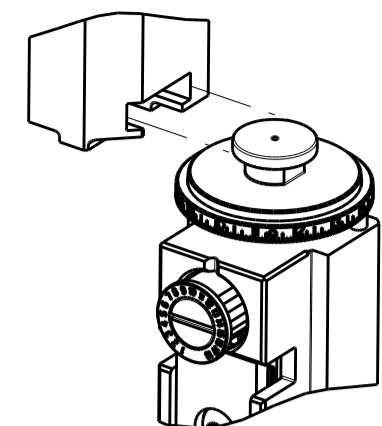


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151811-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151811-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151811-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

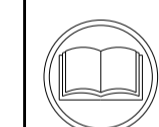


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F

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.

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APP'D
		B	ECR-14-011976	08AUG2014	KH JT
		C	ECR-18-004642	28MAR2018	FL TE
		D	ECR-19-006357	19APR2019	FJ TE
		E	ECR-20-008425	12JUN2020	FZ 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
-	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	1-1633961-7	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:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	

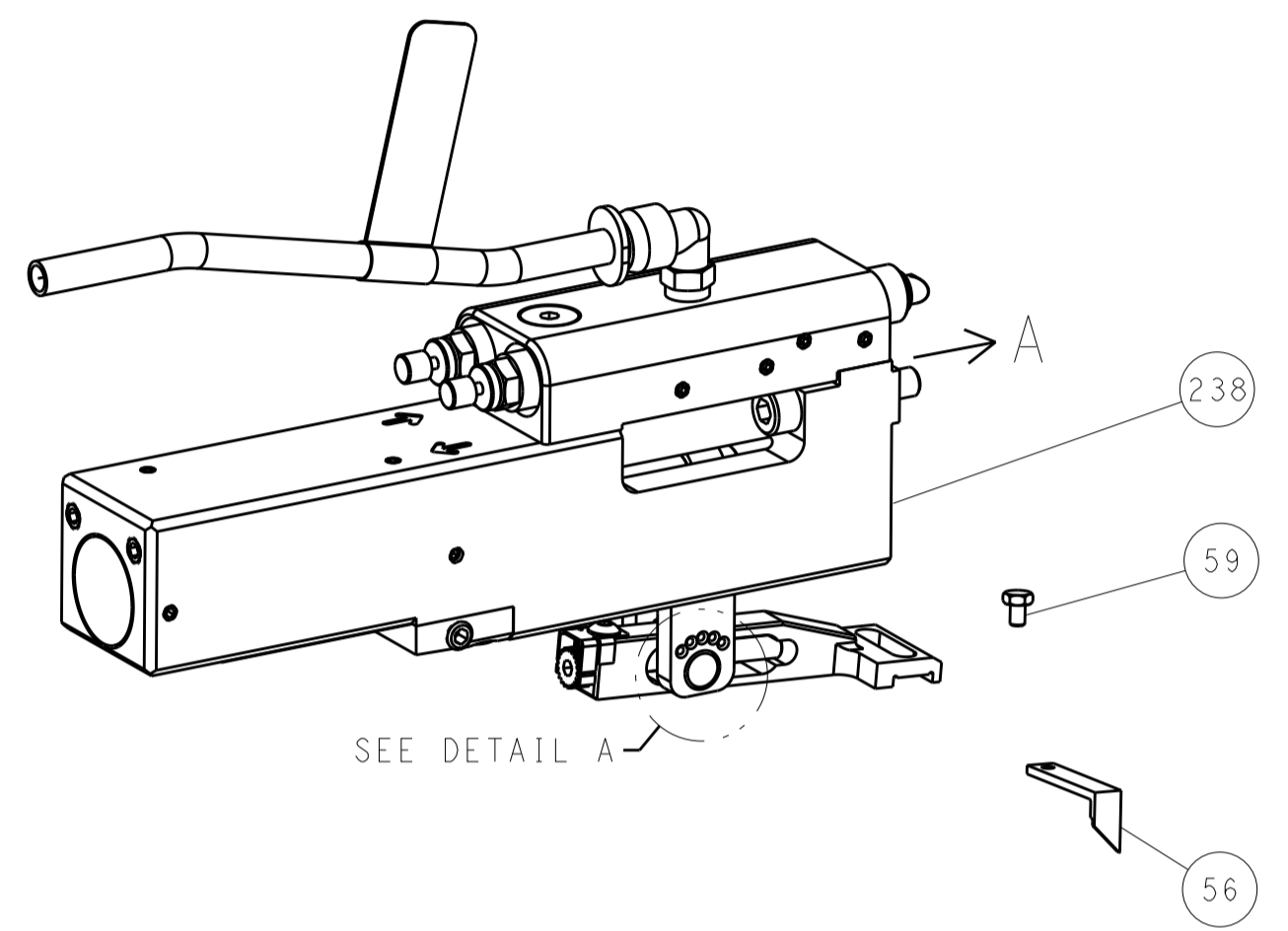
OWN	J. HUANG	13DEC2012	
CHK	S. XI	13DEC2012	
APP'D	S. XI	13DEC2012	
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151811	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV E

