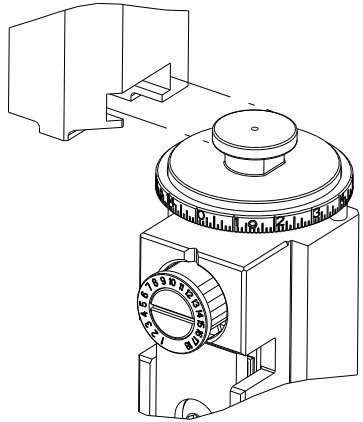


8		7	
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20		20	
(C) COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151083-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151083-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151083-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151083-2	J	MECHANICAL AND CRIMP TOOLING KIT	PNEUMATIC
7-2151083-7	H	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DYNAMIC D1000 SERIES REC CONTACT			
WIRE STRIP LENGTH 1.70-2.30 mm [.067-.091 IN]			INSULATION DIAMETER RANGE Ø1.40-2.20 mm [.055-.087 IN]
TERMINAL APPLICATION SPECIFICATION		(A)114-5377	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL (A) 1827572-2	TE TERMINAL (A) 1871731-1	TE TERMINAL (A) 1903114-2	TE TERMINAL (A) 1903122-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HD1 CONTACT 2L SIZE			
WIRE STRIP LENGTH 1.70-2.30 mm [.067-.091 IN]			INSULATION DIAMETER RANGE Ø1.40-2.20 mm [.055-.087 IN]
TERMINAL APPLICATION SPECIFICATION (A)114-5377		-	-
TERMINAL APPLICATION SPECIFICATION (B)114-78021		-	-
TERMINALS APPLIED 			
TE TERMINAL (B) 2316663-4	TE TERMINAL (B) 2316670-4	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.86mm2	1.15+/-0.03 [.045+/- .001]	4.8
20 AWG OR 0.52mm2	1.00+/-0.03 [.039+/- .001]	6.3
22 AWG OR 0.35mm2	0.85+/-0.03 [.033+/- .001]	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 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 LUBRICANT IS RECOMMENDED.
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.

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

2		1							
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
			G	ECR-18-005881			19APR2018	MZ	JD
			G1	ECR-18-008851			08JUN2018	KH	LZ
			H	ECR-20-014197			06OCT2020	JWC	RK
			J	ECR-22-151337			02SEP2022	FZ	GB

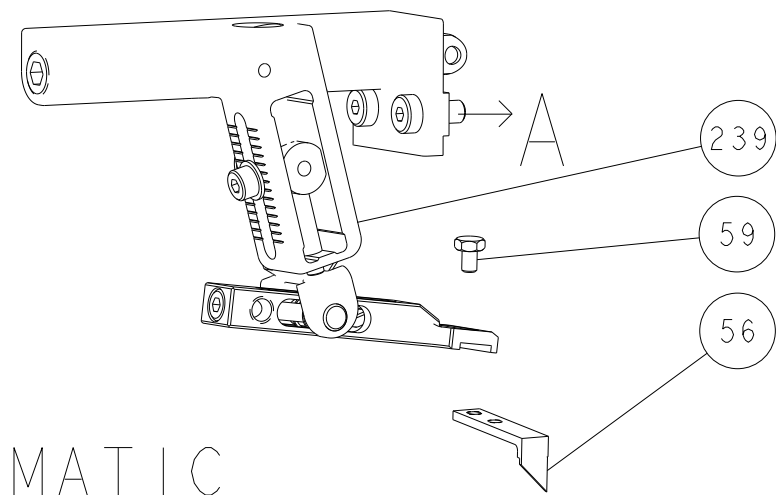
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	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	455888-3	SPACER, CRIMPER	28
-	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	1-356885-4	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	1	3-1729372-5	ANVIL	8
-	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-6	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2-1803384-6	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	2	2	1	1	4-1633730-4	CRIMPER, WIRE	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.		DWN R. HUANG	31AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK		NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD S. XI	31AUG2011	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL		WEIGHT		A1 00779 ©=2151083	
Customer Accessible Production Drawing		SCALE	1:2	SHEET	1 OF 4
		REV	J		

