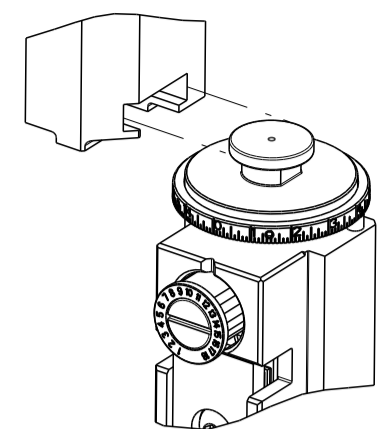


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151661-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151661-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151661-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.19 mm [.165]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JPT LITEALUM CONTACT, SWS			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.20-4.80 mm [.165-.189 IN]		Ø2.88-3.04 mm [.113-.120 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94204	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
2-2208043-1		963292-1		2.0-2.7mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.56+/-0.04 [.0614+/- .0016]	7.5



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 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.
- 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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	F		ECR-15-015265	19OCT2015	MR	JDG
		G		ECR-18-018240	21NOV2018	MZ	KZ
		H		ECR-19-000059	03JAN2019	RK	GB

-	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	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2063440-1	AIR FEED MODULE	238	
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	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	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	455888-2	SPACER, CRIMPER	82	
-	1	1	1803607-1	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	
6	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1803382-7	HOLD DOWN, SPRING LOADED	50	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	2-1803583-3	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	1752356-4	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1320928-2	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	690472-2	STRIPPER	19	
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	2	1	1	1803318-1	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	1	1	1633996-3	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	2	1	1	456407-5	CRIMPER, WIRE PREMIUM	1