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

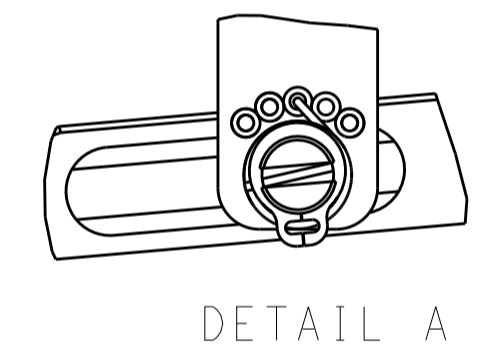
LOC	DIST	REVISIONS					
		P.	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

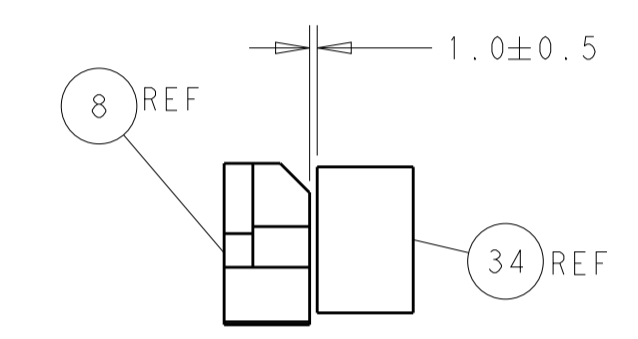
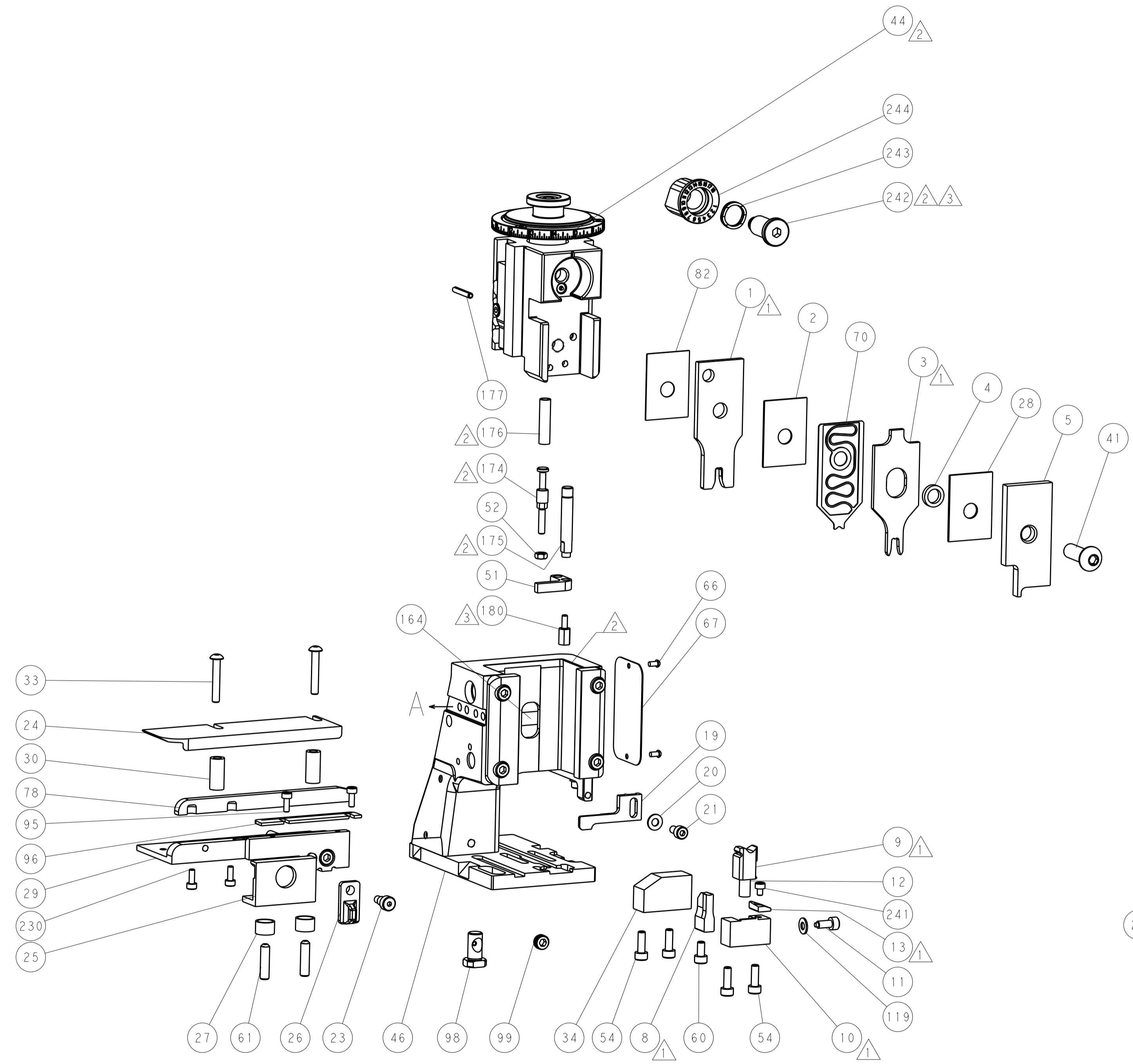
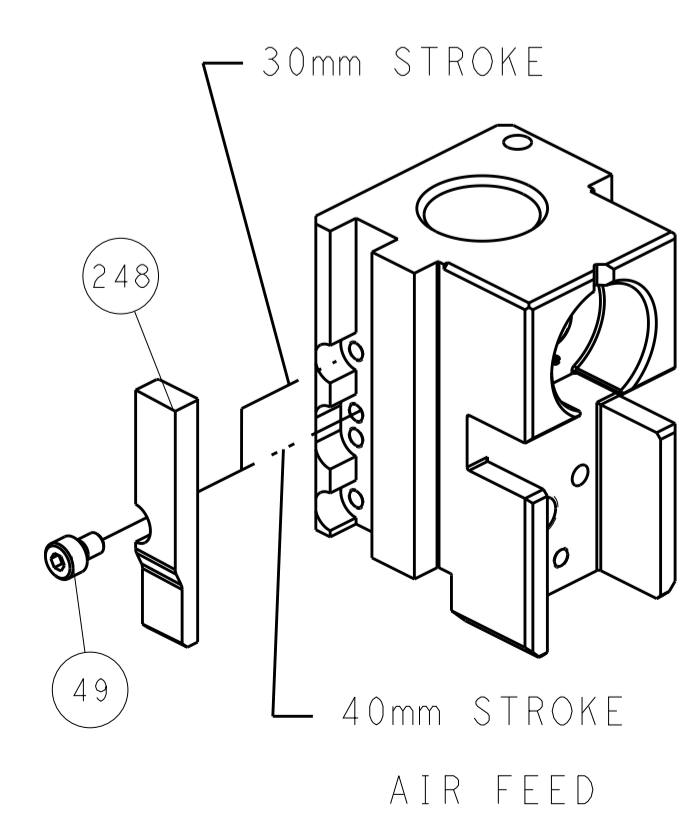