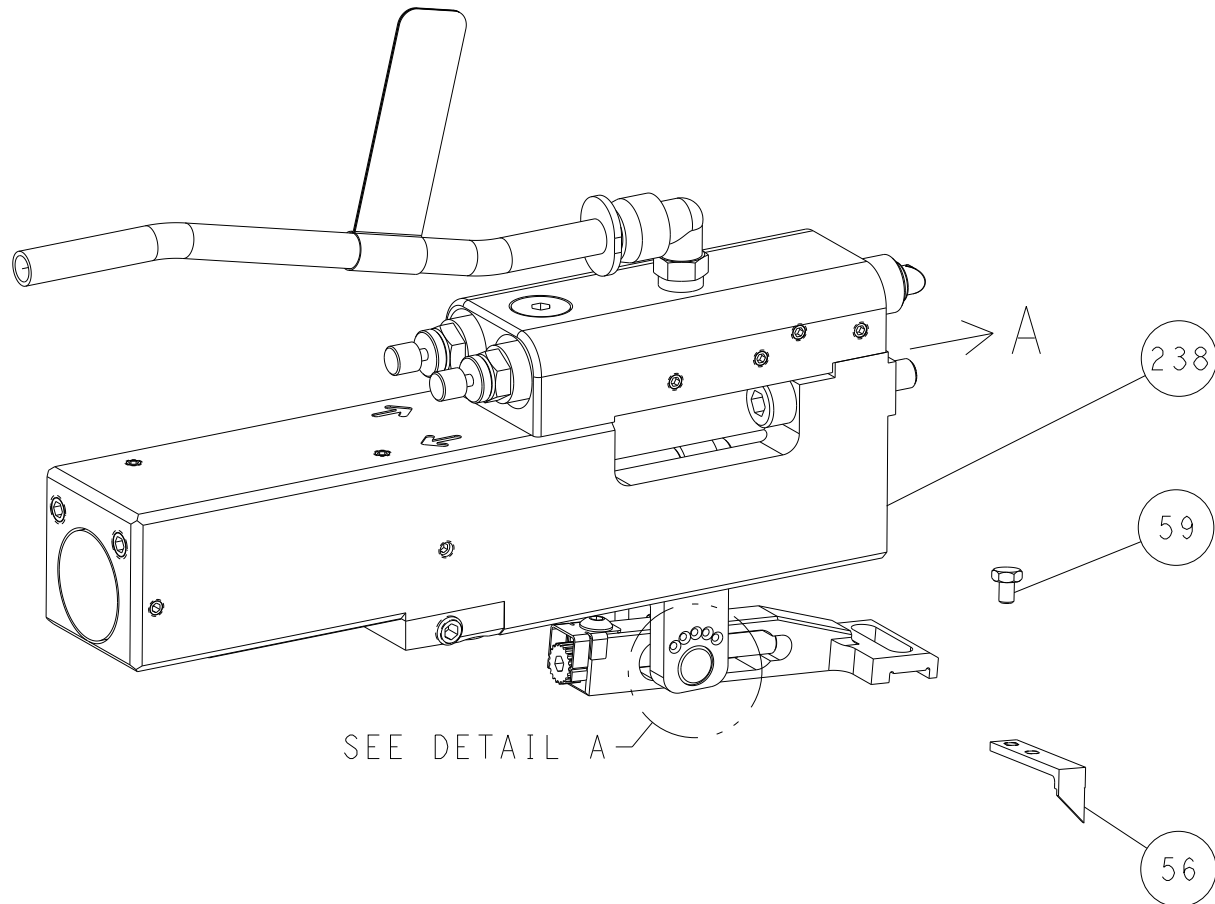
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