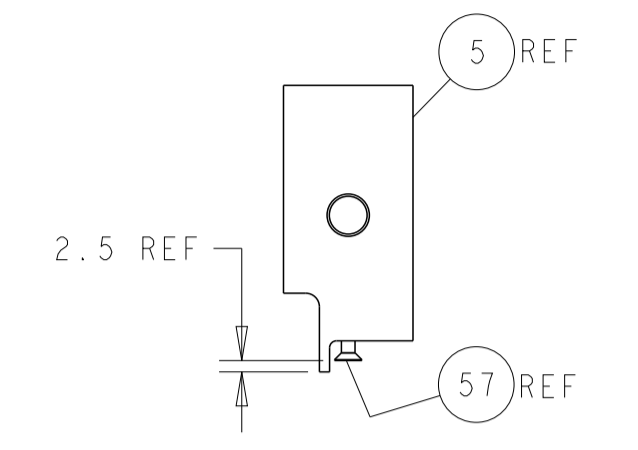
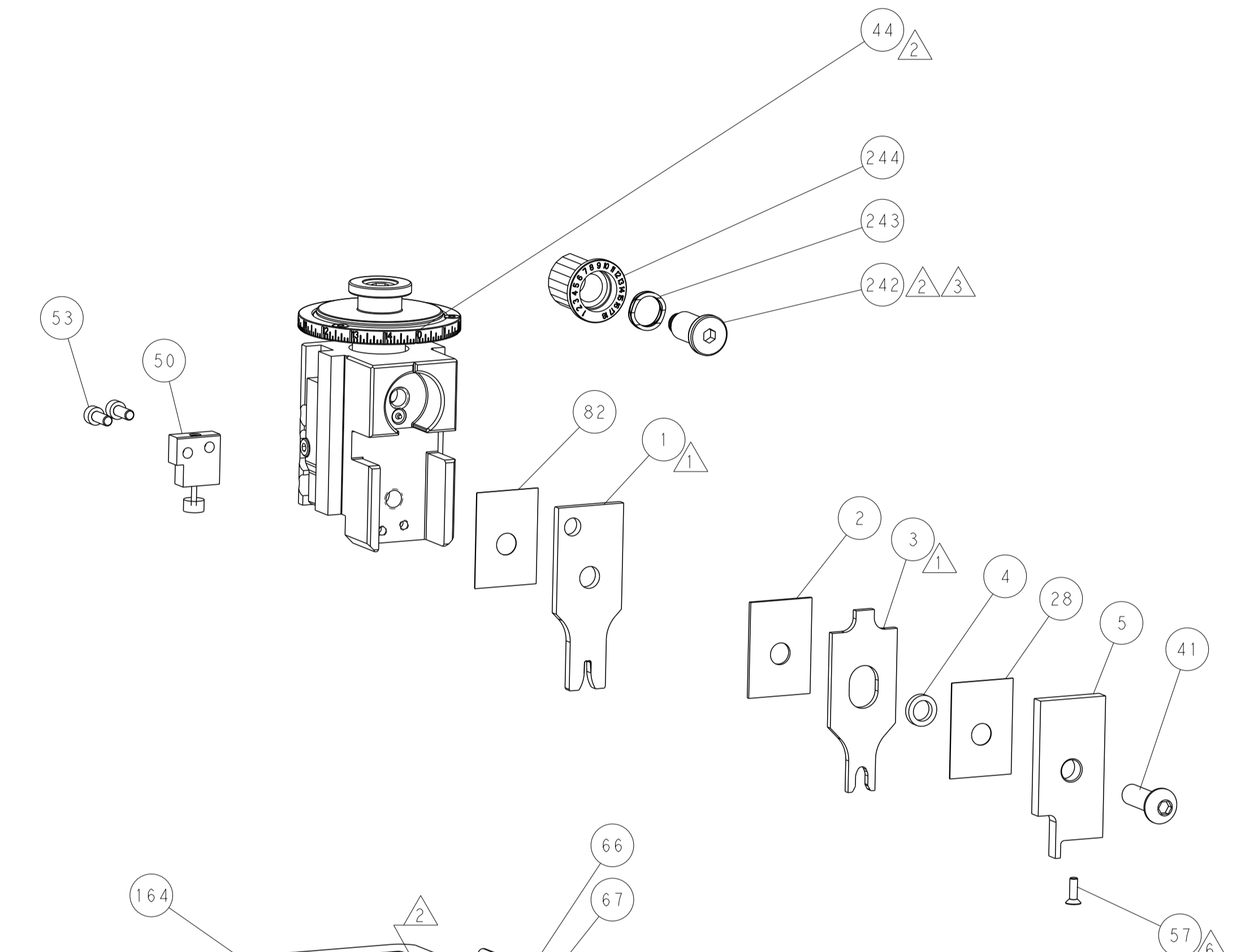
