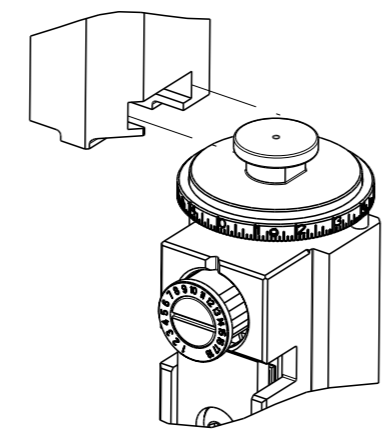


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151454-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151454-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151454-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151454-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151454-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

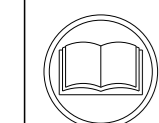


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.92 mm [.115]	F
INSUL	3.68 mm [.145]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL MINI F280			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.30-5.70 mm [.209-.224 IN]		Ø3.00-4.00 mm [.118-.157 IN]	
TERMINAL APPLICATION SPECIFICATION	B0-018.009A		
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
1949757-1	17.08332720		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	1.90+/-0.05 [0.075+/-0.002]	6.5
3.00mm2	1.80+/-0.05 [0.071+/-0.002]	7.5
2.50mm2	1.70+/-0.05 [0.067+/-0.002]	8.3



- 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.
- 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)

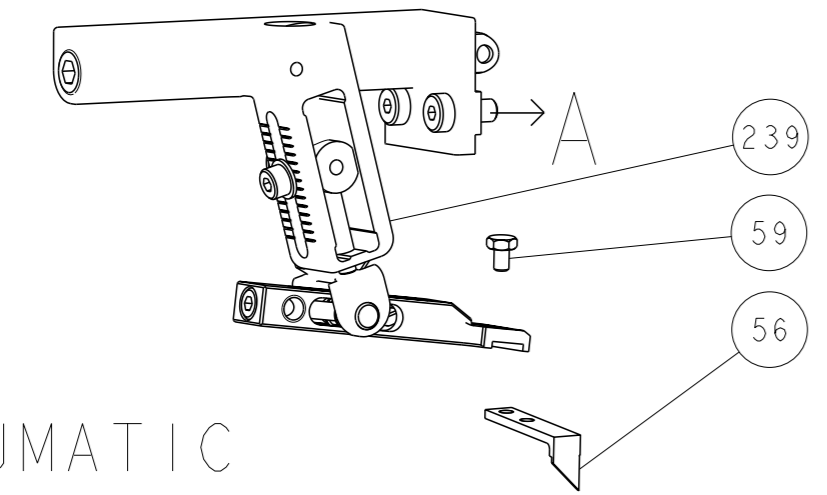
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		B		ECR-20-002544	21FEB2020	FJ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	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	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	22278-8	SPRING, COMPRESSION	77	
-	1	1	1	1	854769-1	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	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50	
-	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	1-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-0	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	9-1633138-8	ANVIL, COMBINATION	8
-	1	1	1	1	240641-1	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119780-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	4-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-8	SPACER, CRIMPER	2	
-	1	2	2	1	1	4-1633588-1	CRIMPER, WIRE	1
-	77	72	71	-2	-1	PART NO	ITEM NO	