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

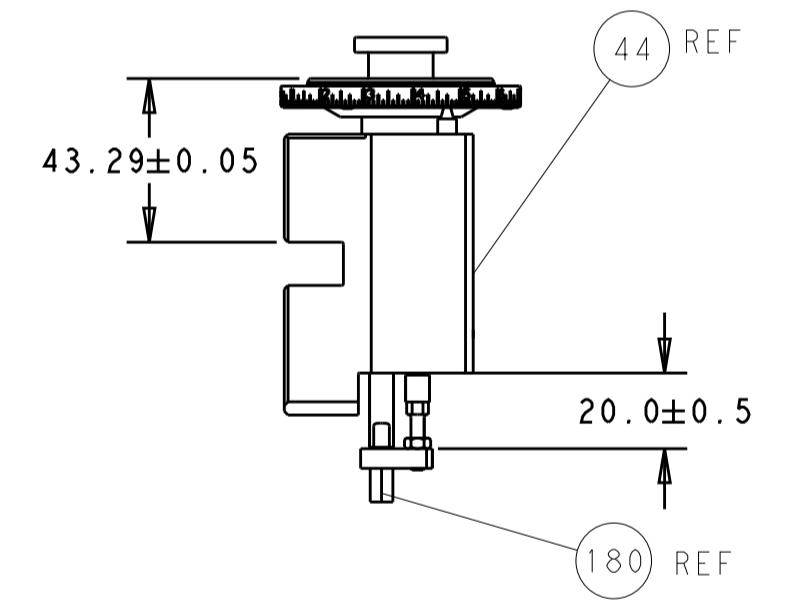


DETAIL A

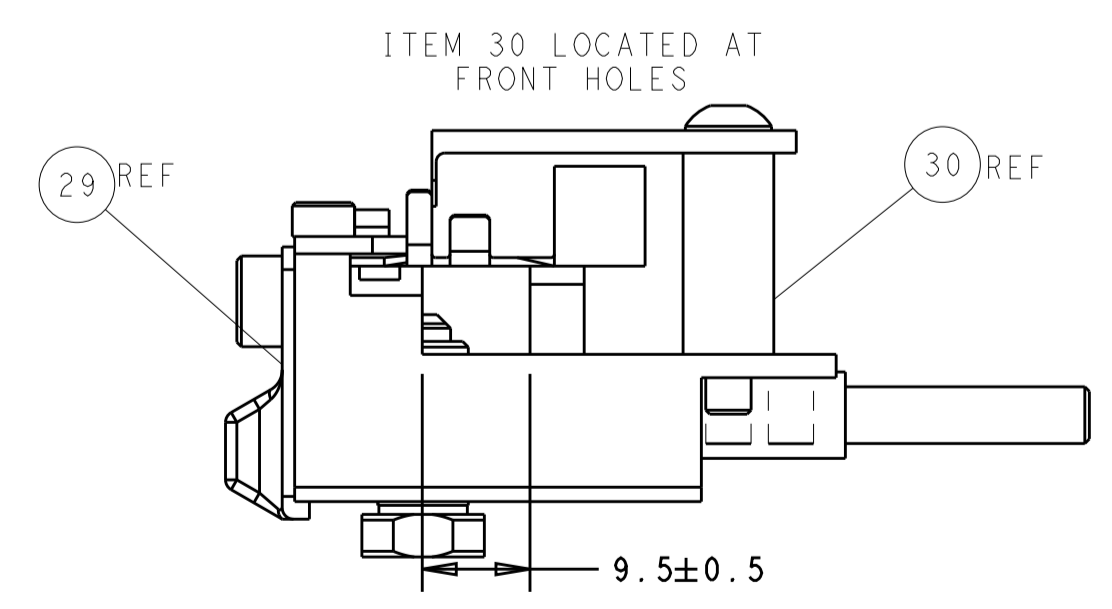
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



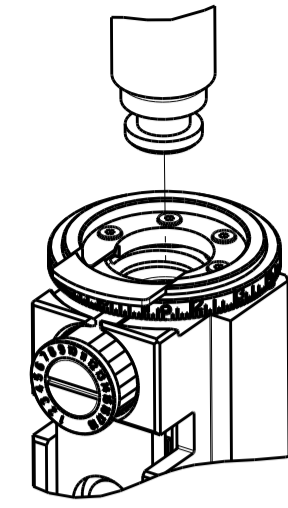
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DMN	13DEC2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	13DEC2012	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	13DEC2012	NAME
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing		Ocean Side Feed Applicator
		RESTRICTED TO		SIZE	CAGE CODE	DRAWING NO
				A1	00779	©=2151811
				SHEET 2 OF 4		REV E

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

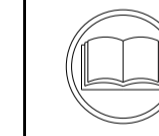
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



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 5.50-6.00 mm [1.217-.236 IN]		INSULATION DIAMETER RANGE Ø3.10-4.20 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 +/- .002]	6.2
2.00mm2	2.43 +/- 0.05 [1.096 +/- .002]	7.8
1.50mm2	2.33 +/- 0.05 [1.092 +/- .002]	8.9



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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. 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	REV	DATE	BY	APPV
A	66				

