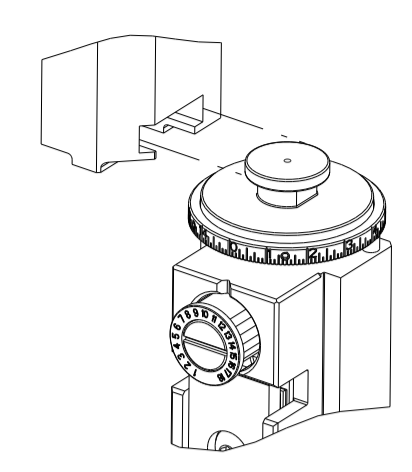


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151546-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151546-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151546-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151546-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151546-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.94-4.70 mm [.155-.185 IN]		Ø0.13-0.13 mm [.005-.005 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2088	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63130-2	63130-3	1-63130-0	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 & 18 AWG	2.34 +/- 0.05 [.092 +/- .002]	5.2
18 AWG	1.85 +/- 0.05 [.073 +/- .002]	10.5

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- RECOMMENDED SETUP WIRE ONLY FOR CRIMP HEIGHT.
- REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA.
- PLACE ITEM 19 BETWEEN ITEM 1 AND ITEM 5.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

**\*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)

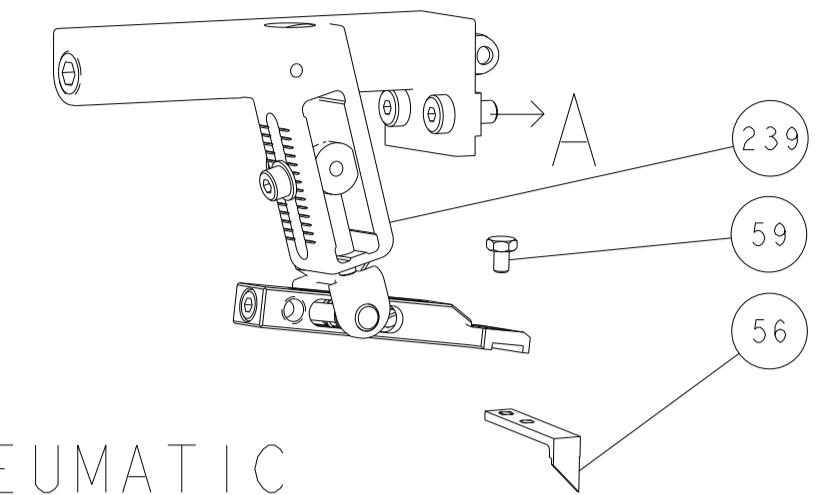
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		E	27APR2020	JWC	GB
		F	13MAY2020	JWC	RK
		F1	19SEP2023	FZ	JAH

-	1	1	1	1	469465-4	STOP, WIRE	262
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	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	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	1-455888-0	SPACER, CRIMPER	82
-	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	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
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-1	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
-	2	2	2	2	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1803333-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	1	1	1	1	1-455888-5	SPACER, CRIMPER	2
-	1	2	2	1	3-1803482-6	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	ITEM NO