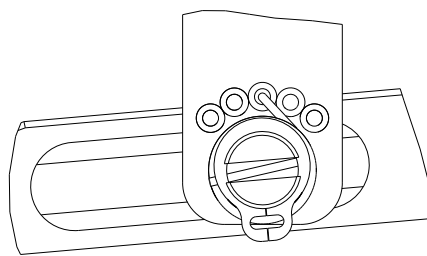
FEED TYPE MECHANICAL



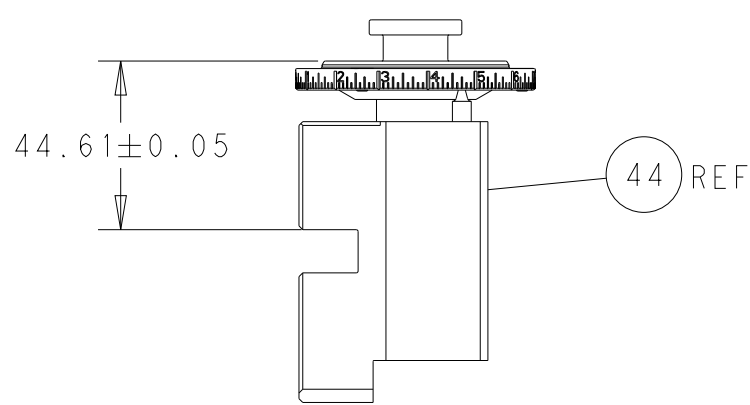
PNEUMATIC



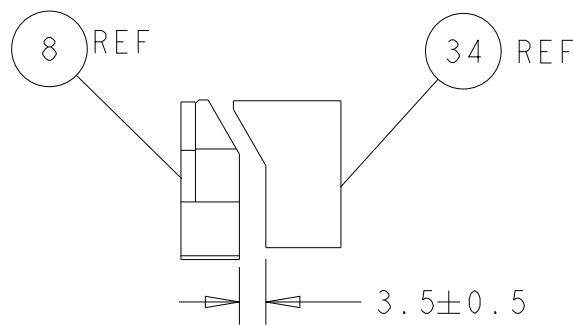
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

