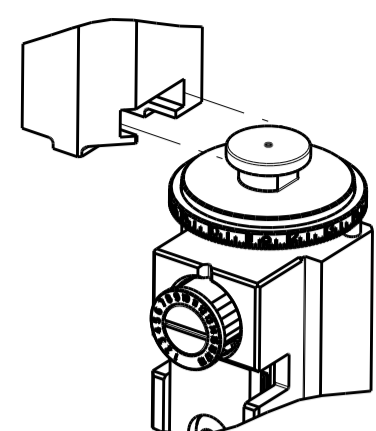


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151107-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151107-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151107-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

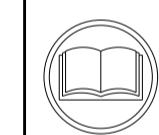


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.55 mm [.140]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH 5.70-6.30 mm [.224-.248 IN]		INSULATION DIAMETER RANGE Ø2.10-3.10 mm [.083-.122 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18365	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927854-1	927854-2	927854-3	927854-6
927854-7	927854-8	927854-9	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.04 +/- 0.05 [.080 +/- .002]	6.6
2.00mm2	1.90 +/- 0.05 [.075 +/- .002]	8.4
1.50mm2	1.76 +/- 0.05 [.069 +/- .002]	10.1



- 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.
 - TERMINAL LUBRICANT IS RECOMMENDED.
7. 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.

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	CHKD
		B	ECR-13-001252	22JAN2013	RK GB
		C	ECR-18-007903	23MAY2018	YY JDG
		D	ECR-18-019058	05DEC2018	MZ CT
		E	ECR-19-005860	11APR2019	FJ TE

-	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
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	318563-1	GUARD, FRONT CHIP	119
-	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	455888-6	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	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	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1-1752356-8	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-2	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	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	2	1338696-1	ANVIL, COMBINATION	8
-	1	1	1-240641-6	SPACER	7
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1633963-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	2	6-456408-0	CRIMPER, WIRE PREMIUM	1

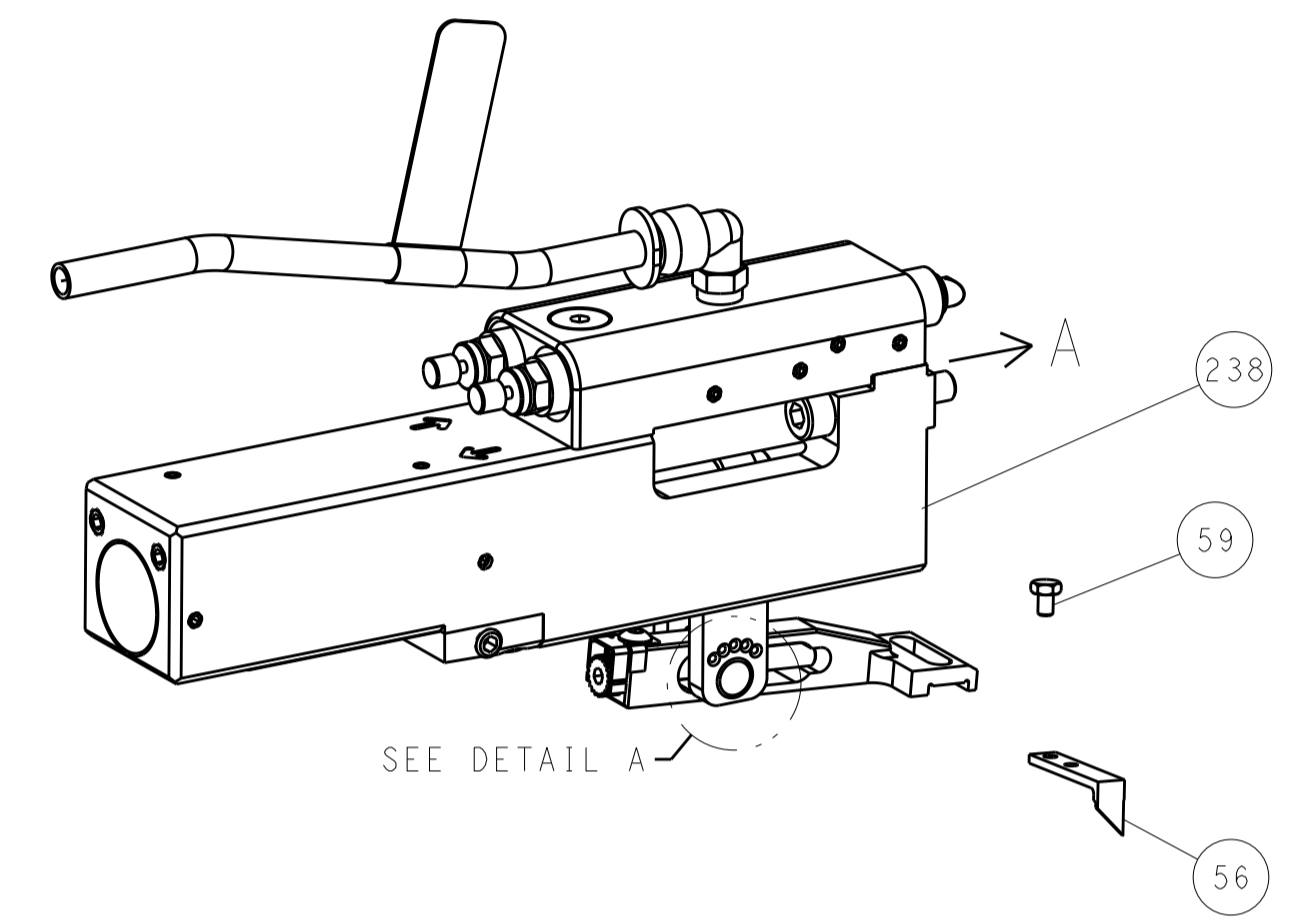
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC ±	1 PLC ±	2 PLC ±	S. ZOU	02JUN2011	G. BAILEY	02JUN2011
	3 PLC ±	4 PLC ±	ANGLES ±	TE Connectivity Harrisburg, PA 17105-3608			
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing			
			1:2	SHEET 1 OF 4			

