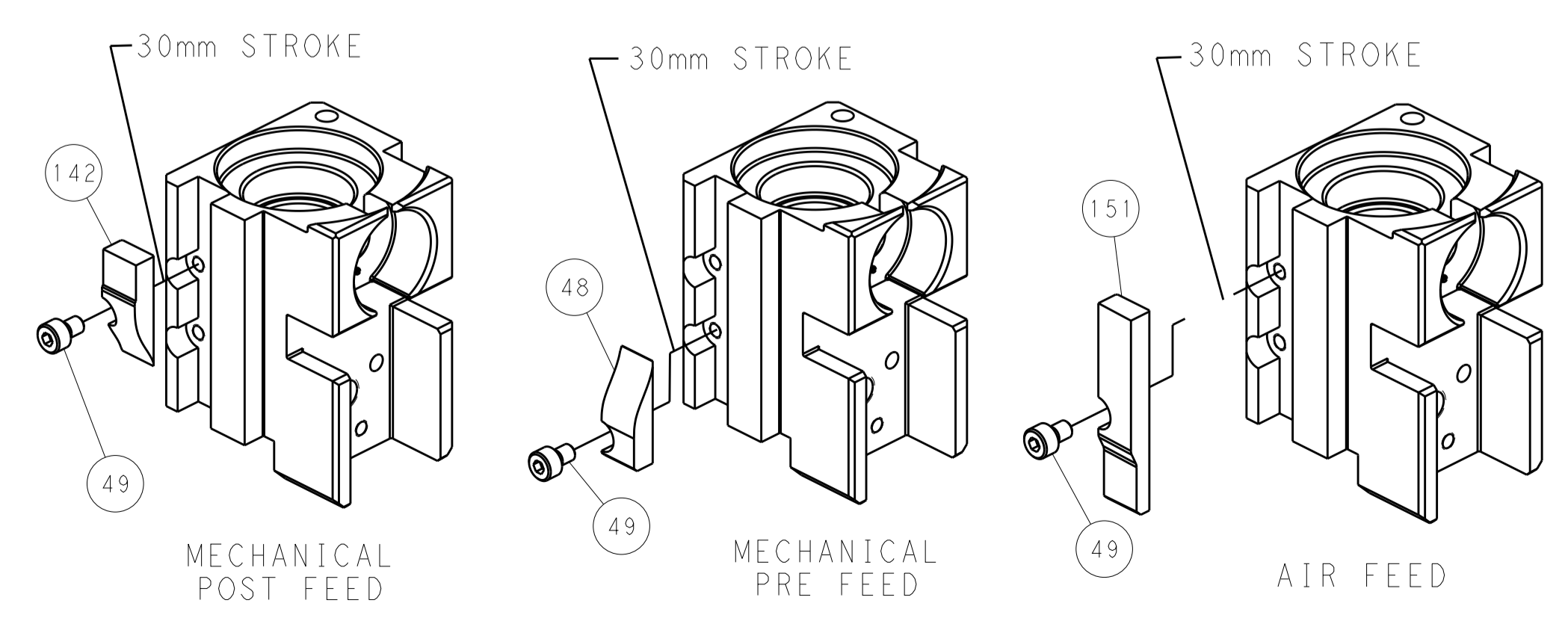
FEED TYPE MECHANICAL



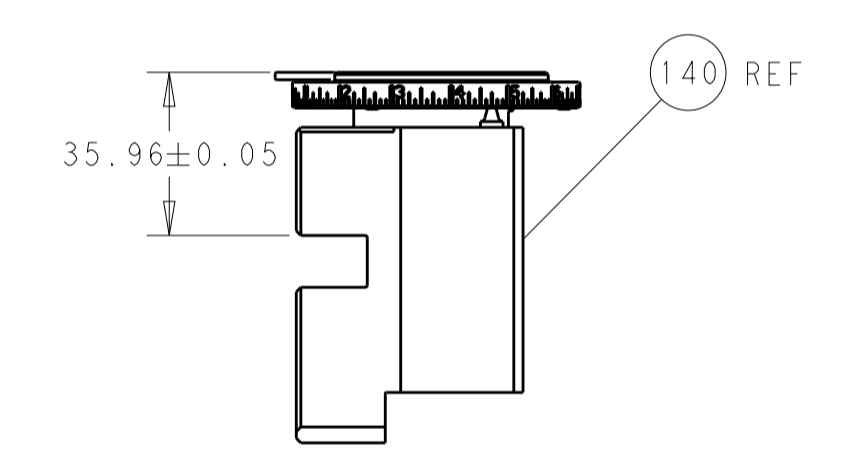
PNEUMATIC



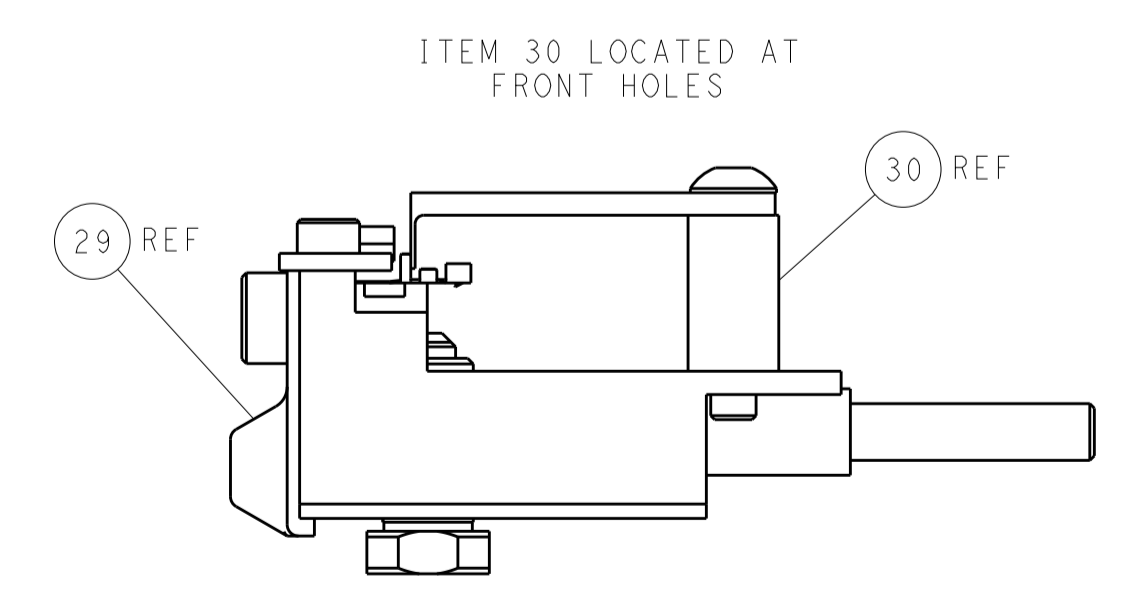
CAM POSITIONS



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)

| | | | |
|---|--|--|--|
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| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2151983 | RESTRICTED TO Customer Accessible Production Drawing SCALE 1:2 SHEET 4 OF 4 REV E |