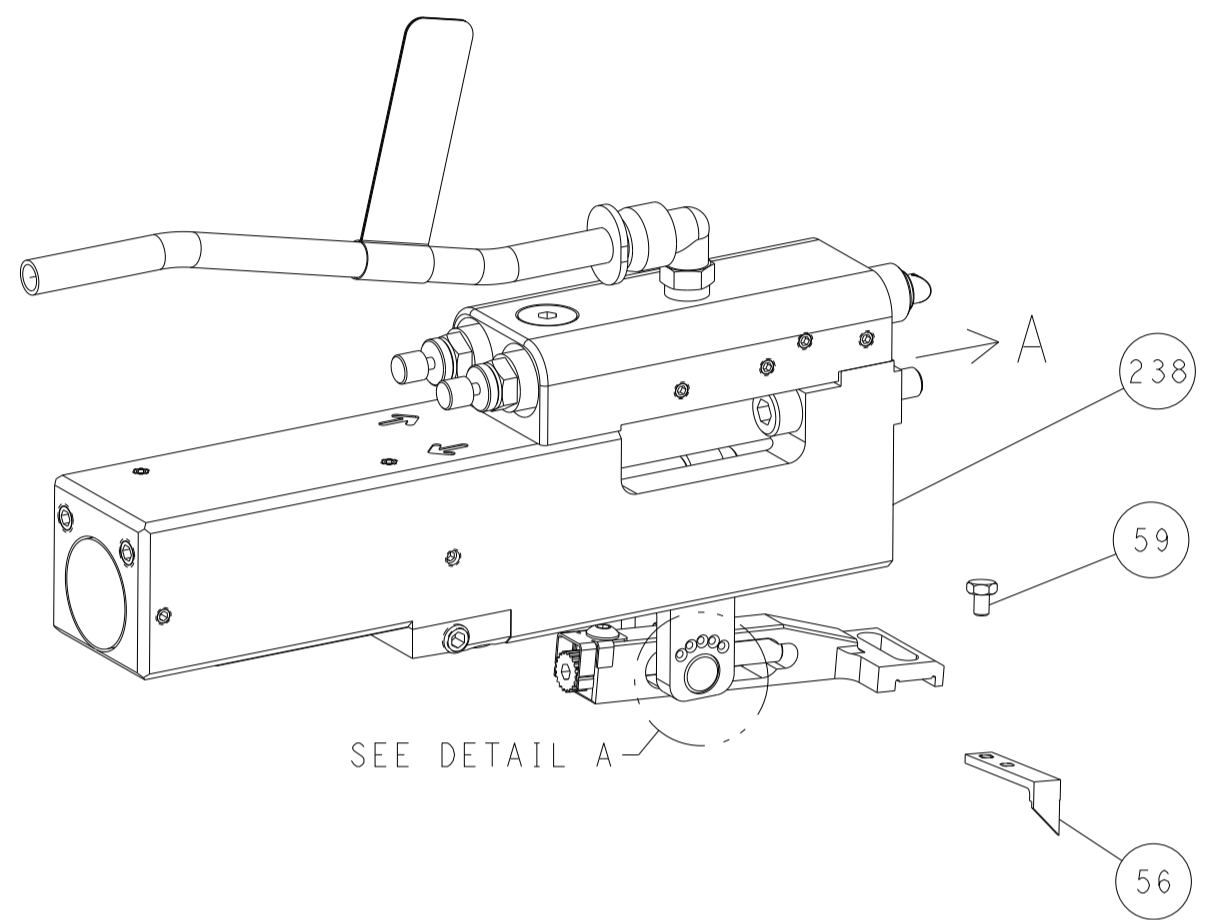
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: HOFFNER 02FEB2012 CHK: T. ELBIN 03FEB2012 APVD: T. ELBIN 03FEB2012 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151546 SHEET 1 OF 4 REV: F1	
MATERIAL: -				RESTRICTED TO: -			

