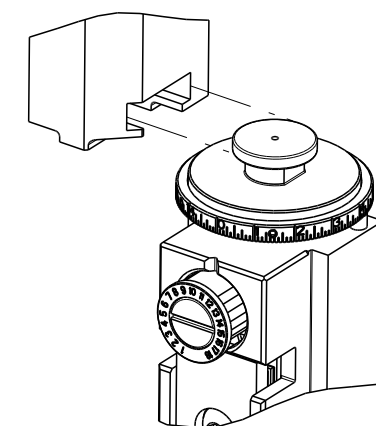


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151951-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151951-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151951-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

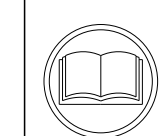


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.00 mm [.157]	F
INSUL	6.20 mm [.244]	OV

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 8mm NGI+ FEMALE TERMINAL W/SEAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
6.20-6.58 mm [.244-.259 IN]	Ø3.34-4.69 mm [1.131-.185 IN]		
TERMINAL APPLICATION SPECIFICATION	114-15106		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1544965-1	1544965-2	1544316-1	1544664-1
		1544316-2	1544664-2
		1544970-1	1544970-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
7.00mm2	2.80 +/- 0.05 [1.110 +/- .002]	6.2
6.00mm2	2.80 +/- 0.05 [1.110 +/- .002]	6.3
5.00mm2	2.45 +/- 0.05 [1.096 +/- .002]	10.0



- 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 ITEM 180. 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	1		DEVELOPMENT	28APR2013	CC	UG
		A		RELEASED	24FEB2014	YY	UG
		B		ECR-18-007751	20MAY2018	TB	JDG
		C		ECR-19-009764	22JUN2019	TB	TE

-	1	1	455888-3	SPACER, CRIMPER	268
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	267
-	1	1	1976053-2	LOCATER BLOCK, TERMINAL	266
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	265
-	1	1	1633782-4	FENCE	264
-	2	2	22283-1	SPRING, COMPRESSION	263
-	1	1	1-690438-0	FRONT STRIP GUIDE	262
-	1	1	240792-1	DRAG, TERMINAL	261
-	1	1	1803078-2	SPACER, PRECISION	259
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-6	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	2844940-2	AIR FEED MODULE	238
-	1	1	2-1752354-8	STANDOFF, HOLD-DOWN	180
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	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	455888-4	SPACER, CRIMPER	82
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1-2119791-1	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	58
-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	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	1901681-4	HOLDDOWN, TERMINAL	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1-1803583-7	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1320928-6	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	4-22280-7	SPRING, COMPRESSION	12
-	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1-2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	318059-9	FLOATING SHEAR, FRONT	9
-	1	2	1-4-1803054-0	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1803080-4	DEPRESSOR, SHEAR	5
-	1	1	5-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	1-4-2119785-8	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	1-3-1633860-0	CRIMPER, WIRE	1