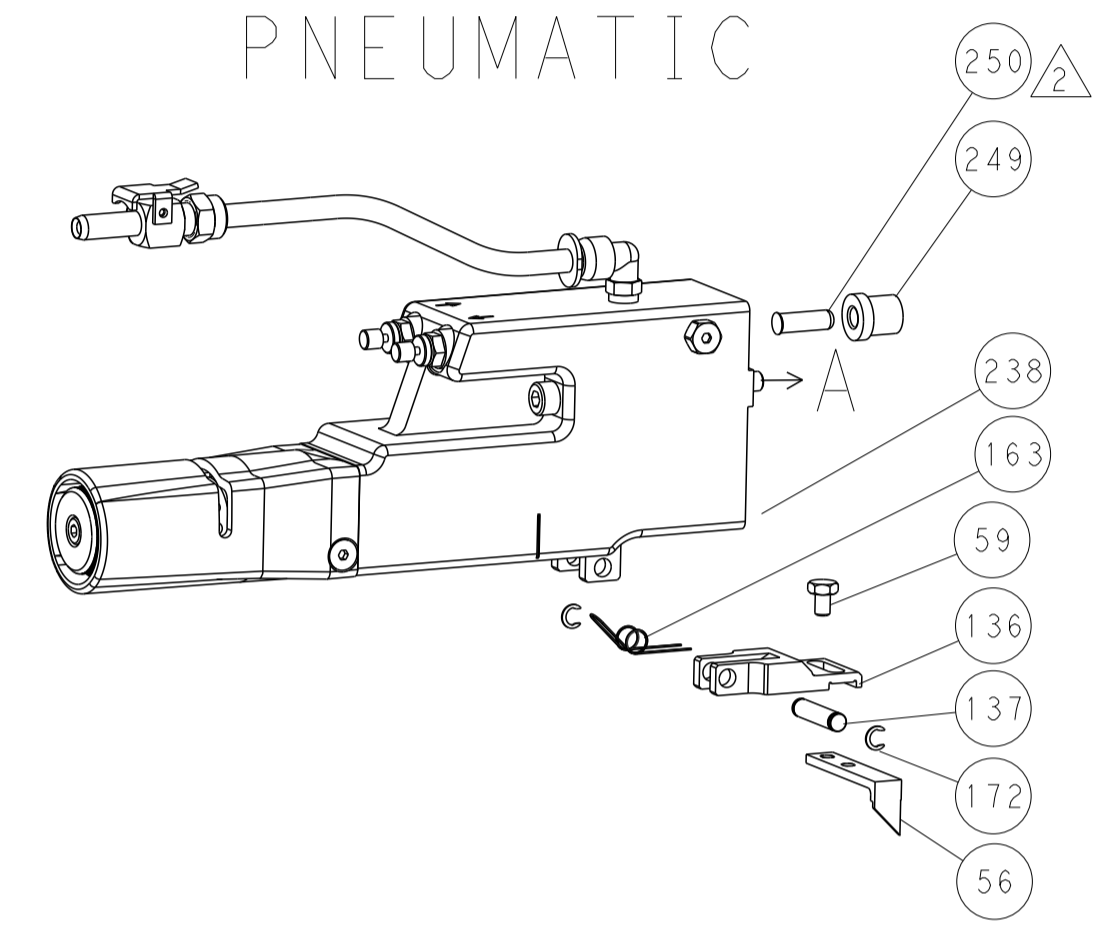
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL		WEIGHT			