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

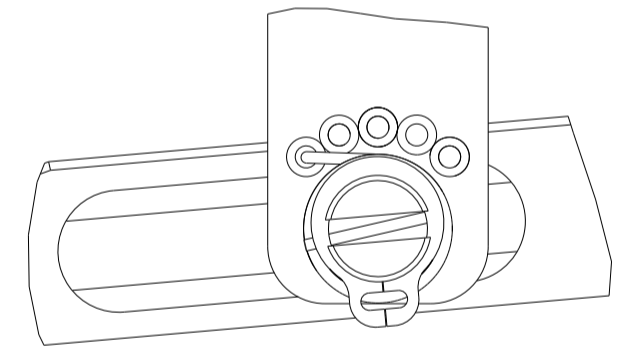
# FEED TYPE MECHANICAL



## PNEUMATIC

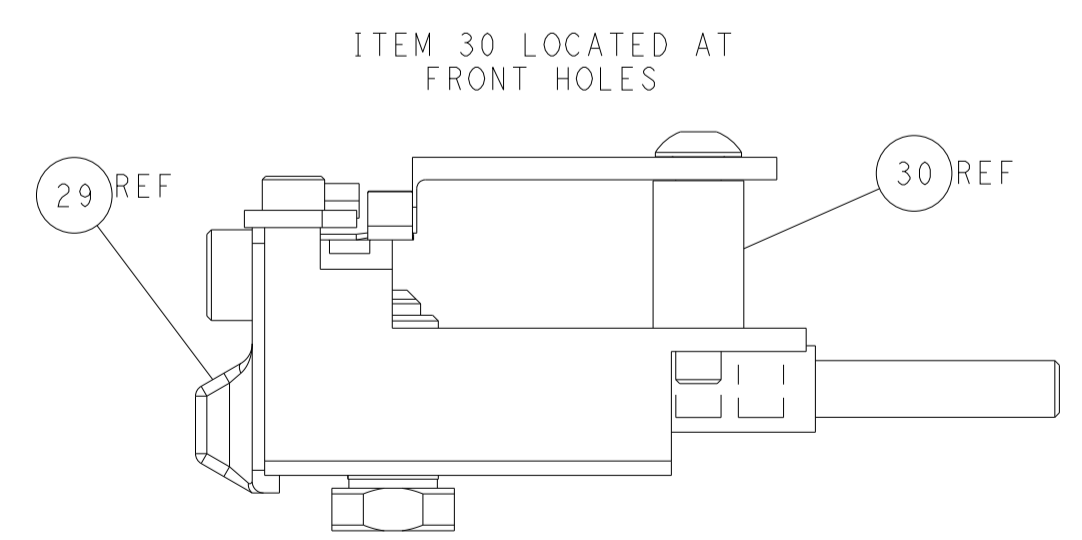