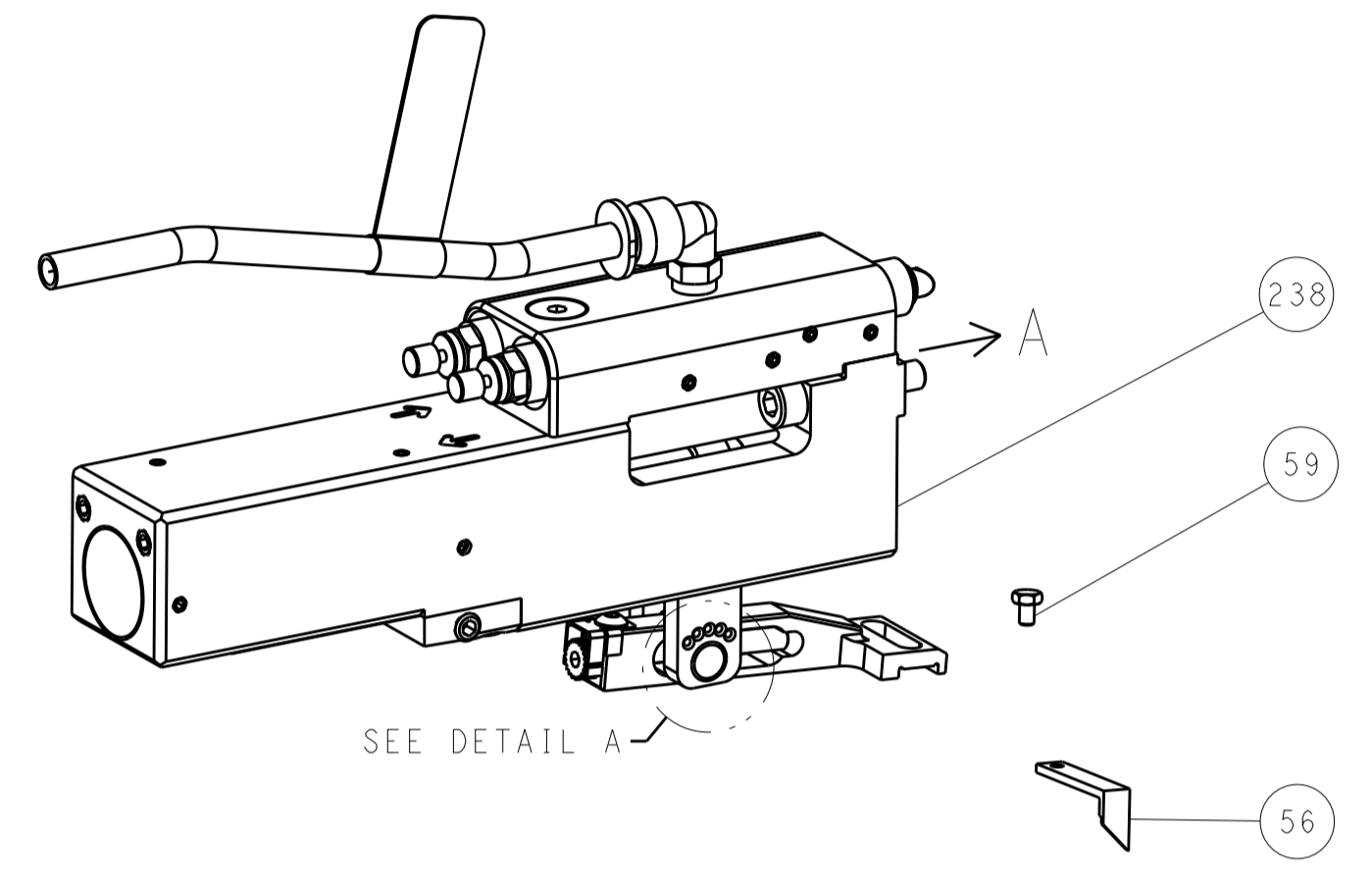
REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	2119082-9			244
-	1	2079764-1			243
3	-	2119083-1			242
-	1	7-18023-7			241
-	1	2844940-2			238
-	2	2168083-1			230
3	-	2-1752354-0			180
-	1	993111-1			177
-	1	8-22280-7			176
-	1	1752353-2			175
-	1	1901680-2			174
-	REF	994970-2			164
-	1	2119641-2			151
-	1	2168083-8			144
-	4	2168083-9			143
-	1	1-1803583-0			141
-	1	1803516-1			140
-	1	1-18028-2			119
-	1	2844908-1			99
-	1	2844907-1			98
-	1	1-690438-0			96
-	2	2168083-1			95
-	1	455888-4			82
-	1	1633782-3			78
-	1	1803607-3			71
-	1	2119791-5			70
-	1	2119740-1			67
-	2	2168078-1			66
-	2	2-18032-5			61
-	1	5-18022-5			59
-	1	1338683-8			56
-	1	1-5018030-0			52
-	1	1901681-2			51
-	1	18023-9			49
-	1	1803602-1			41
-	1	1752356-3			34
-	2	1-2079383-3			33
-	2	4-2844962-0			30
-	1	2844992-3			29
-	1	1-455888-0			28
-	2	22283-1			27
-	1	356835-1			26
-	1	240792-1			25
-	1	1320928-2			24
-	1	980371-4			23
-	1	2168083-2			21
-	1	1-18028-2			20
-	1	2119533-1			19
-	1	2119806-1			13
-	1	3-22280-3			12
-	1	1-356885-4			11
-	1	2119805-1			10
-	1	1803095-6			9
1	1	1-1633932-9			8
-	-	-			7
-	-	-			6
-	1	1-2119757-3			5
-	1	238011-4			4
1	1	2-1633961-7			3
-	1	455888-8			2
1	1	2-456411-9			1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN H. HUANG CHK S. XI APPV S. XI	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±			13DEC2012 13DEC2012 13DEC2012	
MATERIAL	FINISH	WEIGHT		SCALE	
		A 00779		1:2	
Customer Accessible Production Drawing				SHEET 3 OF 4	