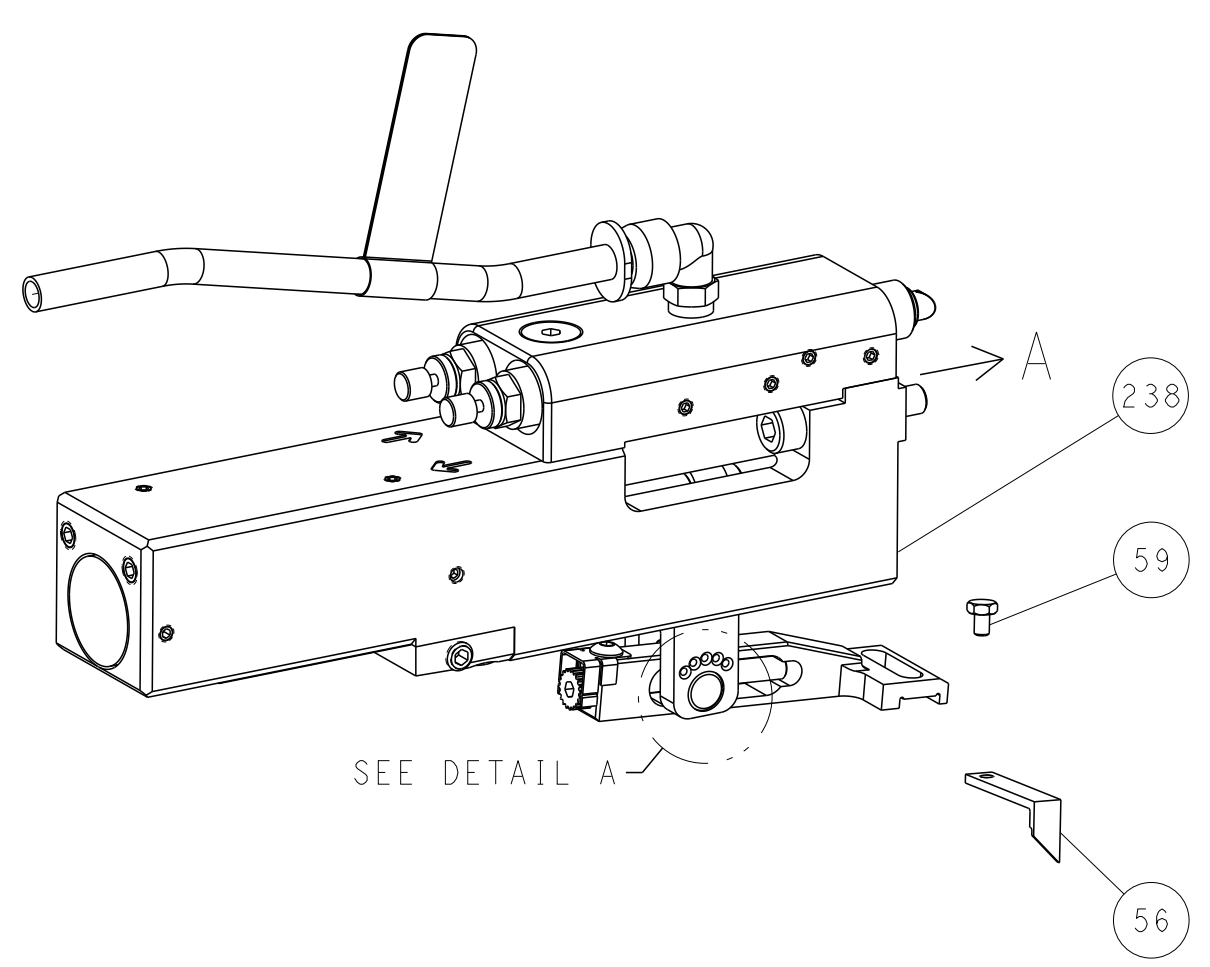
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

OWN	C. CHEN	28APR2013
CHK	U. GUO	28APR2013
APVD	J. CRUZ	28APR2013
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151951
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	C	