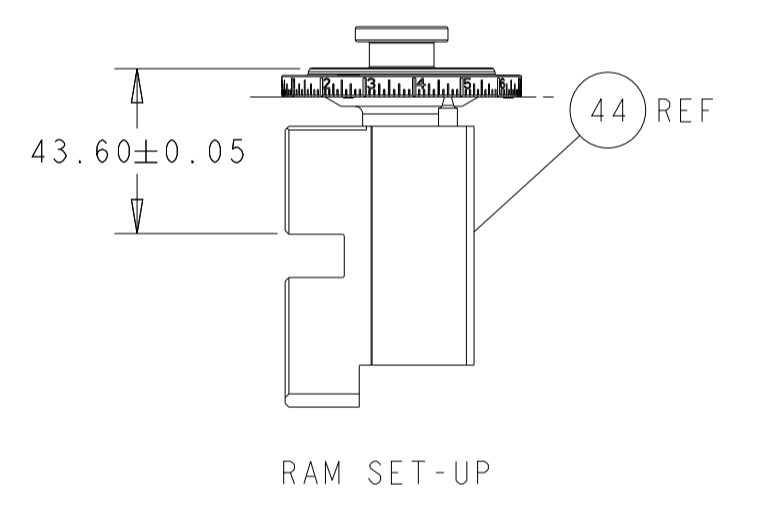
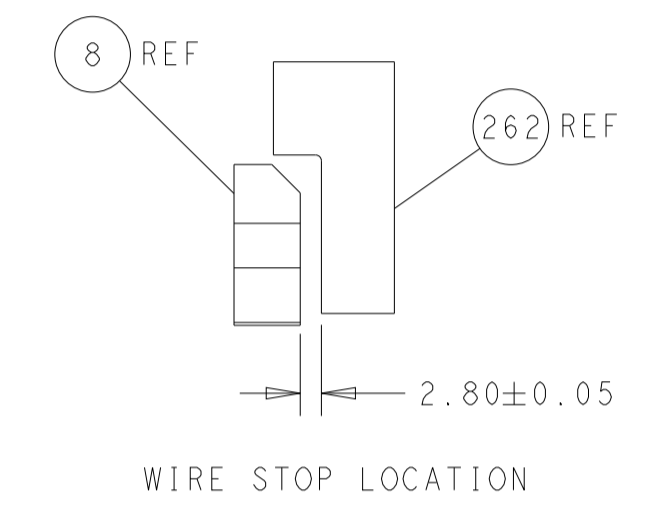
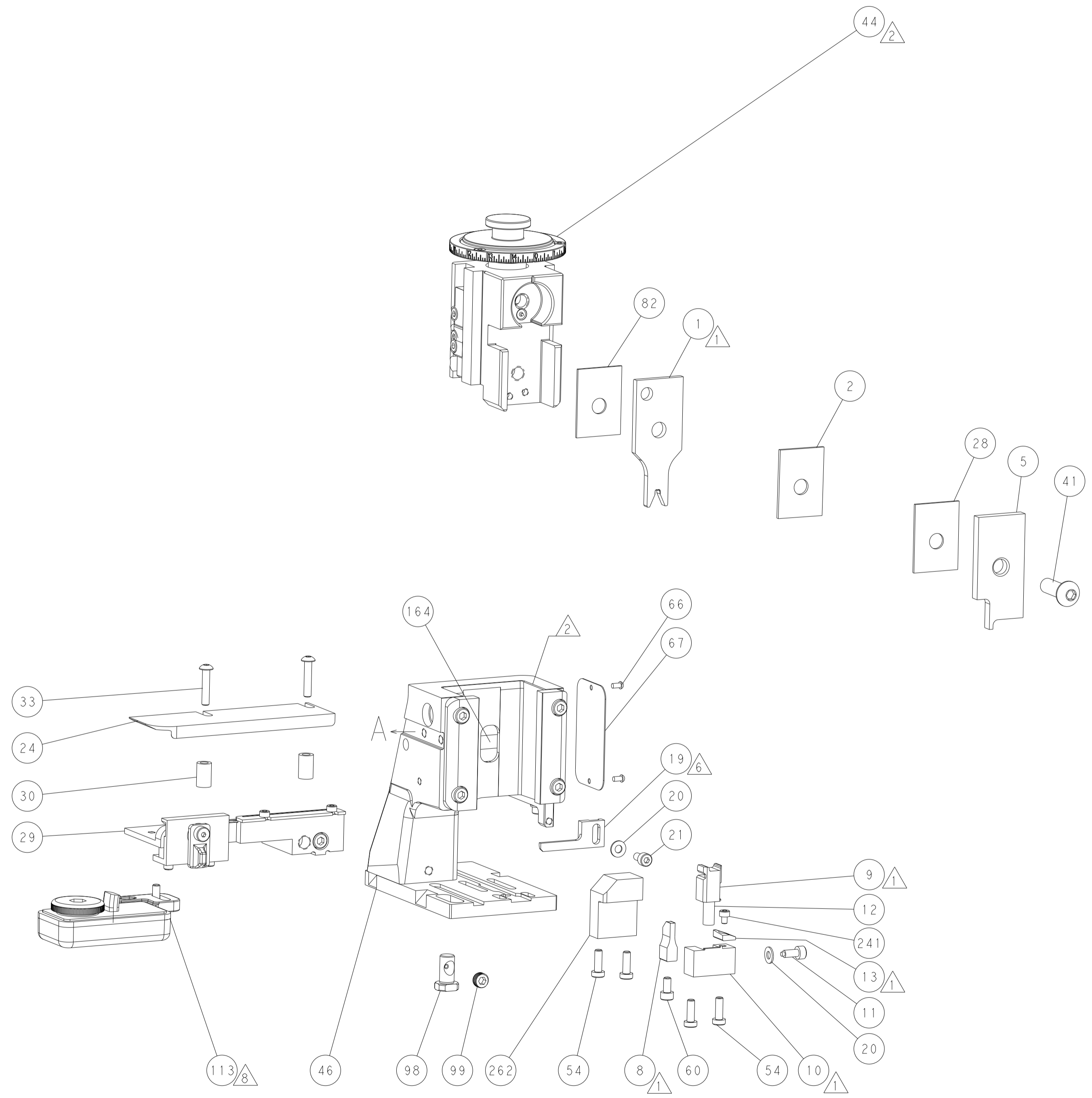
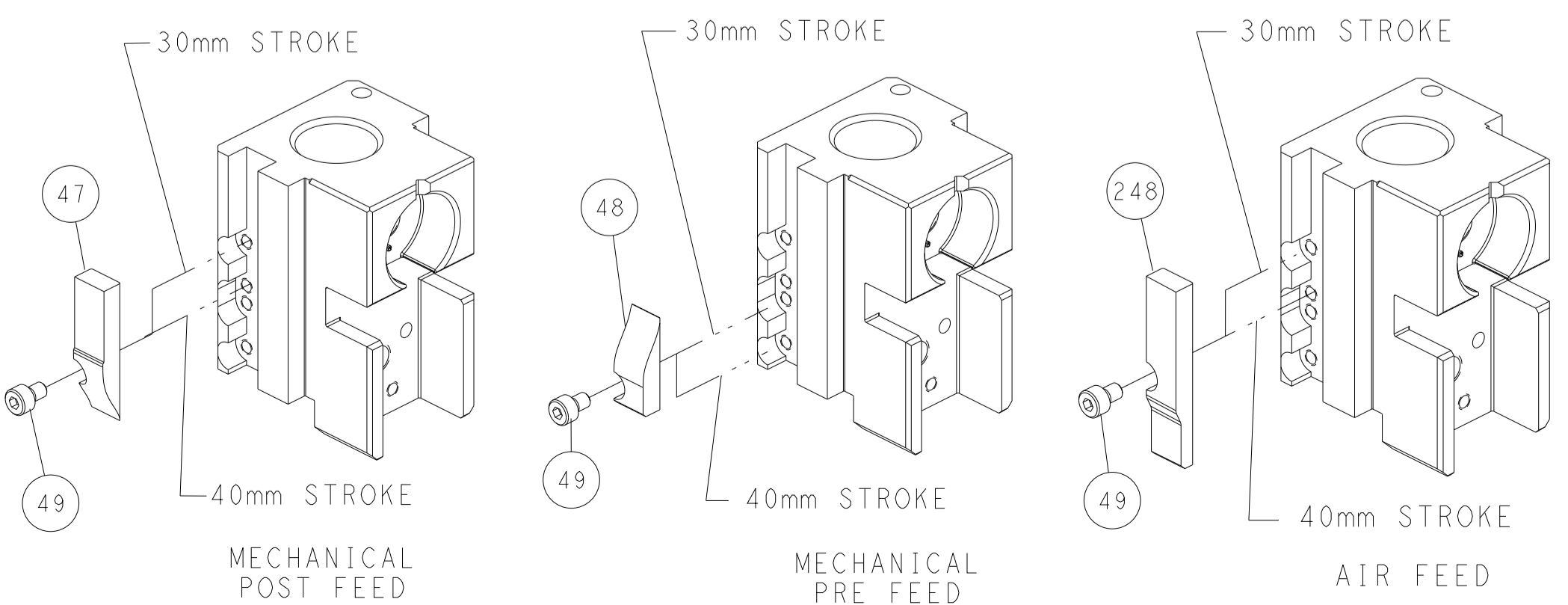