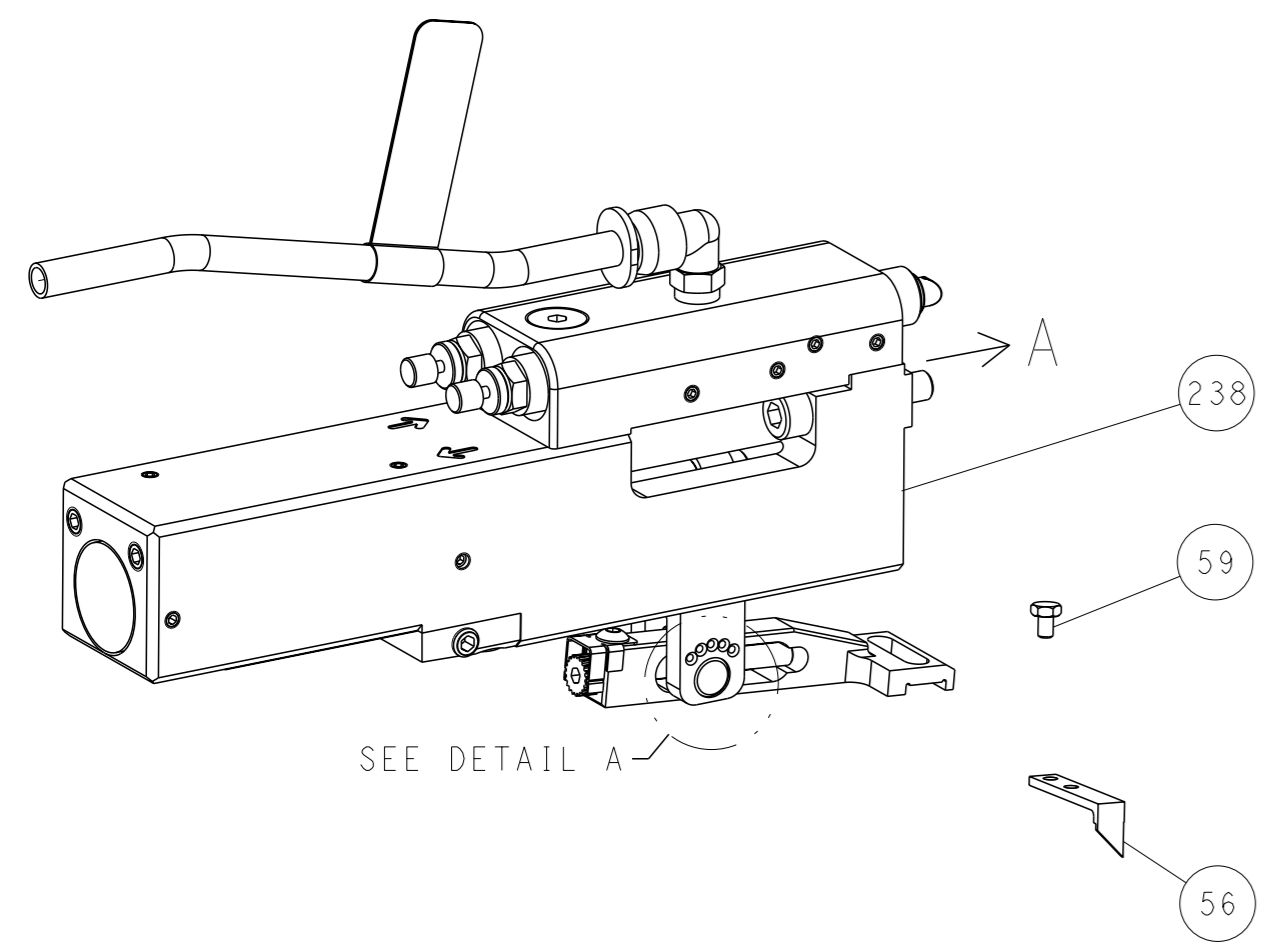
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL		FINISH		WEIGHT		SCALE	
-		-		-		1:2	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

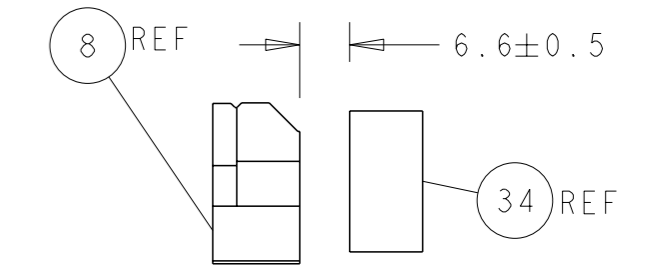
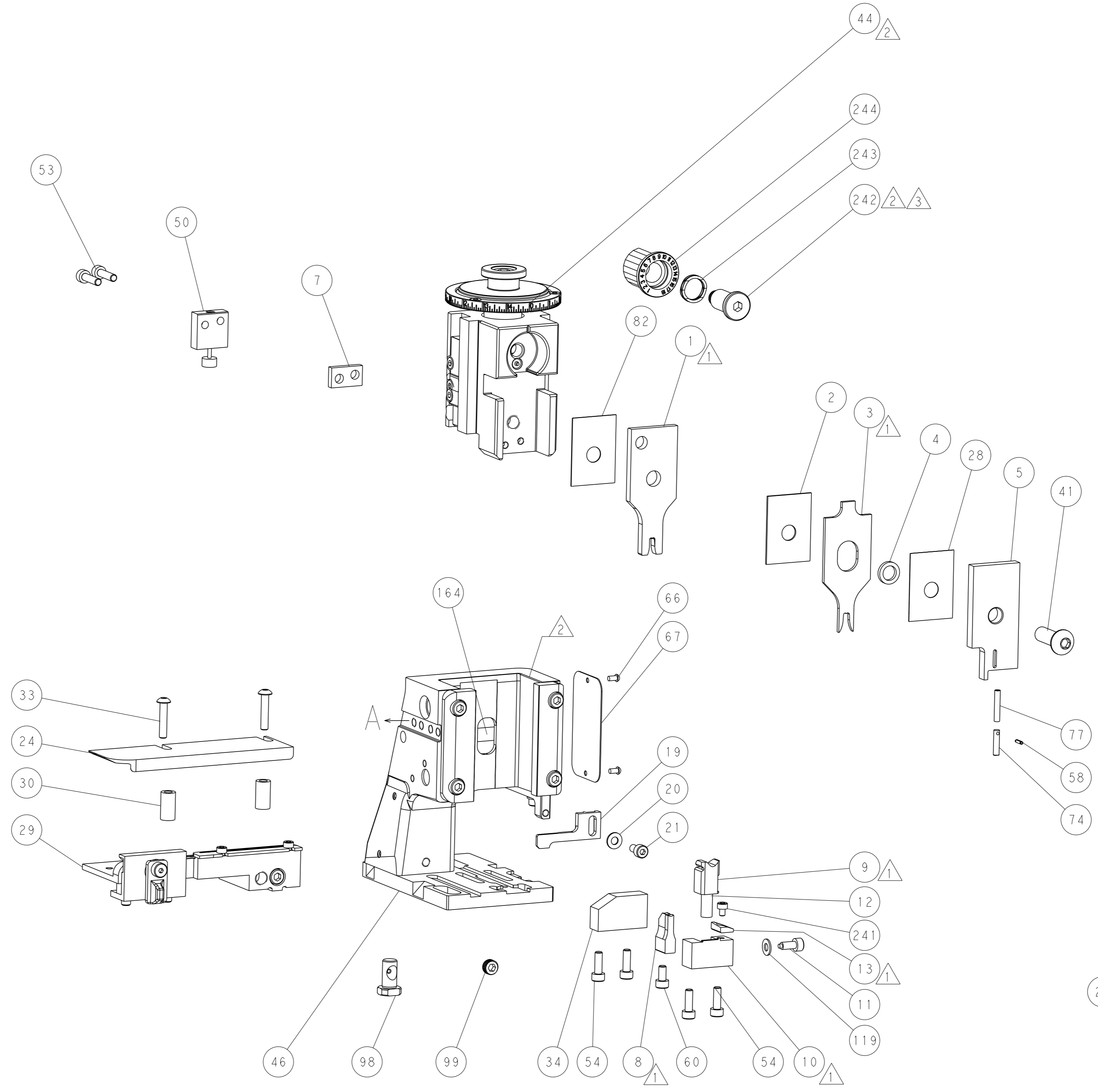
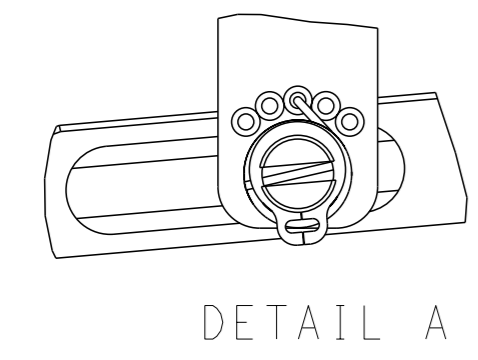
# FEED TYPE MECHANICAL