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

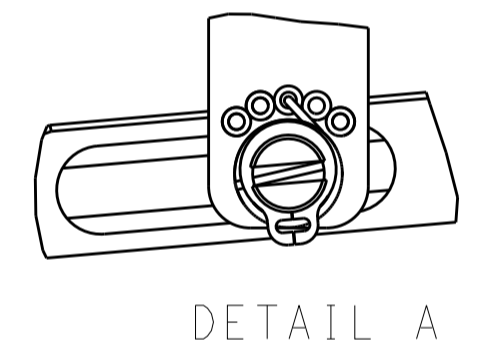
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

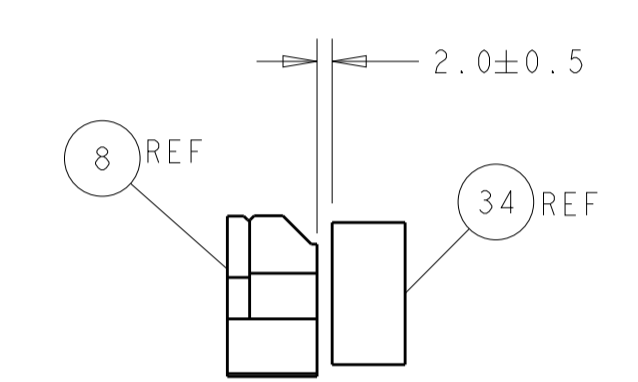
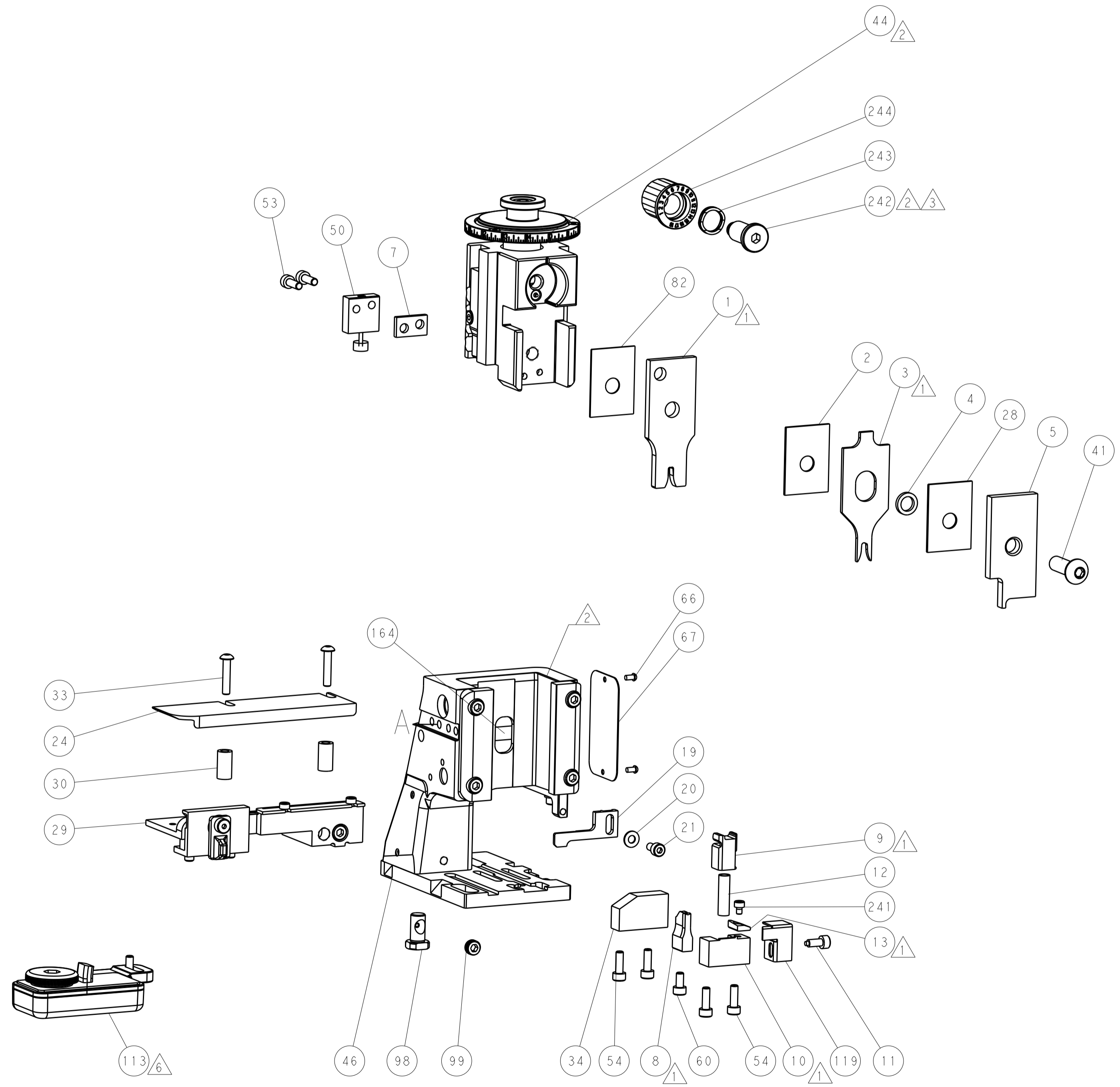
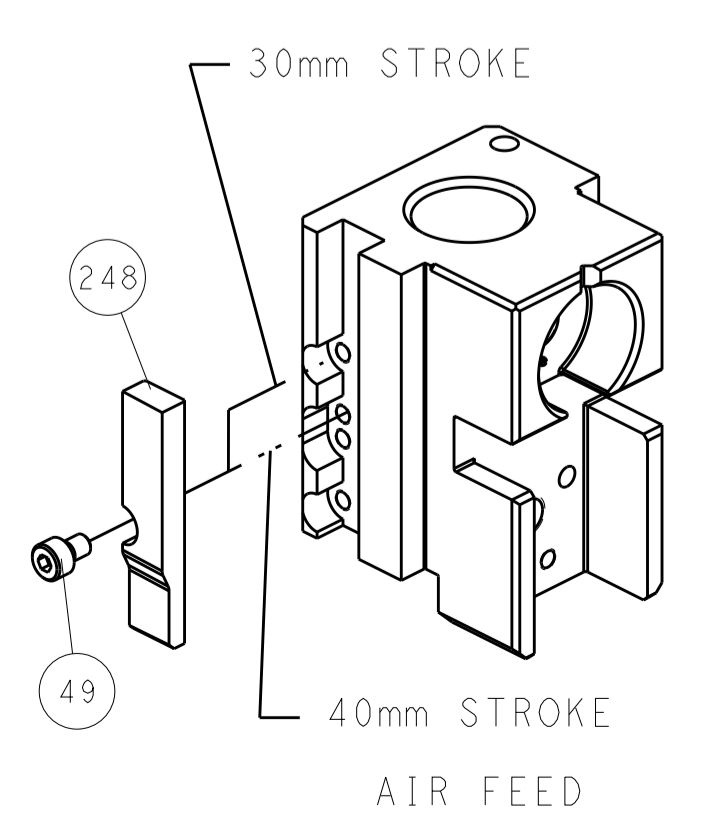