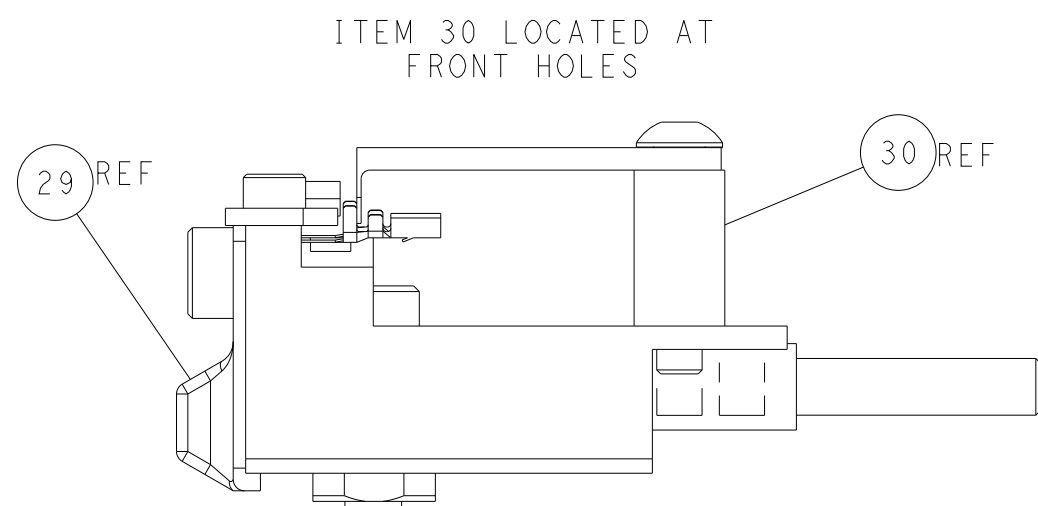
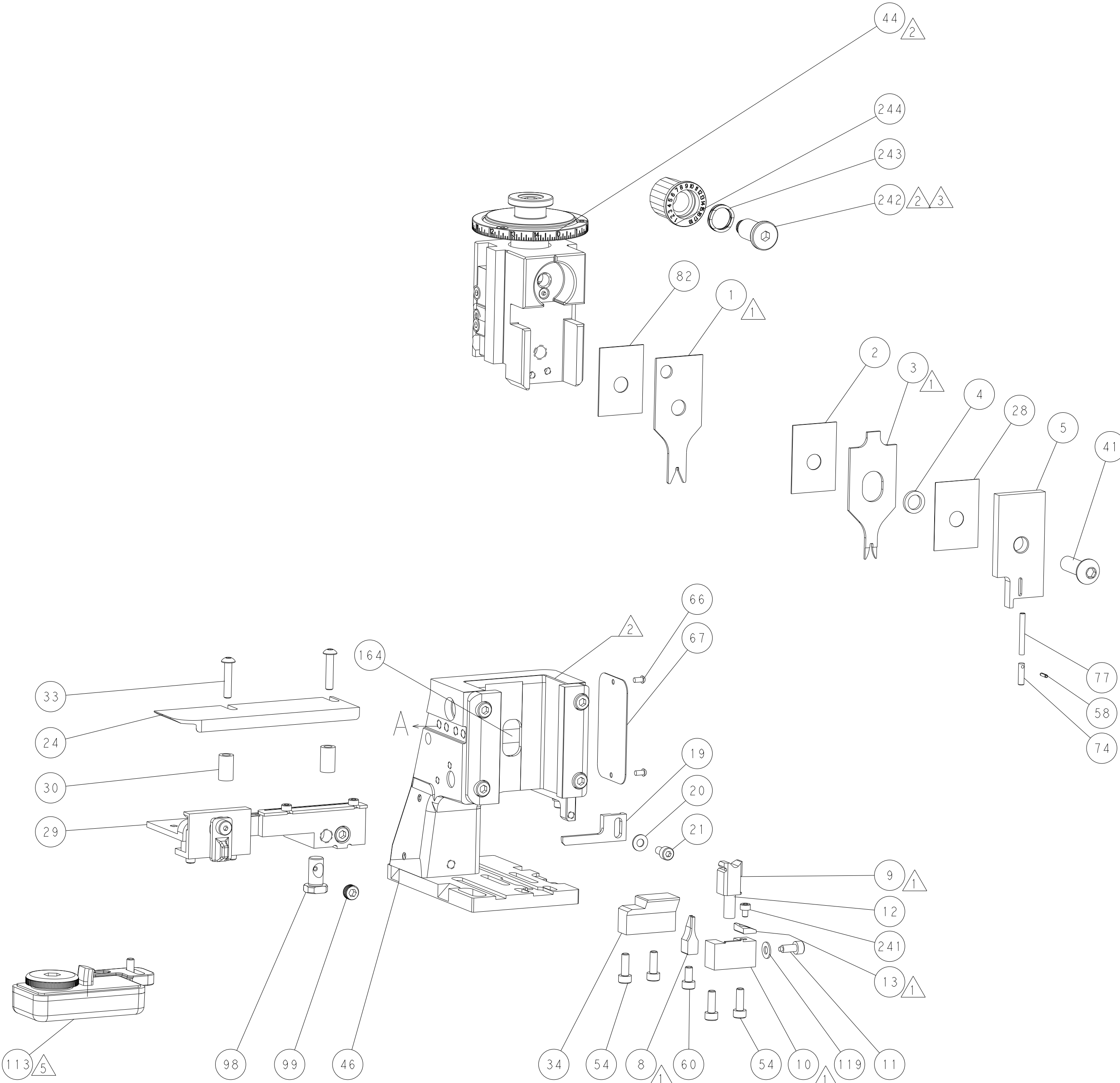
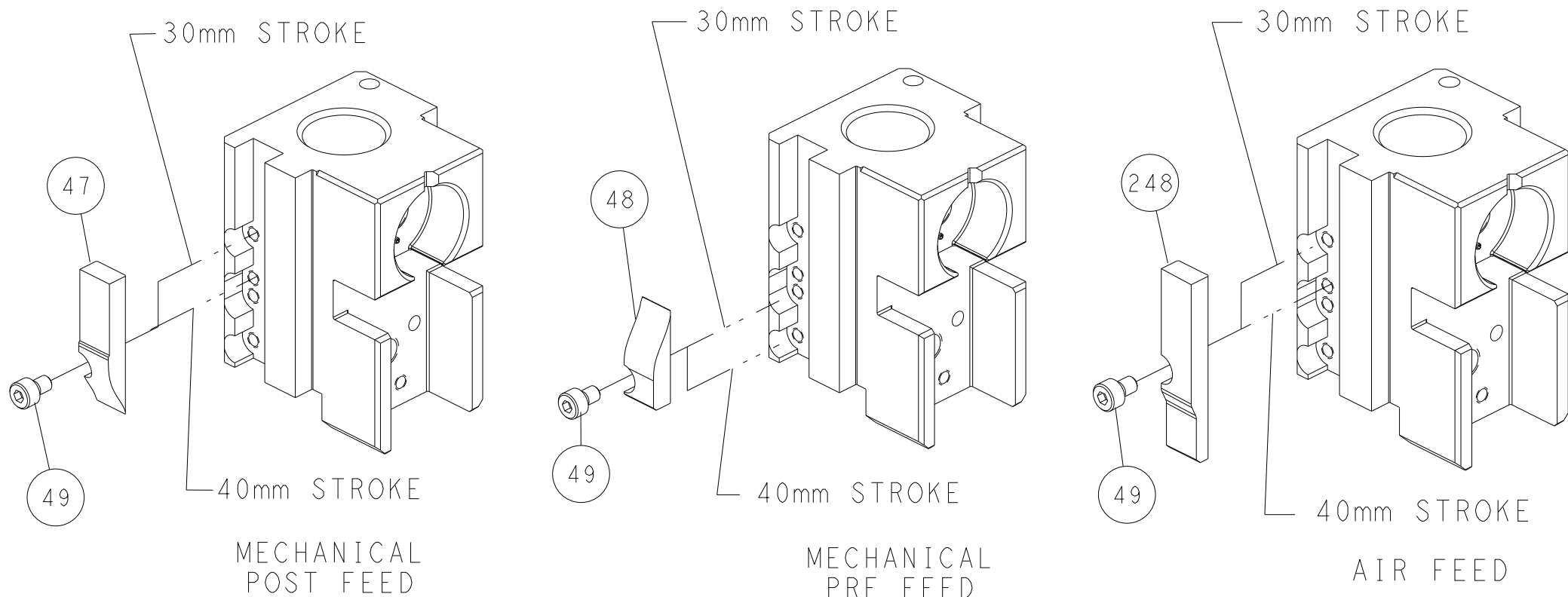