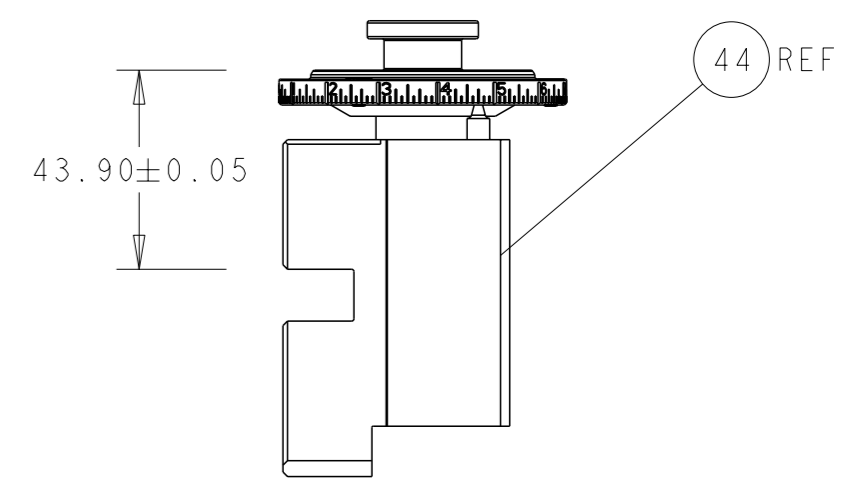
## PNEUMATIC



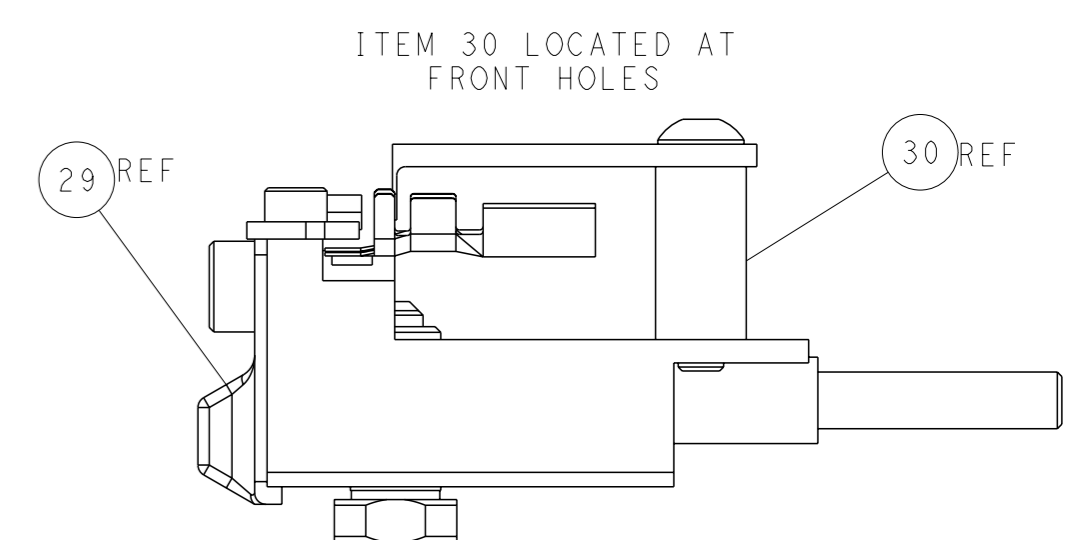
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