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

## CAM POSITIONS



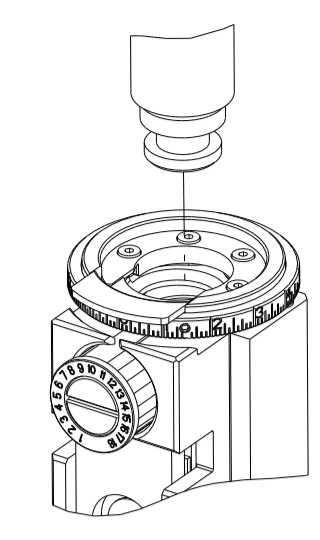
FEED TRACK POSITION GUIDE BY WIRE BARREL

**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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: HOFFNER 02FEB2012 CHK: TELBIN 03FEB2012 APVD: TELBIN 03FEB2012	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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151546	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 OF 4 REV: F1
MATERIAL: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151546-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151546-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151546-7	F	CRIMP TOOLING KIT	-

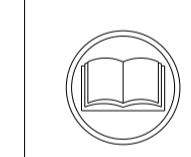
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.110]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE			
WIRE STRIP LENGTH 3.94-4.70 mm [1.55-.185 IN]		INSULATION DIAMETER RANGE Ø0.13-0.13 mm [0.005-.005 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2088	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63130-2	63130-3	1-63130-0	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 & 18 AWG	2.34 +/- 0.05 [0.092 +/- 0.002]	5.2
18 AWG	1.85 +/- 0.05 [0.073 +/- 0.002]	10.5



- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. 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.
- 4. RECOMMENDED SETUP WIRE ONLY FOR CRIMP HEIGHT.
- 5. REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA.
- 6. PLACE ITEM 19 BETWEEN ITEM 1 AND ITEM 5.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 8. TERMINAL LUBRICANT IS RECOMMENDED.

**\*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)

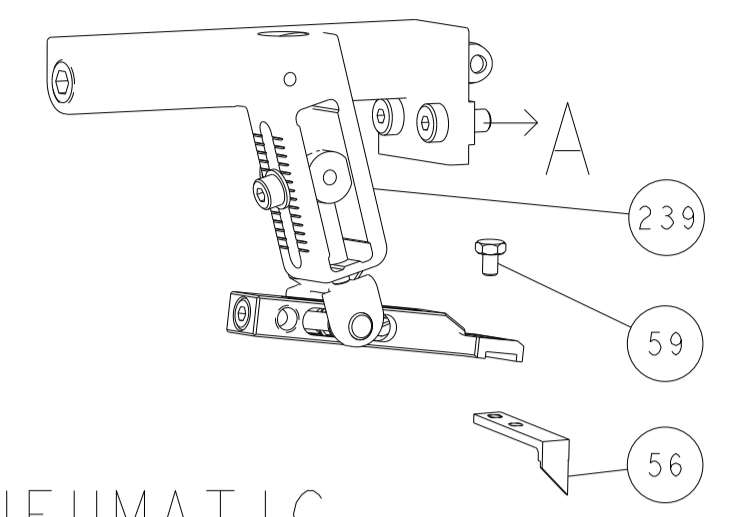
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1	469465-4	STOP, WIRE	262
-	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
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	2	2	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-0	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	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
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-1	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	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	1	1803333-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	1	1	1-455888-5	SPACER, CRIMPER	2
-	1	1	3-1803482-6	CRIMPER, WIRE	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

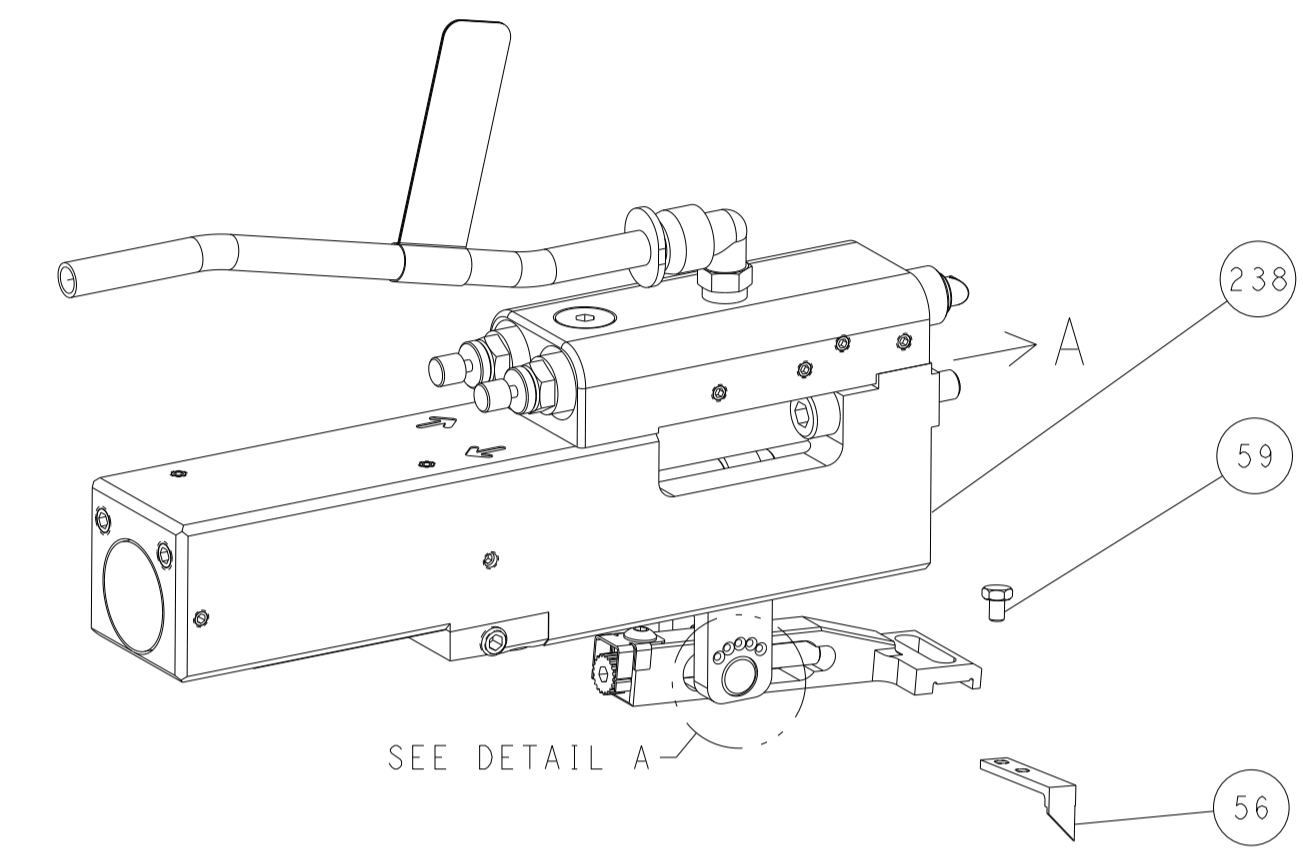
<small>THIS DRAWING IS A CONTROLLED DOCUMENT. FOR THE LATEST REVISION INFORMATION, CONTACT THE APPLICATOR MANUFACTURER. THIS DRAWING IS TO BE USED FOR THE LATEST REVISION.</small>		DWN: HOFFNER 02FEB2012 CHK: T. ELBIN 03FEB2012 APVD: T. ELBIN 03FEB2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151546 RESTRICTED TO: -
MATERIAL: -		WEIGHT: -	SCALE: 1:2 SHEET 3 OF 4 REV: F1