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

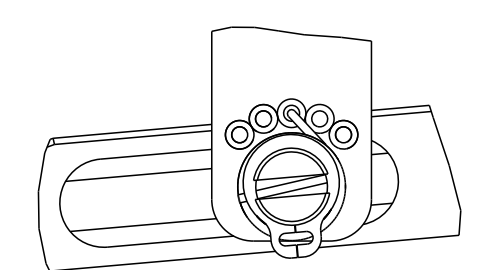
### FEED TYPE

#### PNEUMATIC



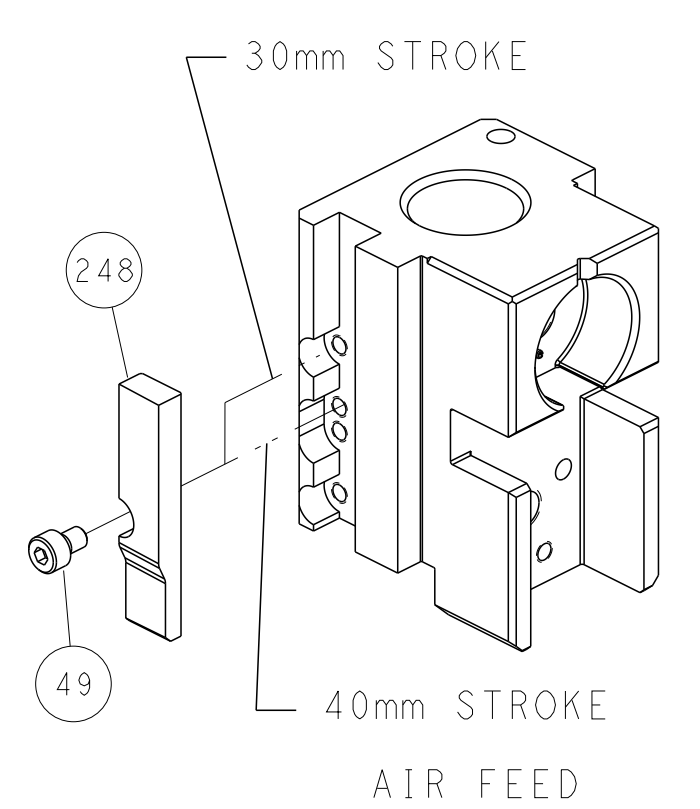
SEE DETAIL A