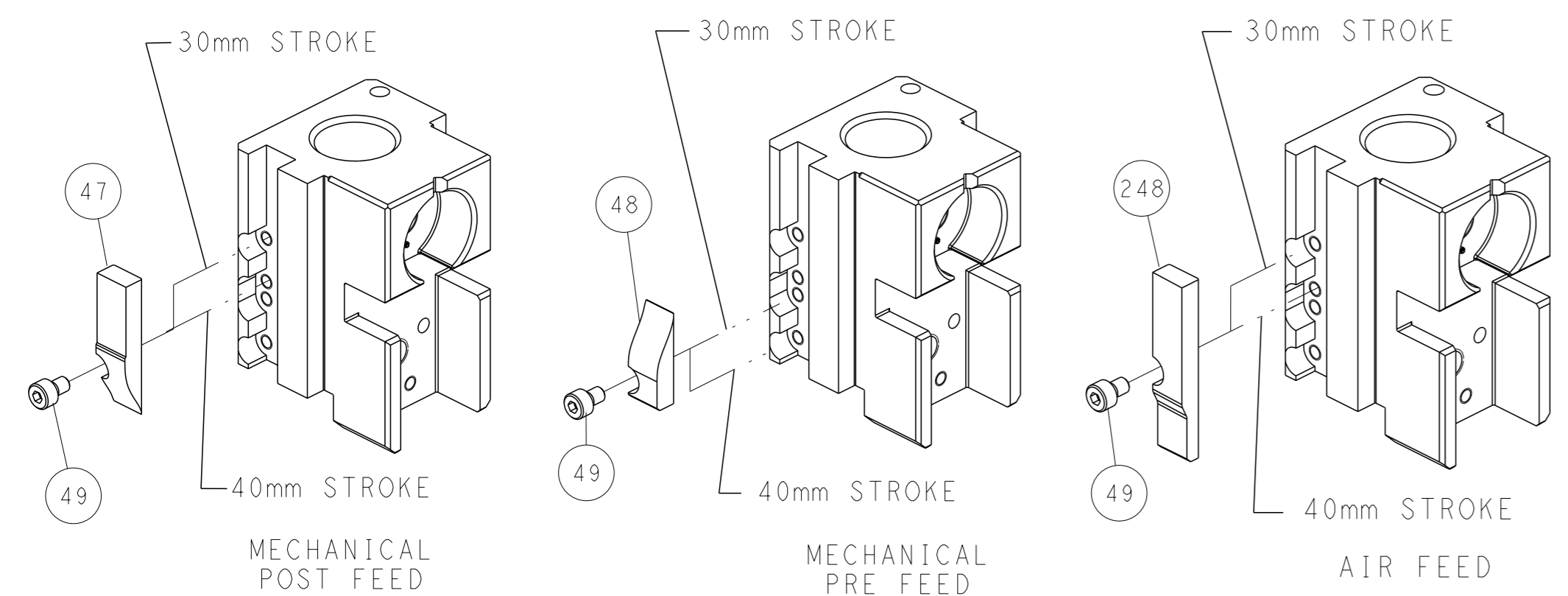


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

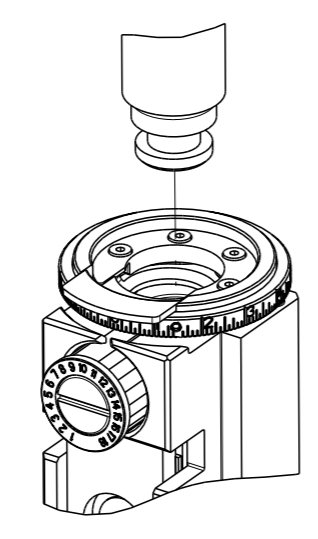


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: H. HUANG CHK: S. XI APVD: S. XI PRODUCT SPEC: 04JUN2012 APPLICATION SPEC:	DATE: 04JUN2012 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151454 RESTRICTED TO: Customer Accessible Production Drawing
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH: *	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: B	TE Connectivity Harrisburg, PA 17105-3608	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151454-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151454-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151454-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.92 mm [.115]	F
INSUL	3.68 mm [.145]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL MINI F280			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.30-5.70 mm [.209-.224 IN]		Ø3.00-4.00 mm [.118-.157 IN]	
TERMINAL APPLICATION SPECIFICATION	B0-018.009A	-	-
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
1949757-1	17.08332/20		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	1.90+/-0.05 [.075+/-0.002]	6.5
3.00mm2	1.80+/-0.05 [.071+/-0.002]	7.5
2.50mm2	1.70+/-0.05 [.067+/-0.002]	8.3