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

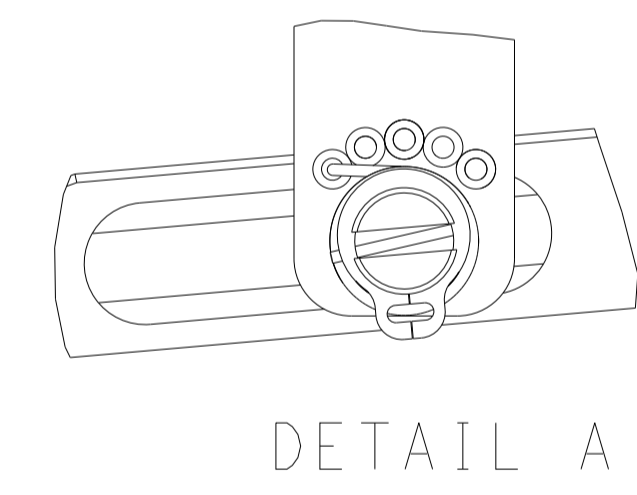
# FEED TYPE MECHANICAL



## PNEUMATIC

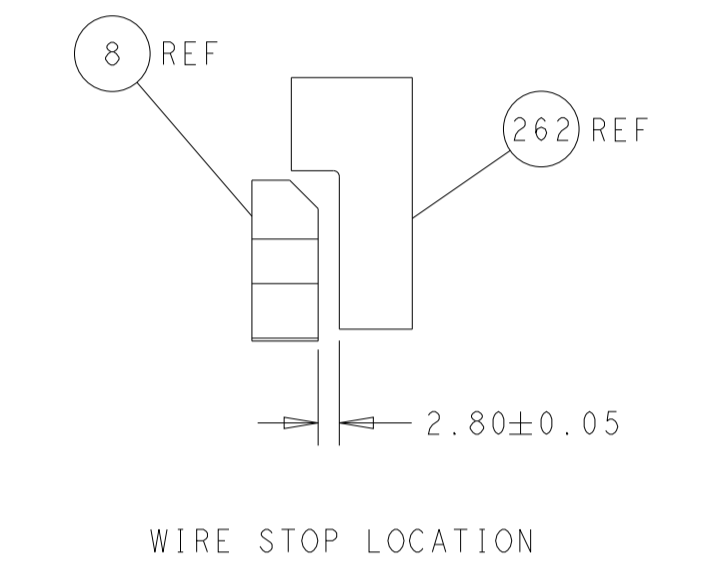
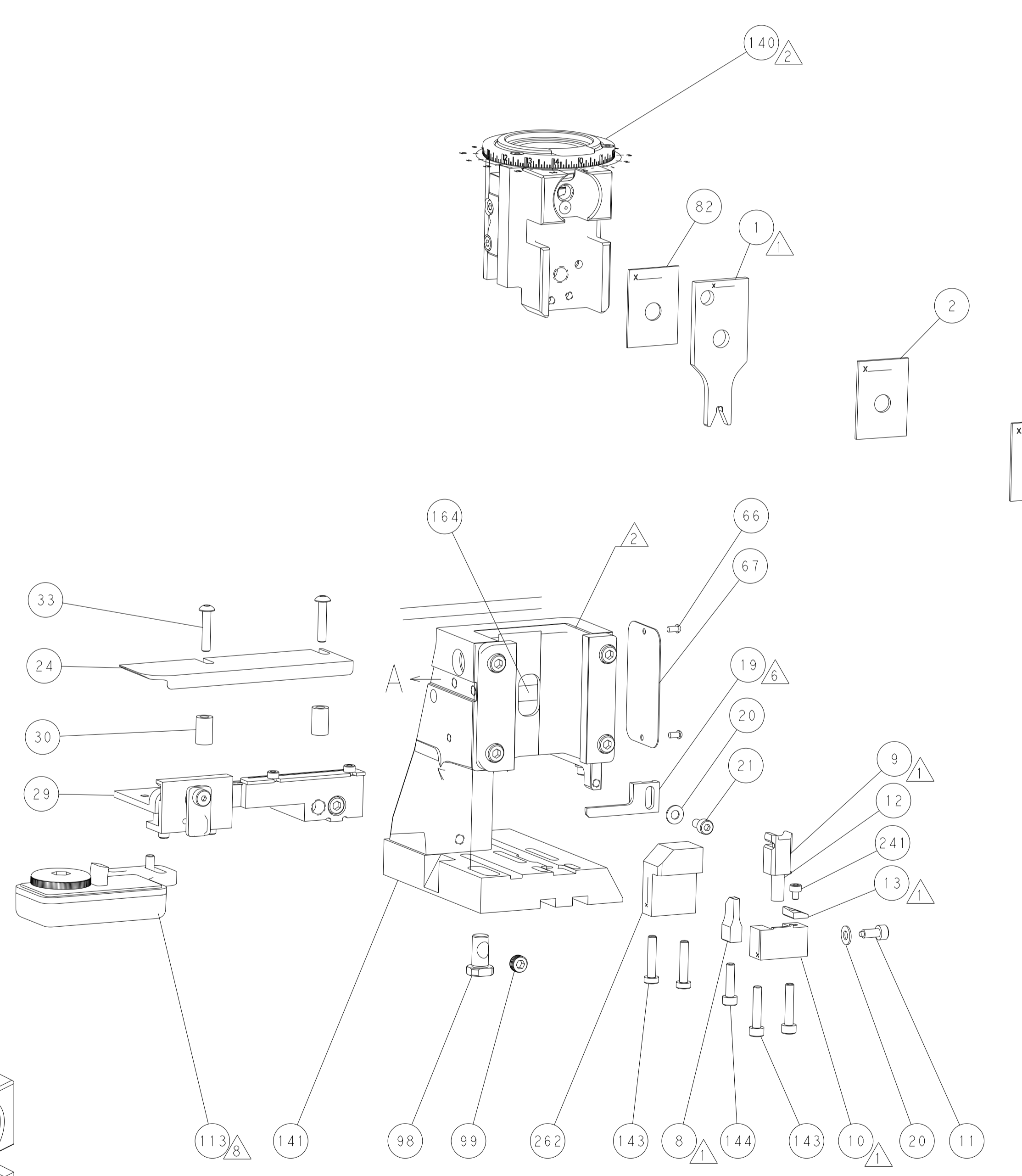
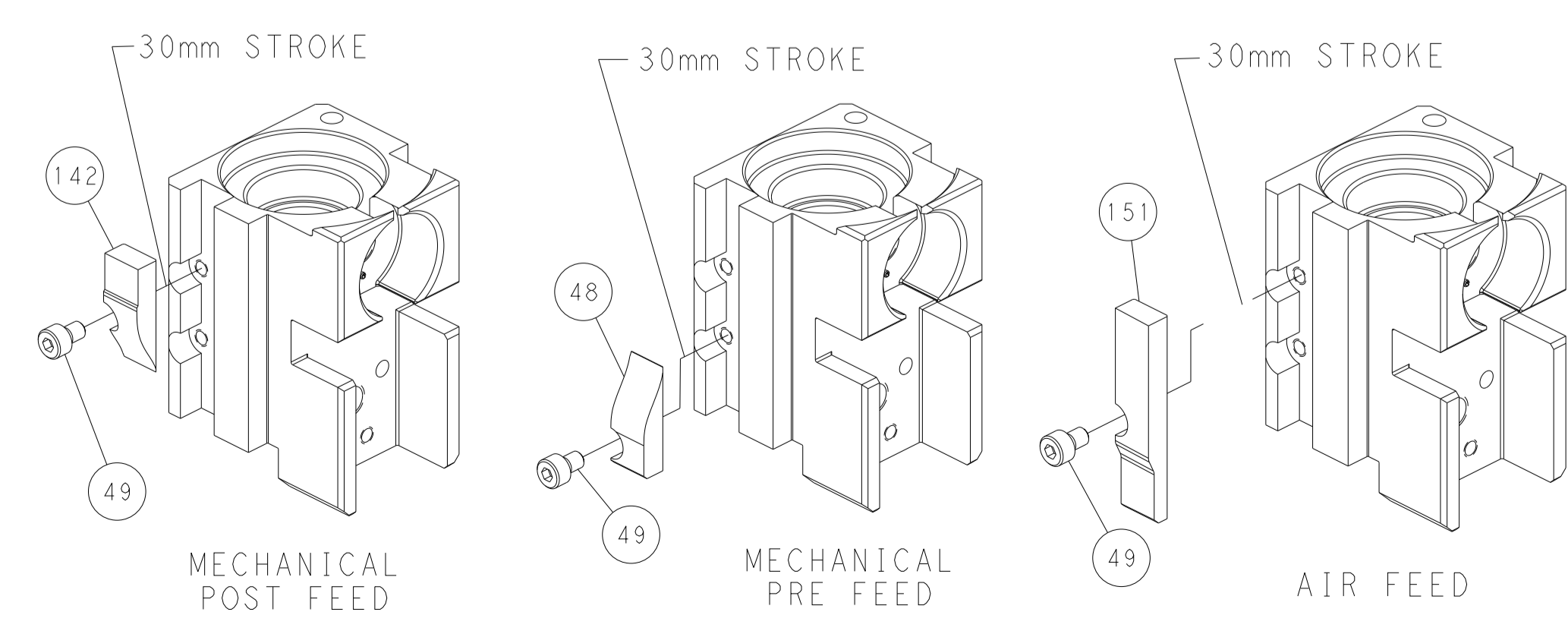