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

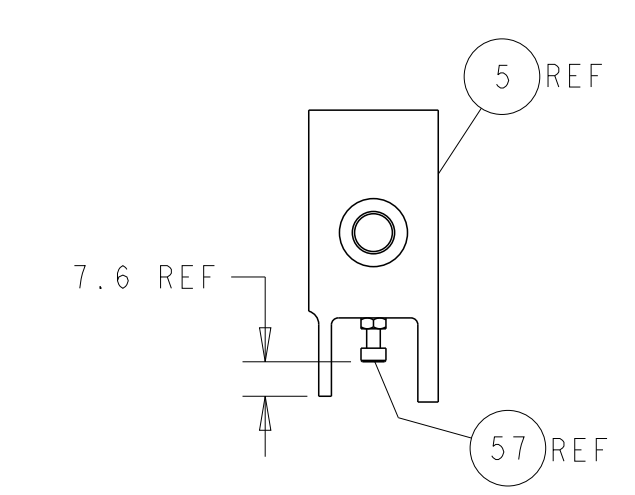
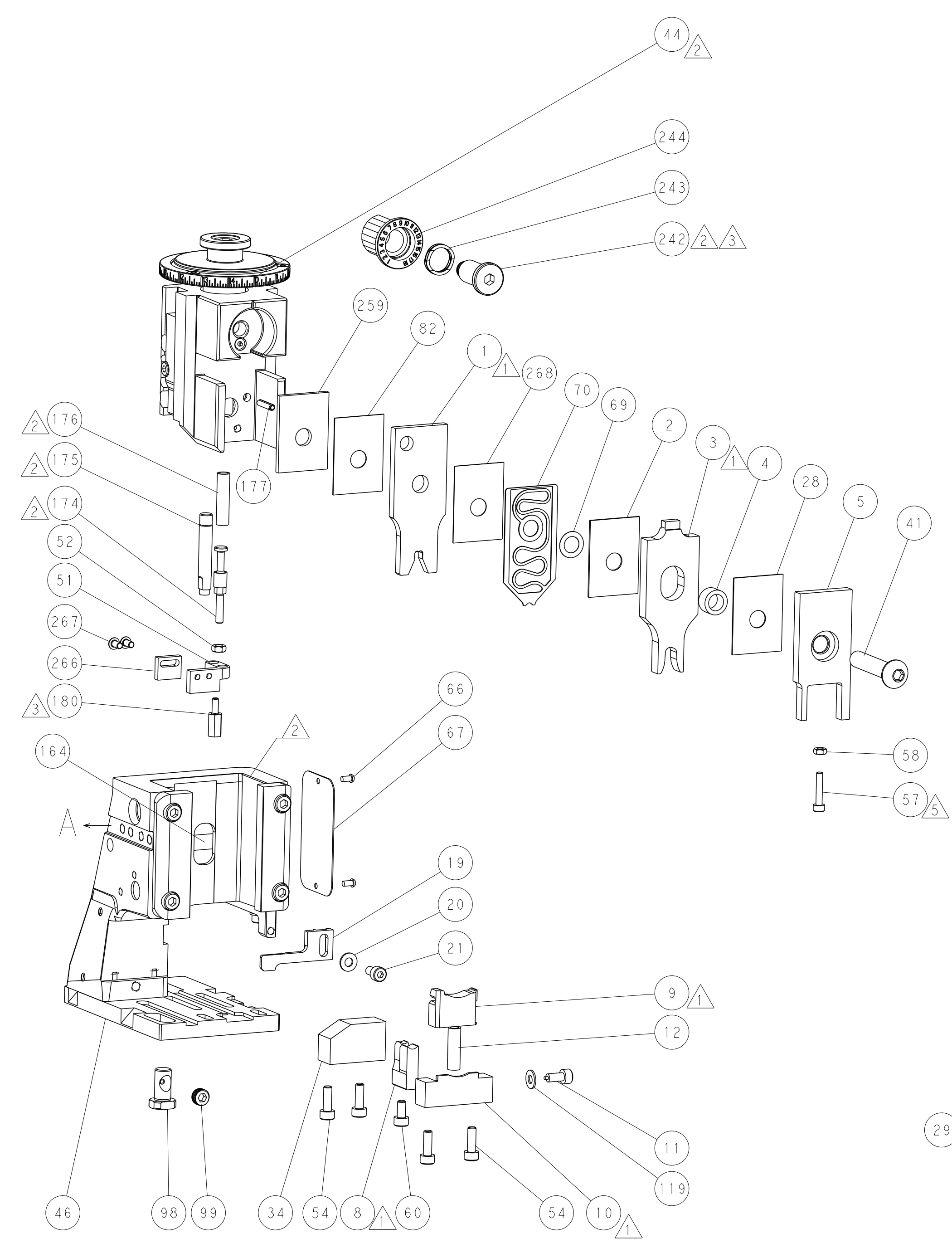
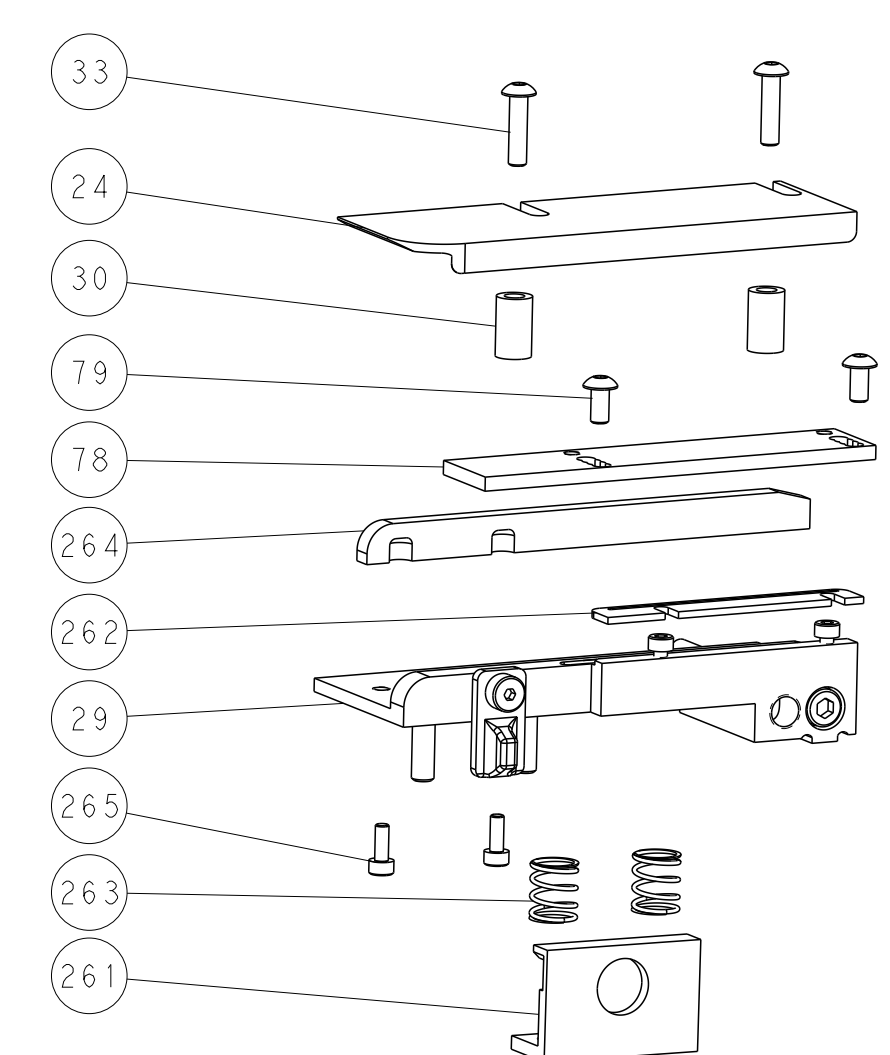