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

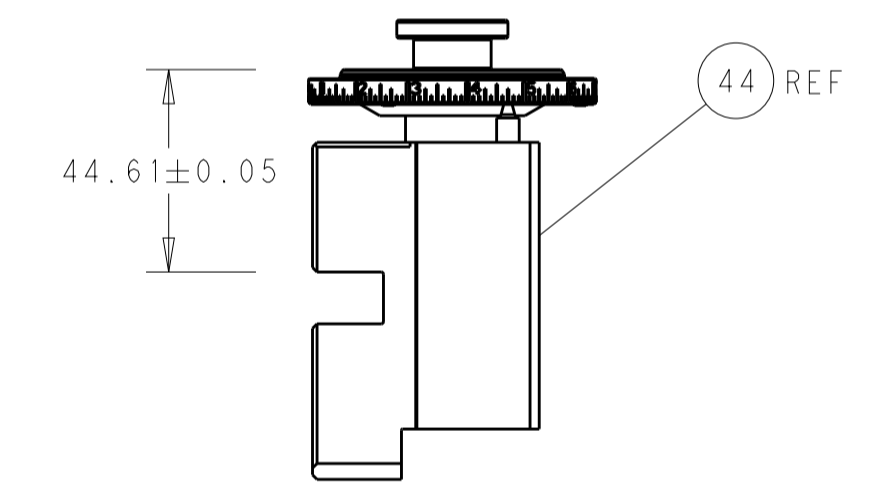


DETAIL A

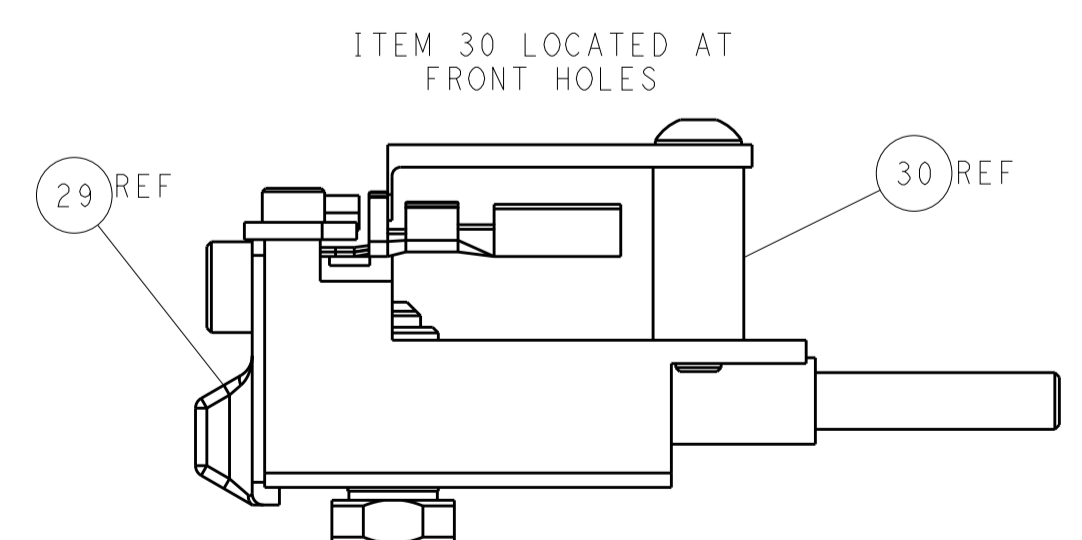
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