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

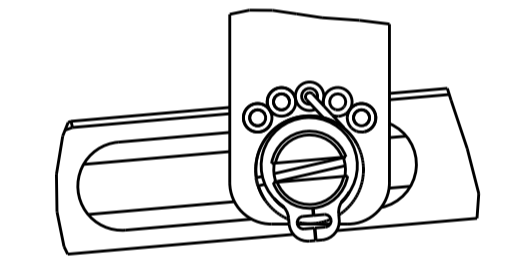
FEED TYPE

PNEUMATIC



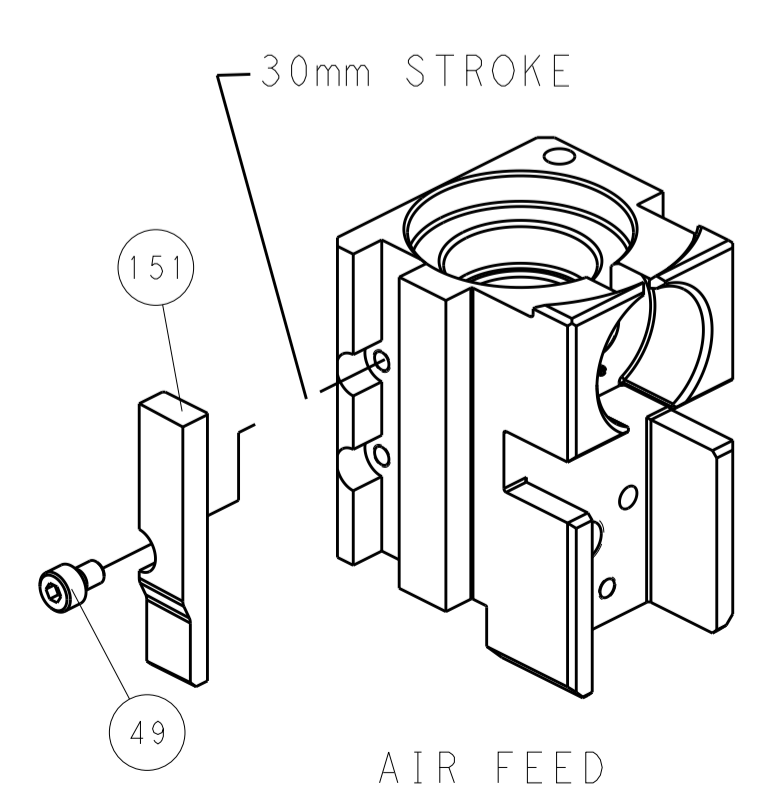
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