OWN	Y. YIN	16MAY2012	
CHK	G. BAILEY	16MAY2012	
APVD	S. XI	16MAY2012	
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151661	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV H

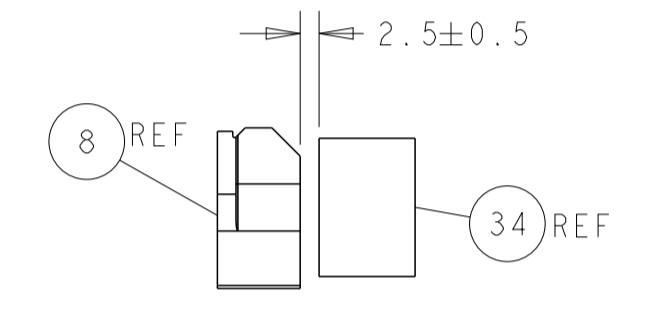
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

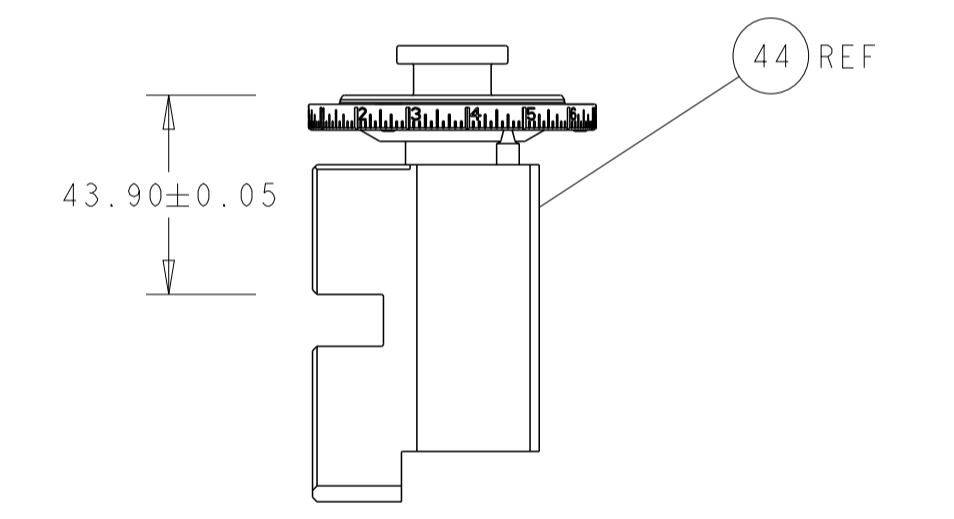
FEED TYPE PNEUMATIC



SHEAR DEPRESSOR DETAIL

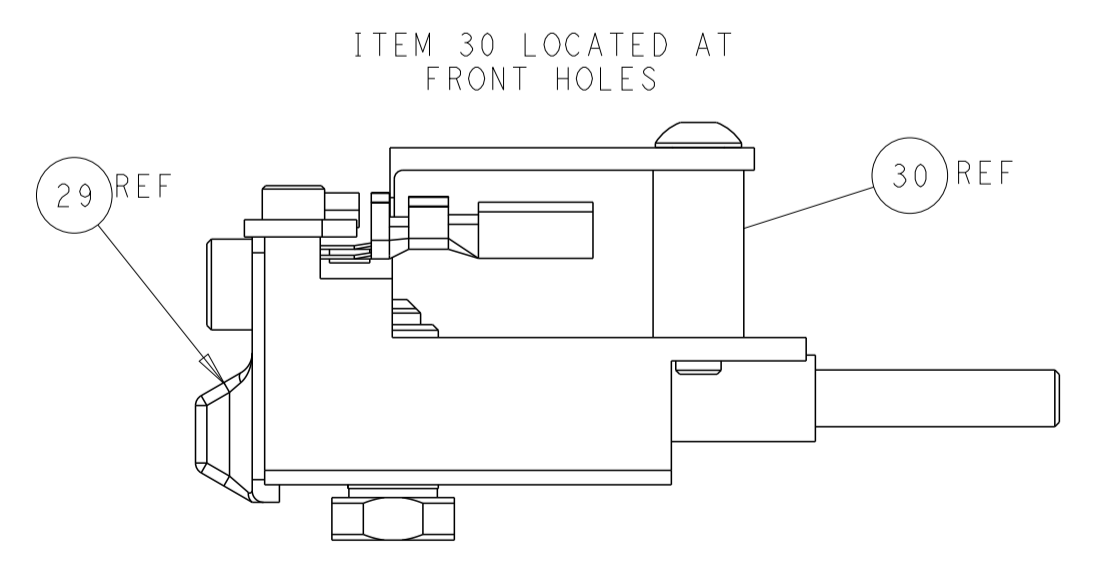
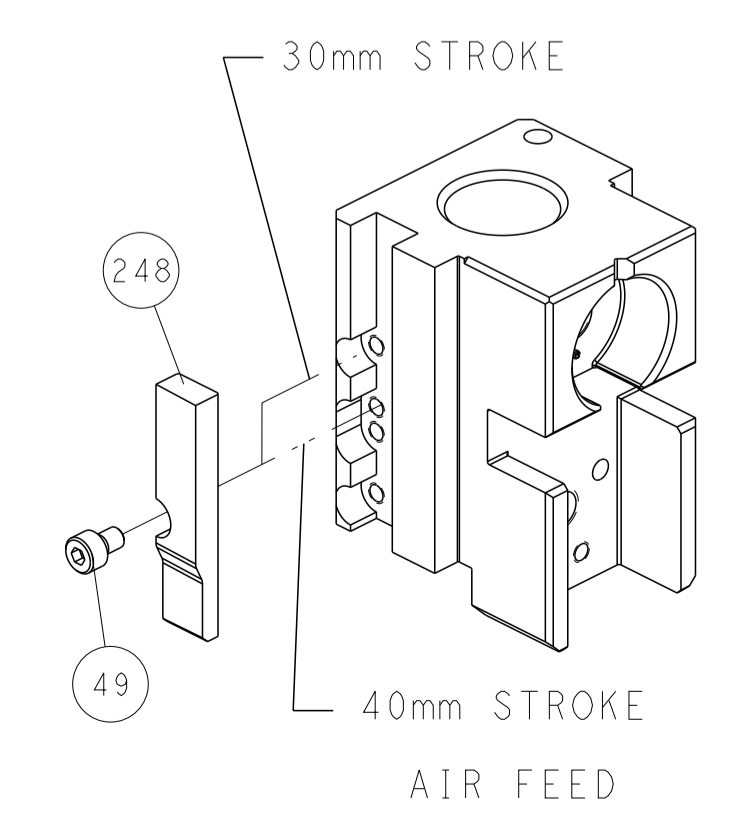


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITIONS



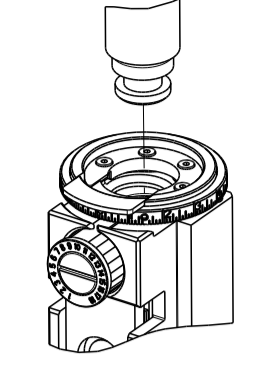
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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. BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN Y. YIN 16MAY2012 CHK G. BAILEY 16MAY2012 APVD S. XI 16MAY2012	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 CAGE CODE DRAWING NO. A1 00779 C=2151661 WEIGHT SCALE 1:2 SHEET 2 OF 4 REV H	RESTRICTED TO
MATERIAL:		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151661-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151661-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.19 mm [.165]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: JPT LITEALUM CONTACT, SWS		
WIRE STRIP LENGTH 4.20-4.80 mm [.165-.189 IN]		TERMINAL INSULATION DIAMETER RANGE Ø2.88-3.04 mm [.113-.120 IN]
TERMINAL APPLICATION SPECIFICATION 114-94204	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
2-2208043-1		963292-1		2.0-2.7mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm ²	1.56 +/- 0.04 [.0614 +/- .0016]	7.5



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 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.
- 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				