- 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. 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)

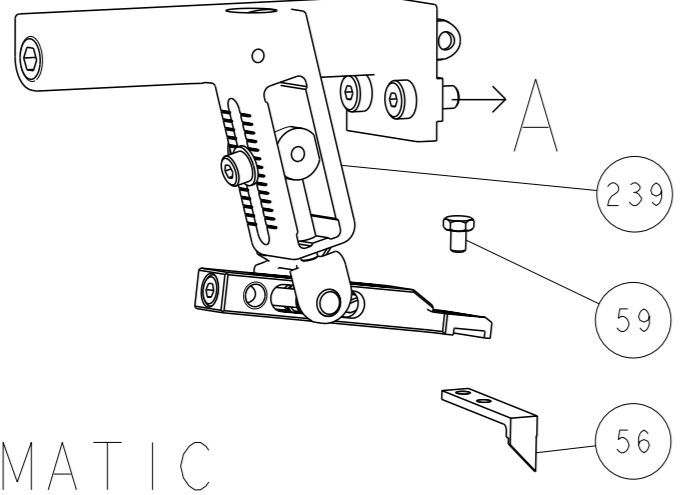
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
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-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	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
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	854769-1	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
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	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	1-1752356-3	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	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	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	1	1	9-1633138-8	ANVIL, COMBINATION	8
-	1	1	240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119780-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	4-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
1	1	1	4-1633588-1	CRIMPER, WIRE	1
-	77	-22	-21	PART NO	ITEM NO

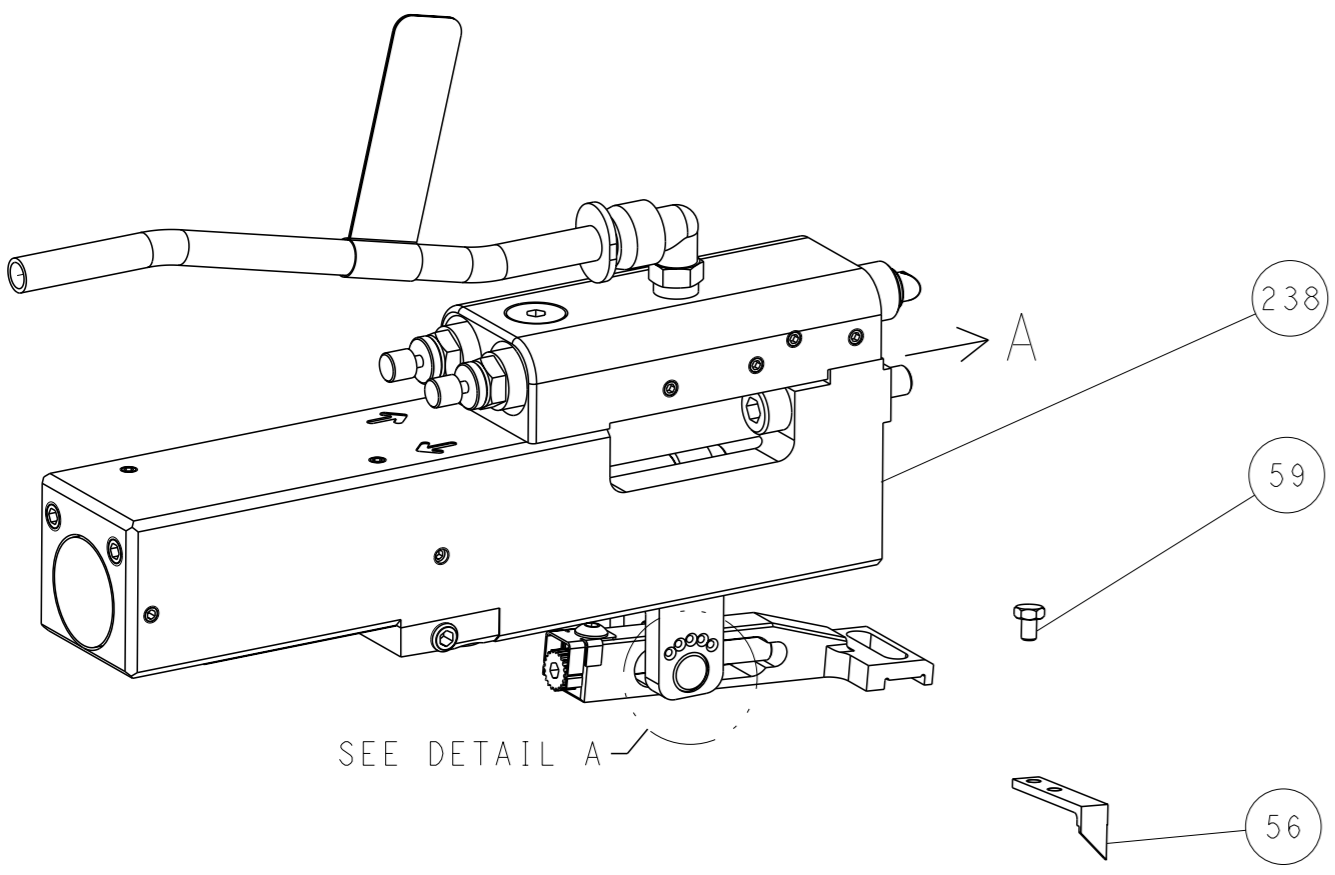
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: H. HUANG	DATE: 04JUN2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	APVD: S. YI	DATE: 04JUN2012	
		3 PLC ±	4 PLC ±	PRODUCT SPEC		NAME: Ocean Side Feed Applicator
MATERIAL:		FINISH:	ANGLE:	APPLICATION SPEC		
WEIGHT:		SCALE:		SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2151454
RESTRICTED TO:		SCALE: 1:2		SHEET 3 OF 4		REV B