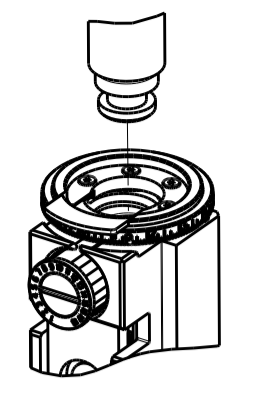
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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:		DWN S.ZOU 02JUN2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK G.BAILEY 02JUN2011		NAME	
				S.XI 02JUN2011		Ocean Side Feed Applicator	
				APVD		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				S.XI		A1 00779 C=2151107	
				WEIGHT		Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151107-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151107-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.55 mm [.140]	OV

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: POSITIVE LOCK RECEPTACLE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.70-6.30 mm [.224-.248 IN]	∅2.10-3.10 mm [.083-.122 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927854-1	927854-2	927854-3	927854-6
927854-7	927854-8	927854-9	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.04+/-0.05 [.080+/-0.002]	6.6
2.00mm2	1.90+/-0.05 [.075+/-0.002]	8.4
1.50mm2	1.76+/-0.05 [.069+/-0.002]	10.1



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - 6 TERMINAL LUBRICANT IS RECOMMENDED.
7. 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.

LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	1	2119082-9		CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	2079764-1		WASHER, WAVE SPRING, CREST-TO-CREST			243
3	-	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
-	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	318563-1		GUARD, FRONT CHIP			119
6	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED			113
-	1	2844908-1		SCREW, LOCKING			99
-	1	2844907-1		POST, LOCKING			98
-	1	455888-6		SPACER, CRIMPER			82
-	1	1803607-3		DOCUMENTATION PACKAGE			71
-	1	2119740-1		TAG, IDENTIFICATION			67
-	2	2168078-1		SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	1	5-18022-5		SCR, HEX HD CAP, M4 X 6.0			59
-	1	1338685-1		PAWL, FEED			56
-	2	2168083-3		SCR, SKT HD CAP, RoHS, M4 X 12.0			53
-	1	1803382-6		HOLD DOWN, SPRING LOADED			50
-	1	18023-9		SCR, SKT HD CAP M4 X 6.0			49
-	1	1803602-1		SCR, BHSC, RoHS (M8 X 25)			41
-	1	1-1752356-8		SUPPORT, TERMINAL			34
-	2	2079383-5		SCR, BHSC, RoHS (M4 X 20)			33
-	2	3-2844962-0		SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	2844992-1		ASSEMBLY, STRIP GUIDE			29
-	1	1-455888-0		SPACER, CRIMPER			28
-	1	1320928-2		STRIP GUIDE			24
-	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	-	1	3-22280-3	SPRING, COMPRESSION			12
-	1	1-356885-4		STOP, SHEAR			11
-	1	2119805-1		SHEAR HOLDER, FRONT			10
1	-	1	454276-5	FLOATING SHEAR, FRONT			9
1	1	1	1338696-1	ANVIL, COMBINATION			8
1	-	1	1-240641-6	SPACER			7
-	1	2119757-8		DEPRESSOR, SHEAR			5
-	1	2-238011-2		BLOCK, CRIMPER SPACER			4
1	1	1	1633963-2	CRIMPER, INSULATION OVERLAP PREMIUM			3
-	1	1	1-455888-0	SPACER, CRIMPER			2
1	1	1	6-456408-0	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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN S.ZOU 02JUN2011 CHK G.BAILEY 02JUN2011 APPV S.XI 02JUN2011		NAME Ocean Side Feed Applicator	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151107		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 3 OF 4	