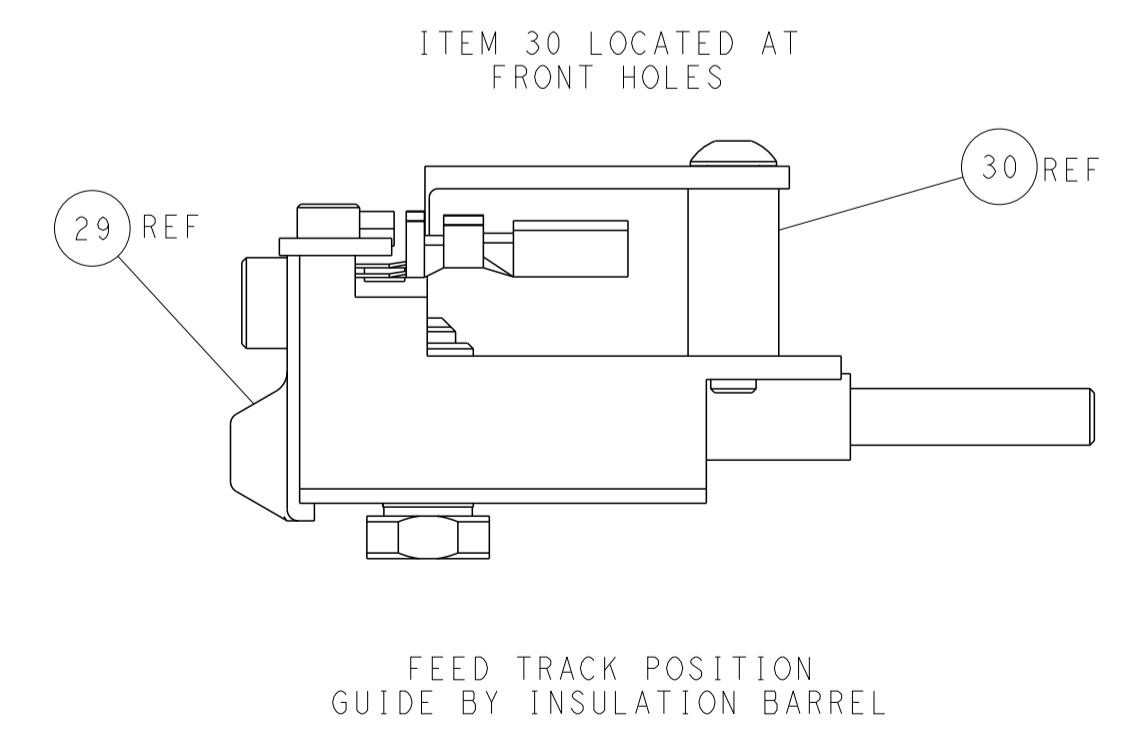
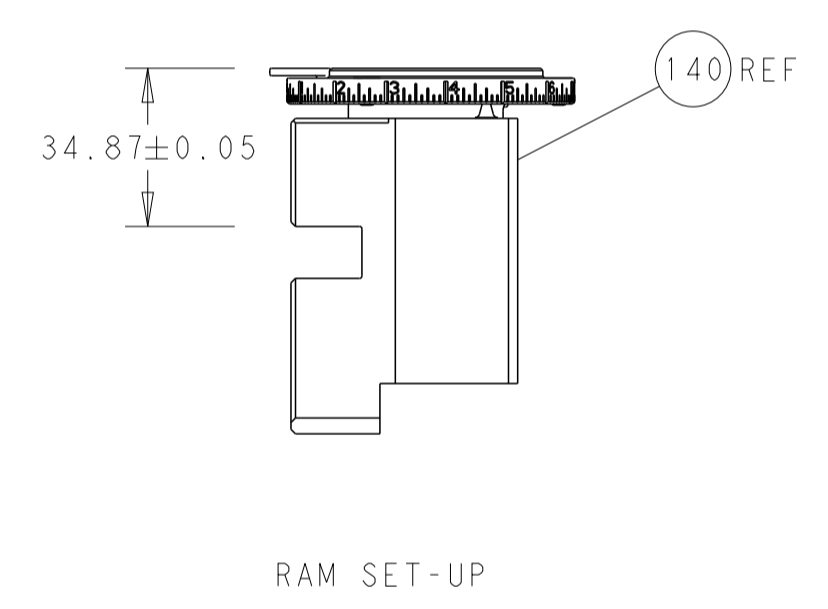
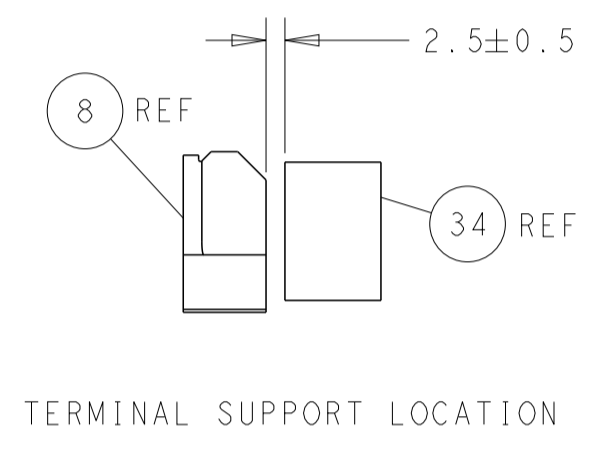
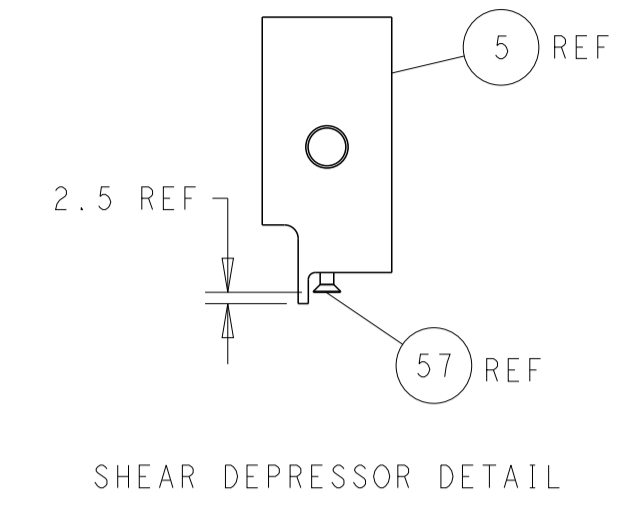
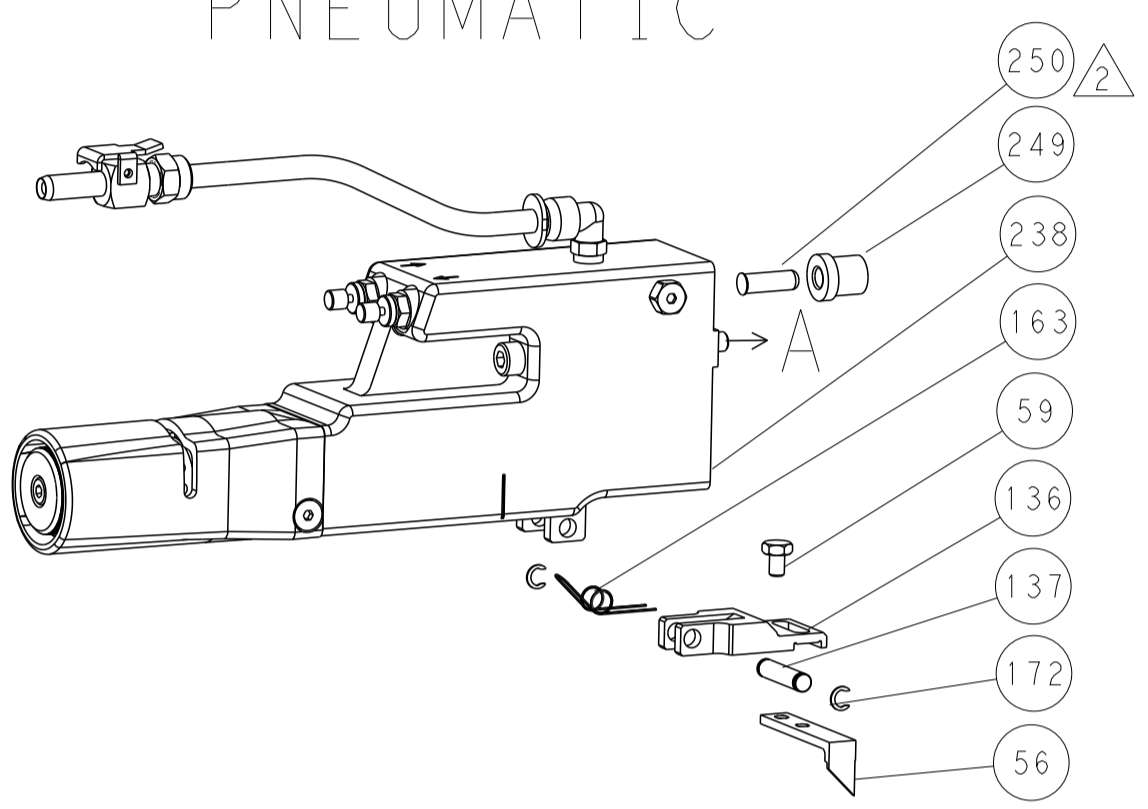
REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	1	2119640-1		PUSH ROD, AIR FEED			250
-	1	1803259-1		BUSHING, FLANGED			249
-	1	2119082-7		CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	2079764-1		WASHER, WAVE SPRING, CREST-TO-CREST			243
-	1	2119083-1		RETAINER, INSULATION DIAL			242
-	1	7-18023-7		SCR, SKT HD CAP M3 X 4.0			241
-	1	2063440-1		AIR FEED MODULE			238
-	2	21045-3		RING, RETAIN, EXTERN, 3/16 CRESCENT			172
-	REF	994970-2		COUNTER, MAGNETIC			164
-	1	240638-1		SPRING, FEED FINGER			163
-	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	2-1803583-4		APPLICATOR BASIC ASSEMBLY, SF			141
-	1	1803516-1		RAM ASSEMBLY, SF PACIFIC			140
-	1	3-23627-7		PIN, RETAIN, GRVD, 3/16 X .854			137
-	1	2119799-1		HOLDER, FEED FINGER, AF			136
-	1	2844908-1		SCREW, LOCKING			99
-	1	2844907-1		POST, LOCKING			98
-	1	455888-2		SPACER, CRIMPER			82