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

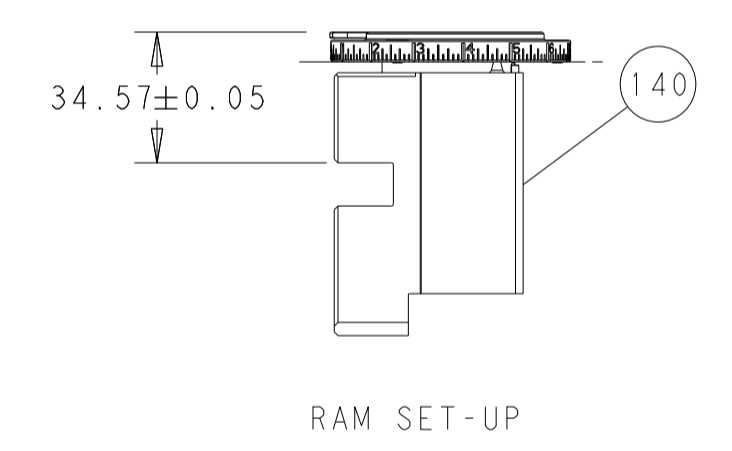


DETAIL A

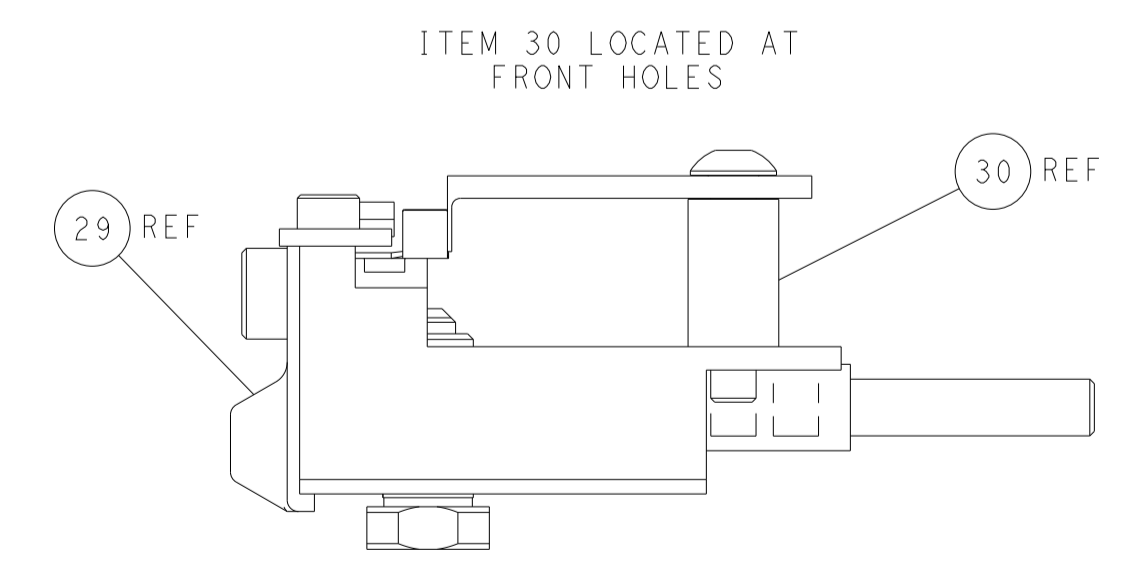
## CAM POSITIONS



WIRE STOP LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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 ± FINISH		NAME: Ocean Side Feed Applicator APPLICATION SPEC:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151546 RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 4 OF 4 REV: 1