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

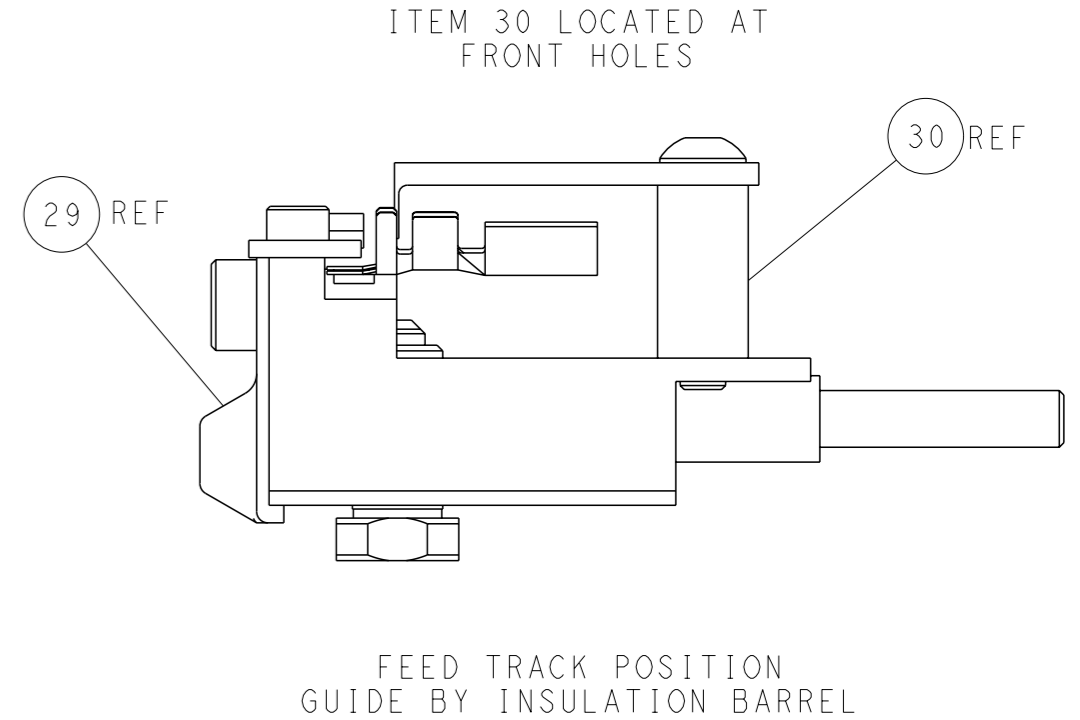
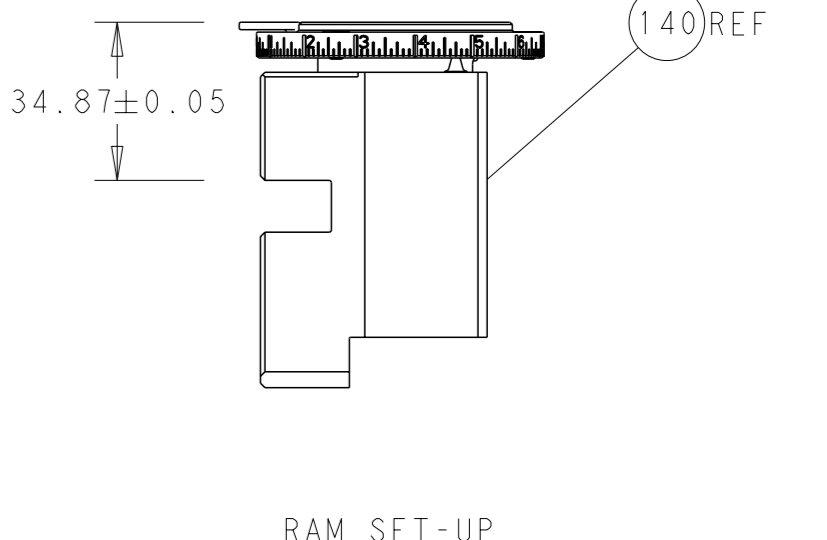