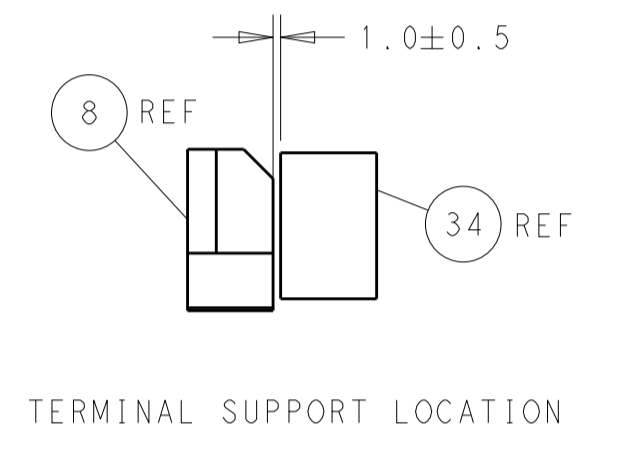
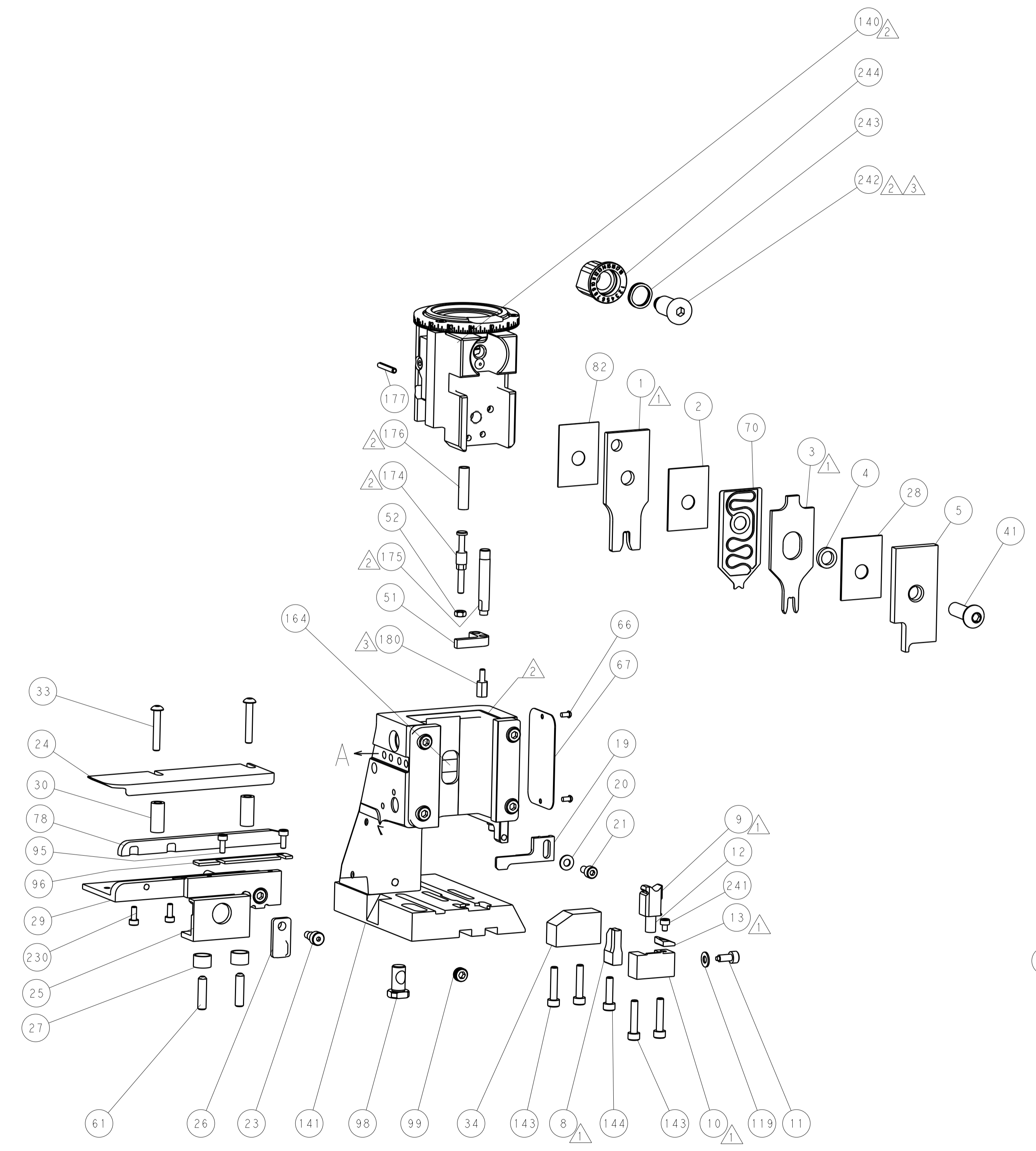