RAM SET-UP



TERMINAL SUPPORT LOCATION

CAM POSITIONS



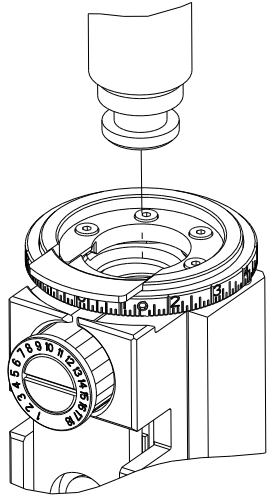
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO COMPANY CONTROL AND INSPECTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN	K. HUANG	31AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
				CHK	-	-		
				APVD	S. XI	31AUG2011	NAME	
				PRODUCT SPEC			Ocean Side Feed Applicator	
				APPLICATION SPEC				
				WEIGHT			RESTRICTED TO	
				Customer Accessible Production Drawing			-	

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20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151083-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151083-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151083-7	H	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: DYNAMIC D1000 SERIES REC CONTACT			
WIRE STRIP LENGTH 1.70-2.30 mm [.067-.091 IN]		INSULATION DIAMETER RANGE Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5377	-	-
TERMINALS APPLIED ³			
TE TERMINAL (A) 1827572-2	TE TERMINAL (A) 1871731-1	TE TERMINAL (A) 1903114-2	TE TERMINAL (A) 1903122-1