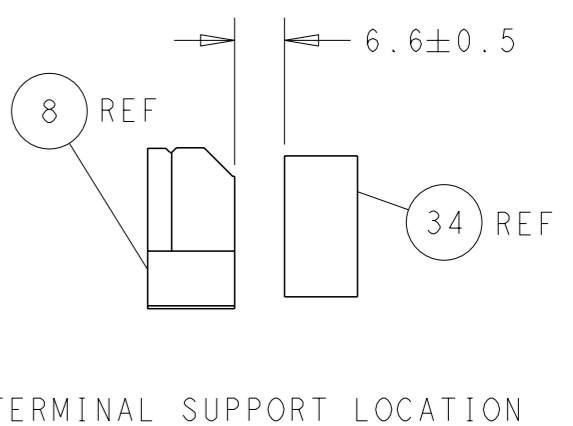
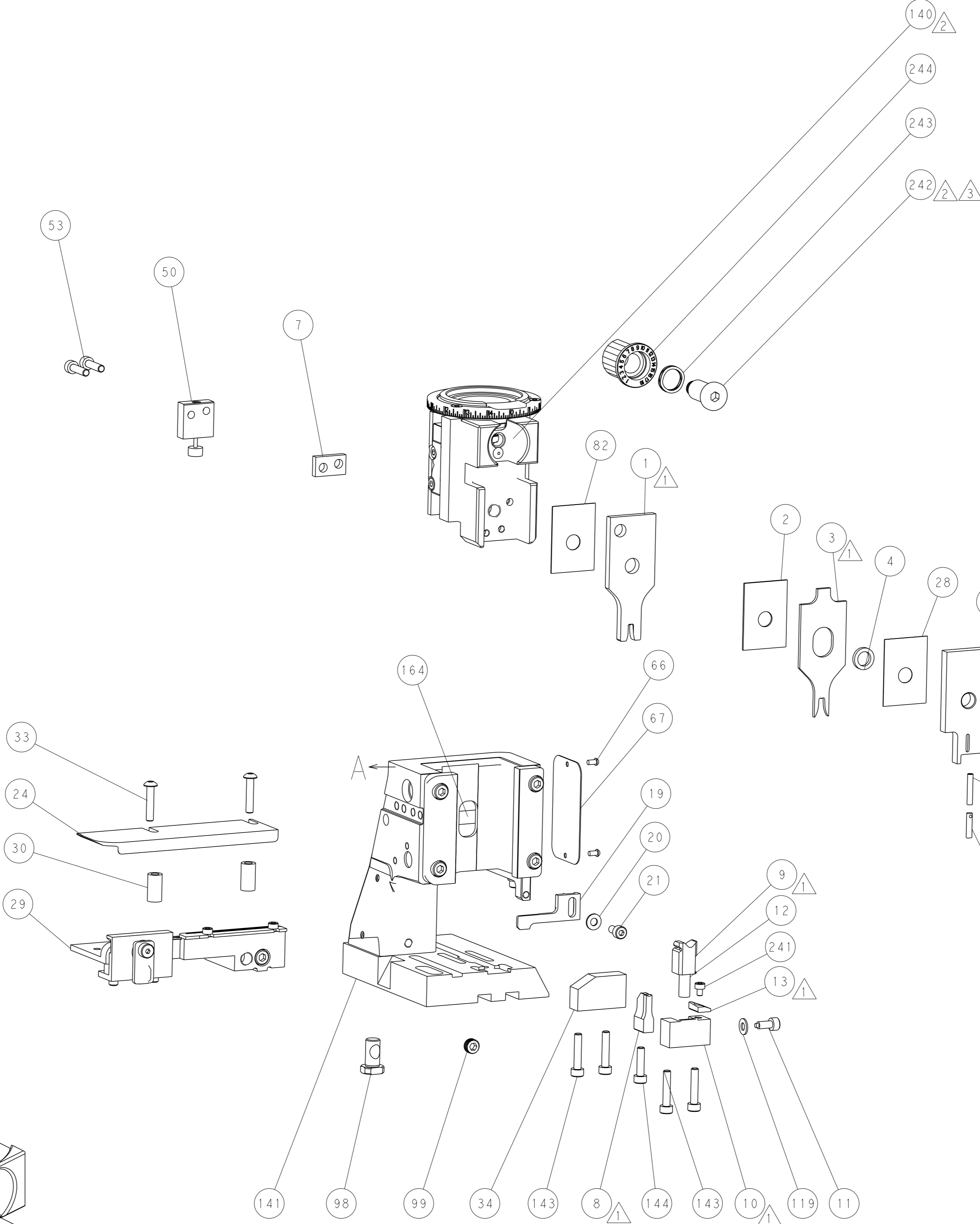
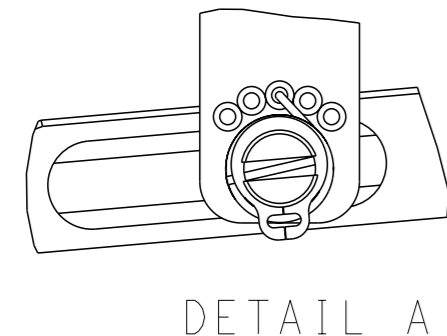
# FEED TYPE MECHANICAL