DETAIL A

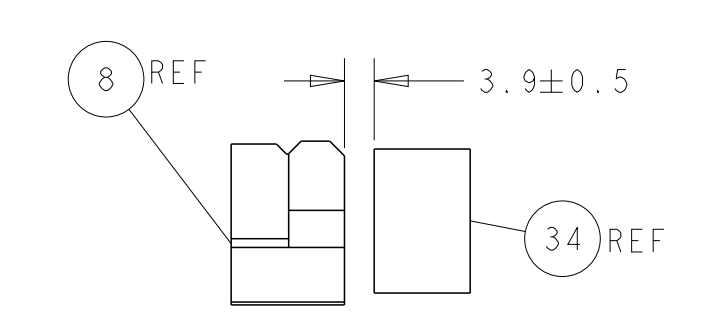
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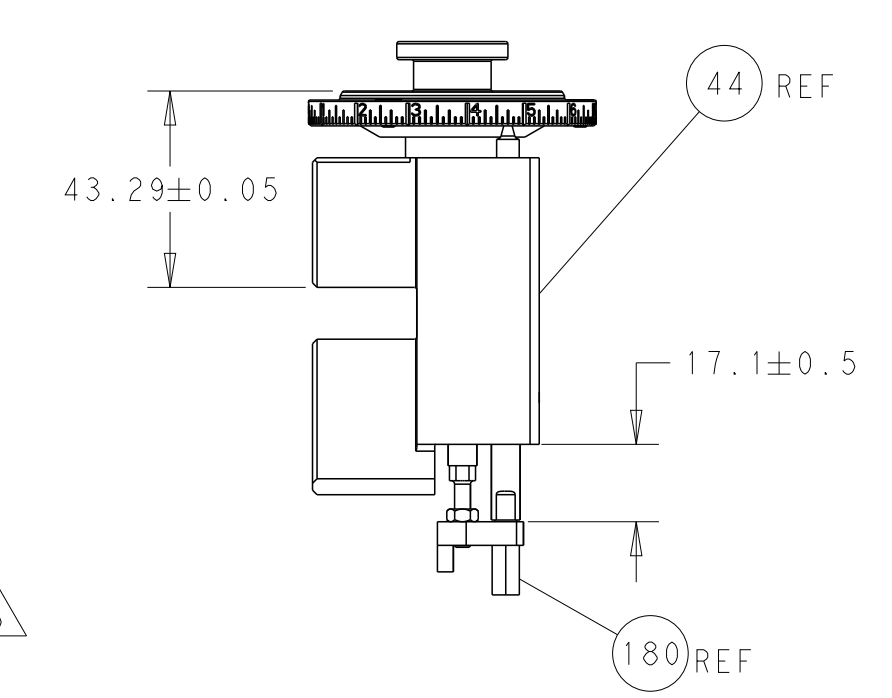
AIR FEED