DETAIL A

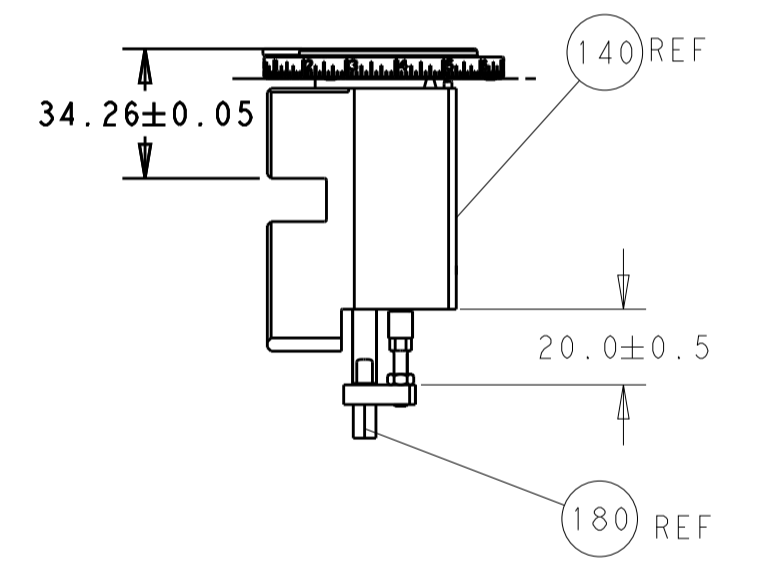
CAM POSITION



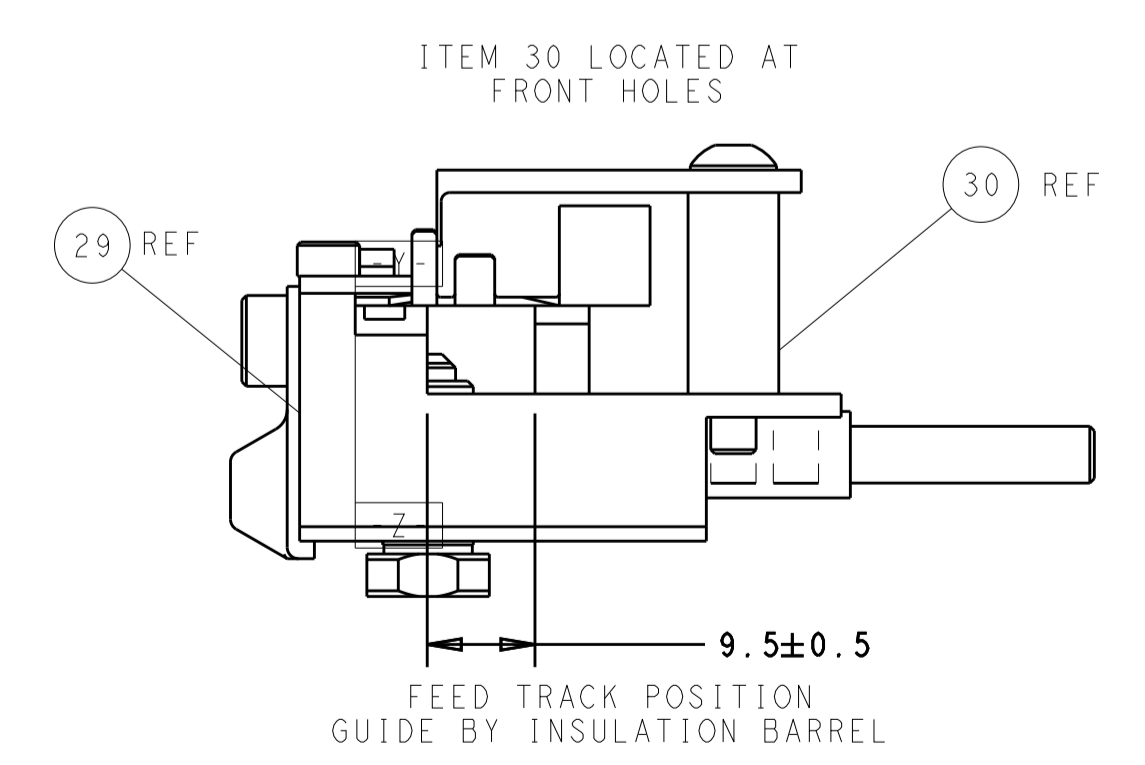
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



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:		DWN R. HUANG 13DEC2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK S. XI 13DEC2012	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD S. XI 13DEC2012	PRODUCT SPEC	-	
	2 PLC	±		APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO
	3 PLC	±		WEIGHT	A1	00779	©=2151811
	4 PLC	±		MATERIAL	Customer Accessible Production Drawing	SCALE	1:2
	ANGLES	±		FINISH	SHEET	4	OF 4
					REV		E