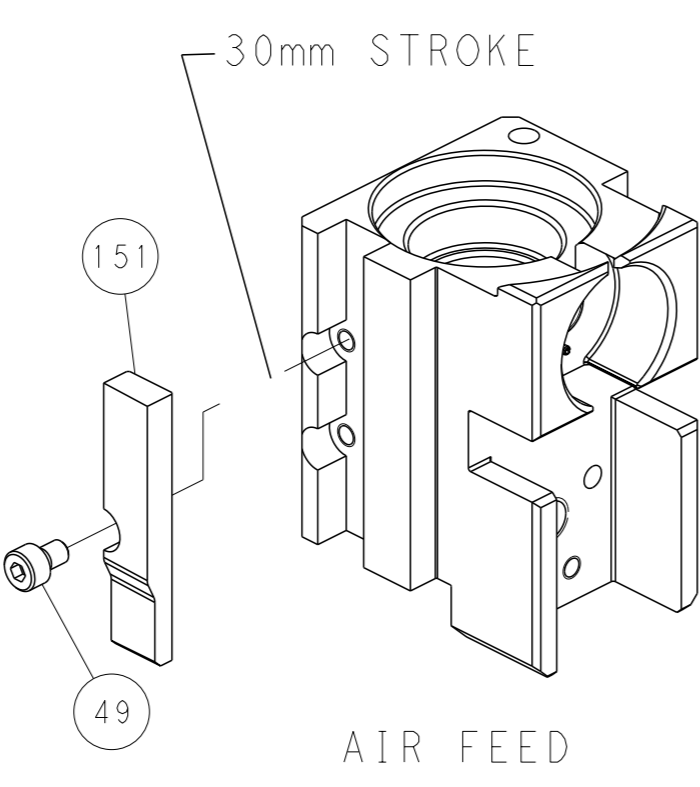
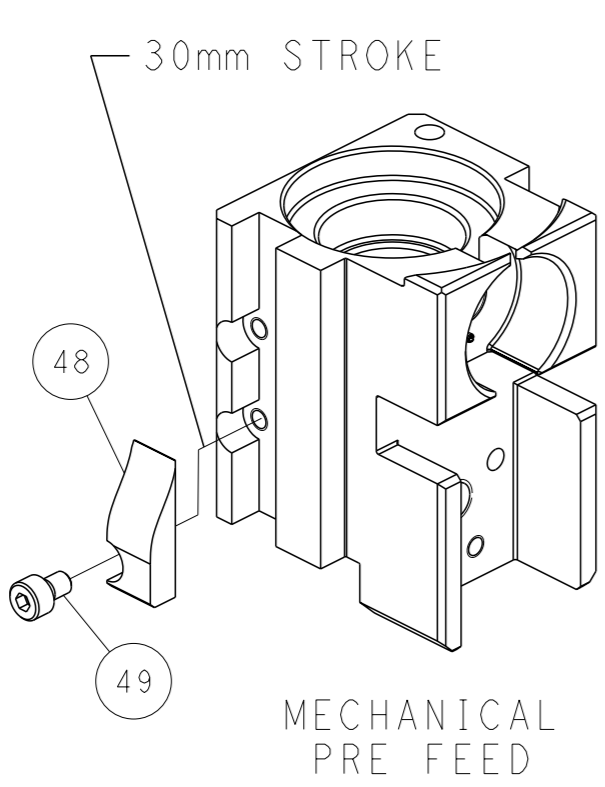
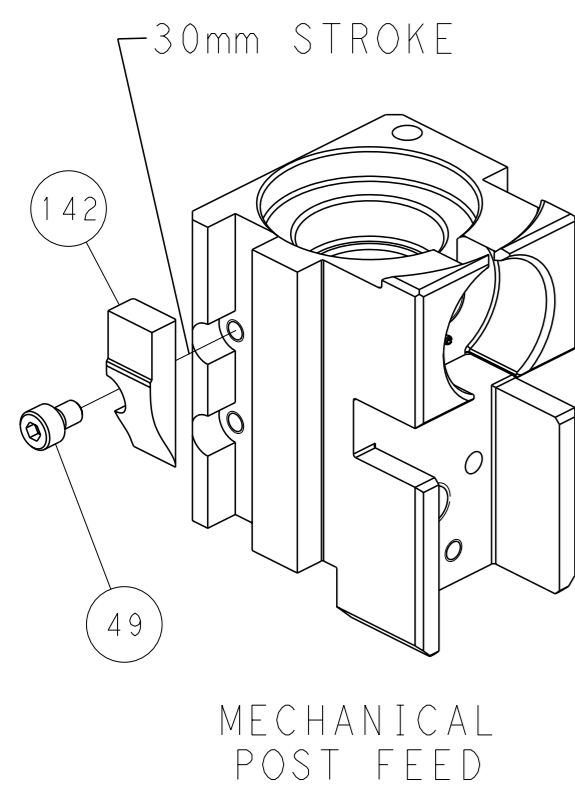
## PNEUMATIC



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



# 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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		OWN: H. HUANG CHK: S. XI APVD: S. XI PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:		DATE: 04JUN2012 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151454 SCALE: 1:2 SHEET: 4 of 4 REV: B		TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO	
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