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: HD1 CONTACT 2L SIZE			
WIRE STRIP LENGTH 1.70-2.30 mm [.067-.091 IN]		INSULATION DIAMETER RANGE Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5377	-	-
TERMINALS APPLIED ⁵			
TE TERMINAL (B) 2316663-4	TE TERMINAL (B) 2316670-4	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁴
18 AWG OR 0.86mm2		1.15+/-0.03 [.045+/- .001]		4.8
20 AWG OR 0.52mm2		1.00+/-0.03 [.039+/- .001]		6.3
22 AWG OR 0.35mm2		0.85+/-0.03 [.033+/- .001]		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 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 LUBRICANT IS RECOMMENDED.
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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

	-	1	1	2119082-4	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
5	-	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	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	854769-4	HOLDER, INS	74
	-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	1	1	1338685-1	PAWL, FEED	56
	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	2-1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-4	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
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	2119533-1	STRIPPER, SIDE FEED	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	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	1	3-1729372-5	ANVIL	8
	-	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
	-	1	1	238011-6	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-1803384-6	CRIMPER, INSULATION F	3
	-	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	4-1633730-4	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
DWN R. HUANG			31AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
CHK			31AUG2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm			APVD S. XI	PRODUCT SPEC	
				APPLICATION SPEC	
MATERIAL			WEIGHT	SIZE A	CAGE CODE 00779
				DRAWING NO C=2151083	RESTRICTED TO -
			Customer Accessible Production Drawing	SCALE 1:2	SHEET 3
				OF 4	REV J

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC		DIST		REVISIONS			
P	LYR	DESCRIPTION		DATE	DWN	APVD	
-	-	SEE SHEET 1		-	-	-	