-	1	1803607-1		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	985575-3		SCR, FLT SKT HD CAP M3 X 10.0			57
-	1	1338685-1		PAWL, FEED			56
-	2	1-2168083-0		SCR, SKT HD CAP, RoHS, M4 X 10			53
-	1	1803382-7		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	1752356-4		SUPPORT, TERMINAL			34
-	2	2079383-5		SCR, BHSC, RoHS (M4 X 20)			33
-	2	2-2844962-8		SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	2844992-1		ASSEMBLY, STRIP GUIDE			29
-	1	455888-3		SPACER, CRIMPER			28
-	1	1320928-2		STRIP GUIDE			24
-	1	2168083-2		SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	2	1-18028-2		WASHER, FLAT, REG M4			20
-	1	690472-2		STRIPPER			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	318707-1		FLOATING SHEAR, FRONT			9
1	1	1803318-1		ANVIL, COMBINATION			8
-	-	-		-			7
-	-	-		-			6
-	1	2119781-5		DEPRESSOR, SHEAR			5
-	1	238011-4		BLOCK, CRIMPER SPACER			4
1	1	1633996-3		CRIMPER, INSULATION SPECIAL			3
-	1	1-455888-0		SPACER, CRIMPER			2
1	1	456407-5		CRIMPER, WIRE PREMIUM			1
-	-	-77 -22		PART NO			ITEM NO