D

C

B

A

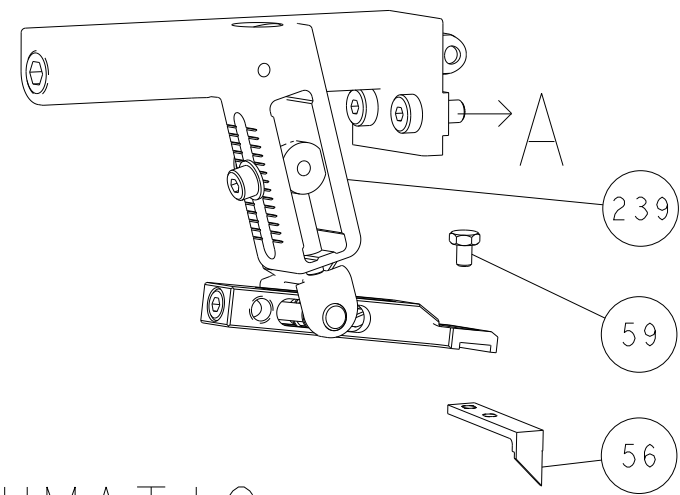
D

C

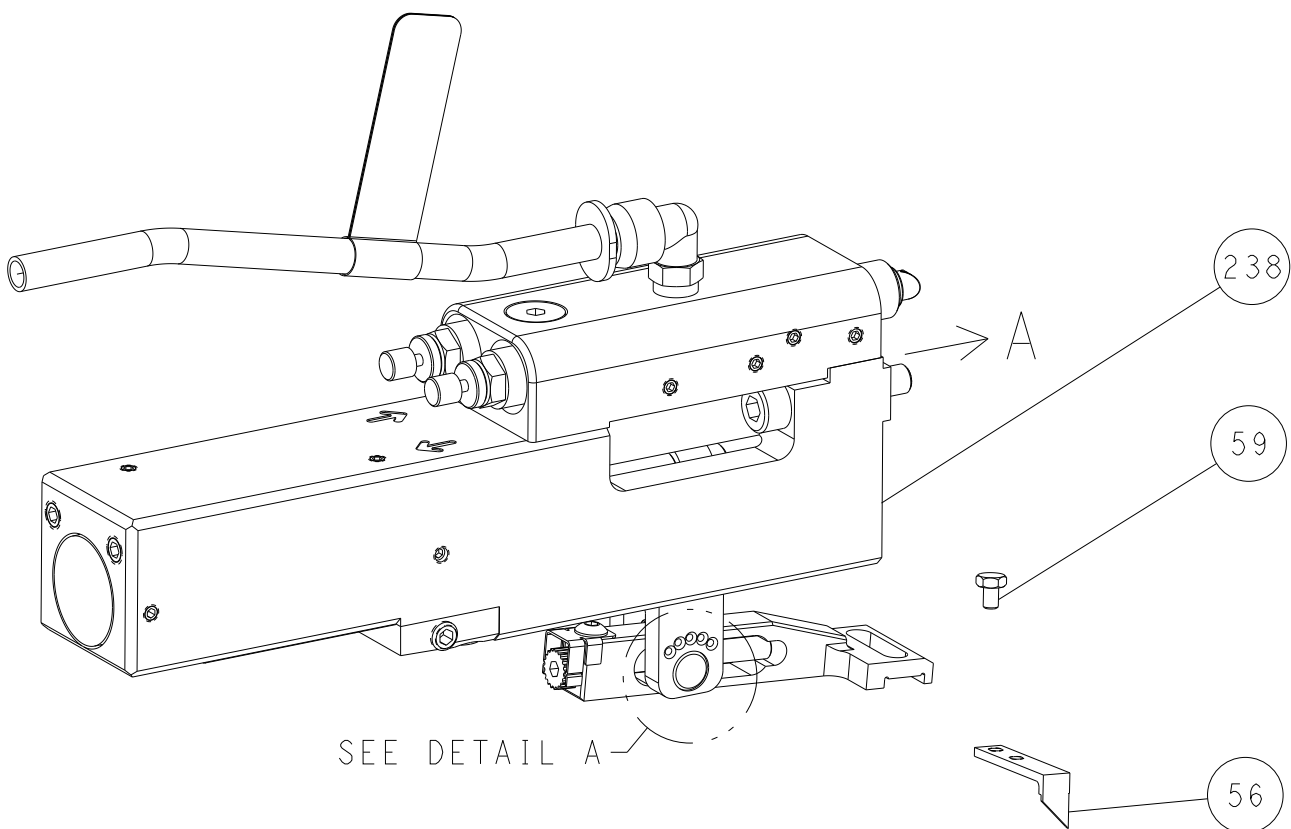
B

A

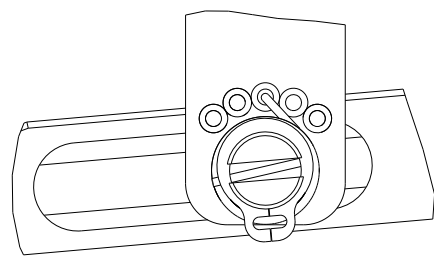
FEED TYPE MECHANICAL



PNEUMATIC

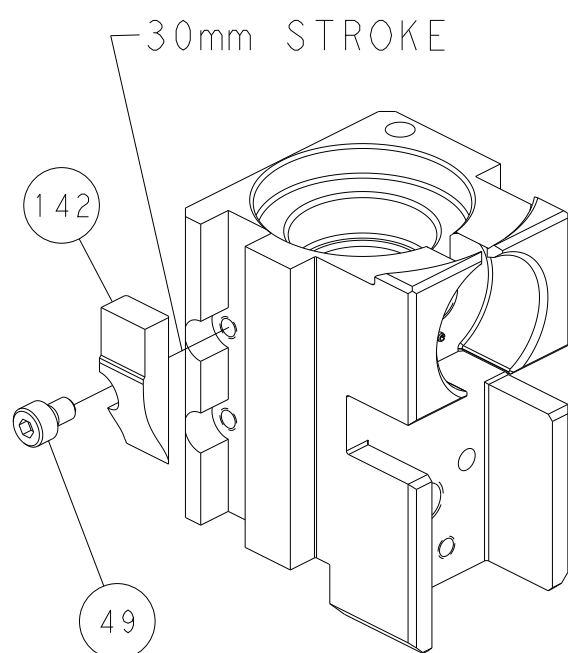


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

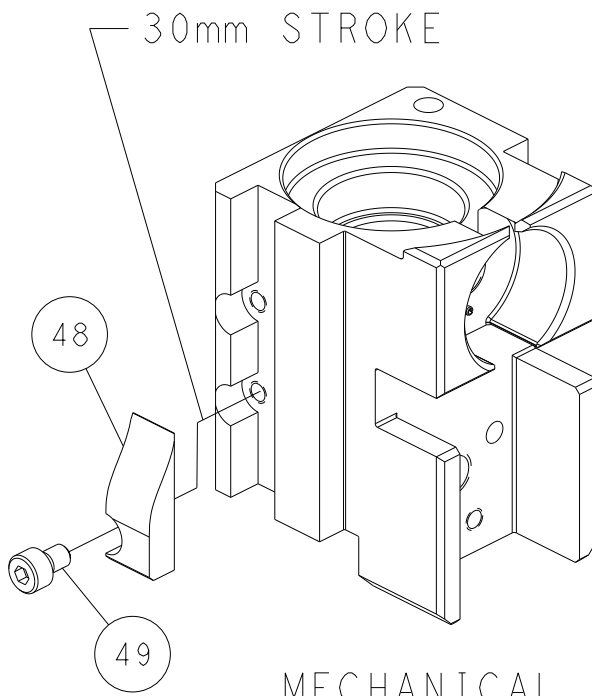


DETAIL A

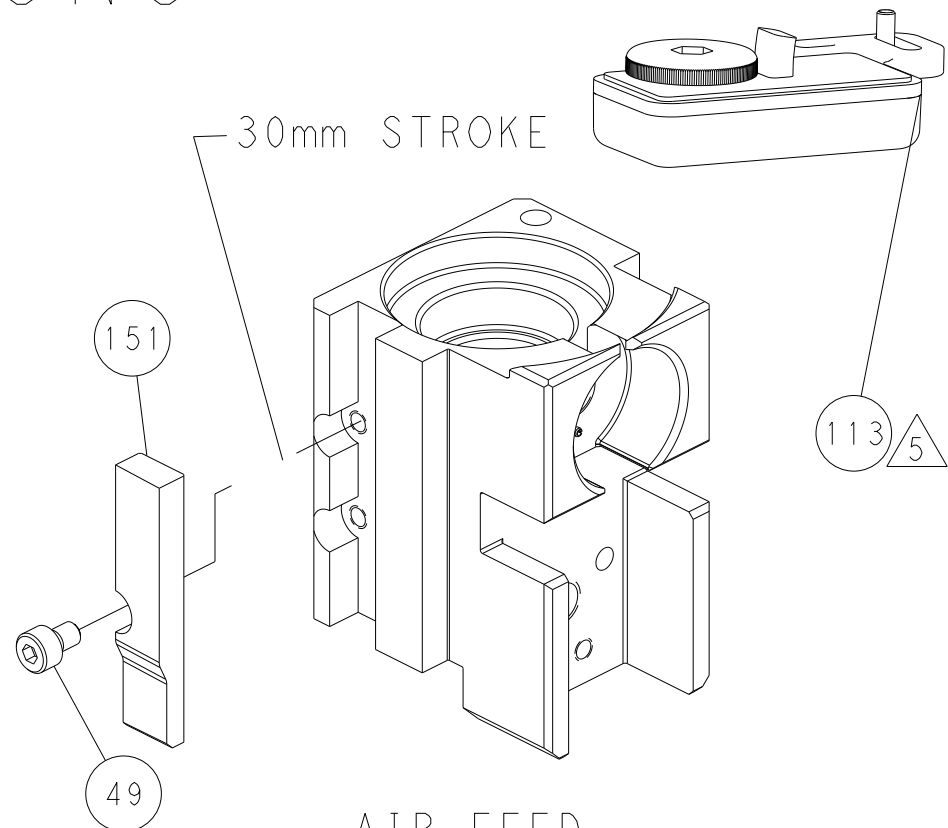
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