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

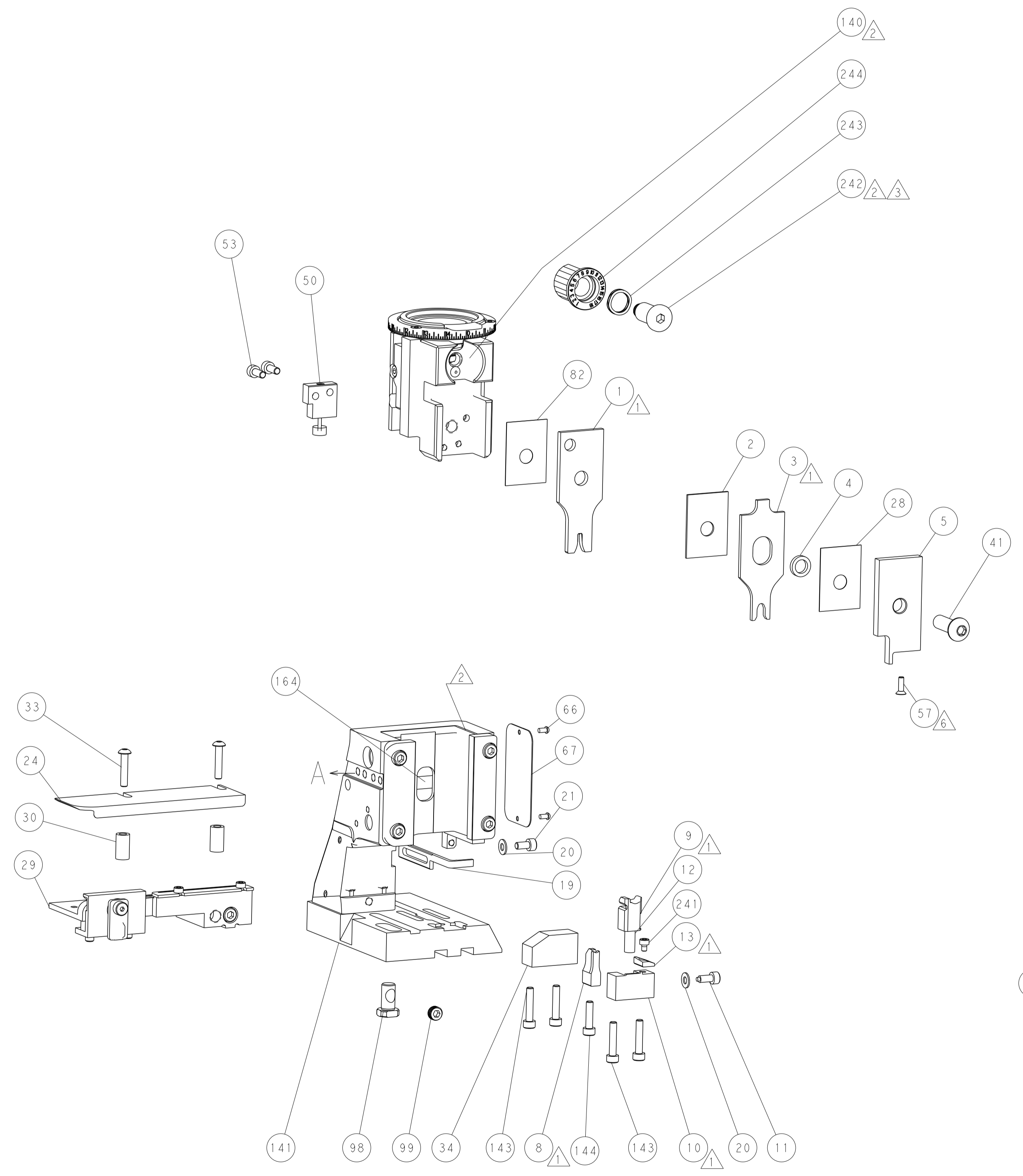
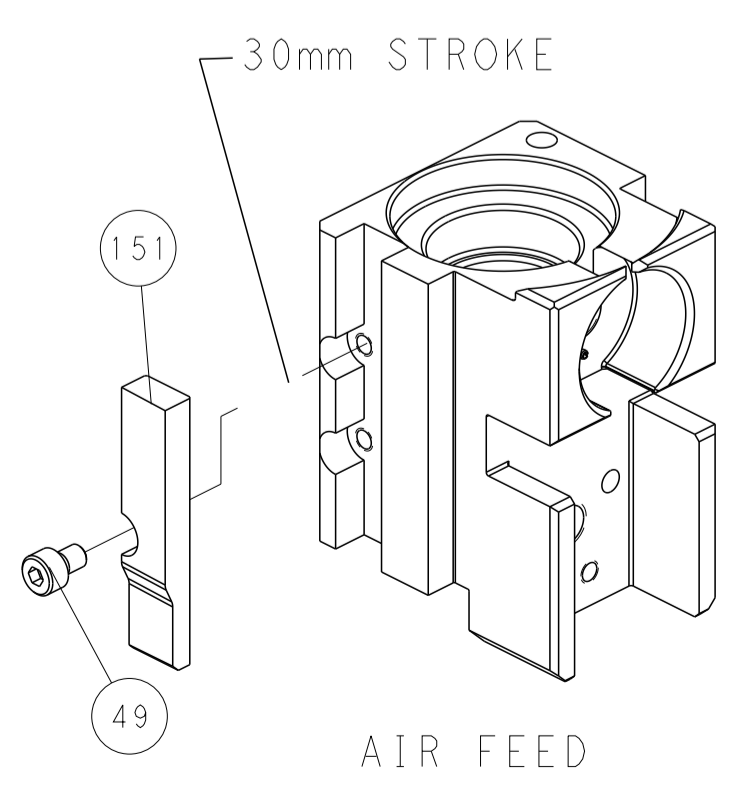
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: Y. YIN 16MAY2012 CHK: G. BAILEY 16MAY2012 APPV: S. XI 16MAY2012		NAME: TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151661		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 3 OF 4 REV H	

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

FEED TYPE PNEUMATIC



CAM POSITIONS



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:		DMN	Y. YIN	16MAY2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	G. BAILEY	16MAY2012	
MATERIAL:		FINISH:		APVD	S. XI	16MAY2012	NAME
				PRODUCT SPEC		Ocean Side Feed Applicator	
				APPLICATION SPEC			
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				WEIGHT	A1	00779	©=2151661
				Customer Accessible Production Drawing		SCALE	1:2
				SHEET		4	OF 4
				REV		H	