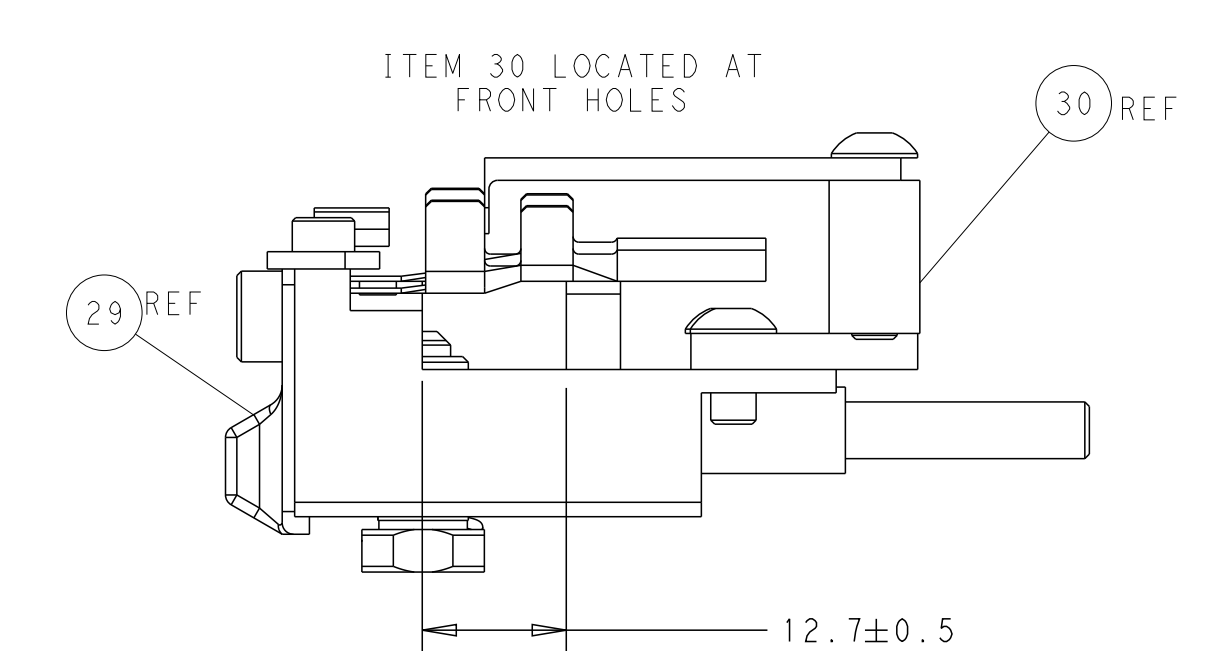
SHEAR DEPRESSOR DETAIL



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE POLICY OF TYCO ELECTRONICS CORPORATION TO CONTINUE TO IMPROVE ITS PRODUCTS. THEREFORE, THIS DRAWING IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT OBLIGATION TO NOTIFY OR TO PROVIDE A TRANSITION PERIOD. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN C. CHEN 28APR2013 CHK U. GUO 28APR2013 APVD J. CRUZ 28APR2013	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-2151951 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151951-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151951-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.00 mm [1.57]	F
INSUL	6.20 mm [2.44]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 8mm NGI+ FEMALE TERMINAL W/SEAL			
WIRE STRIP LENGTH 6.20-6.58 mm [2.44-.259 IN]		INSULATION DIAMETER RANGE Ø3.34-4.69 mm [1.31-.185 IN]	
TERMINAL APPLICATION SPECIFICATION 114-15106	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1544965-1	1544965-2	1544316-1	1544664-1
		1544316-2	1544664-2
		1544970-1	1544970-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
7.00mm2	2.80+/-0.05 [1.10+/-0.02]	6.2
6.00mm2	2.80+/-0.05 [1.10+/-0.02]	6.3
5.00mm2	2.45+/-0.05 [0.96+/-0.02]	10.0



- 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 ITEM 180. 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 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

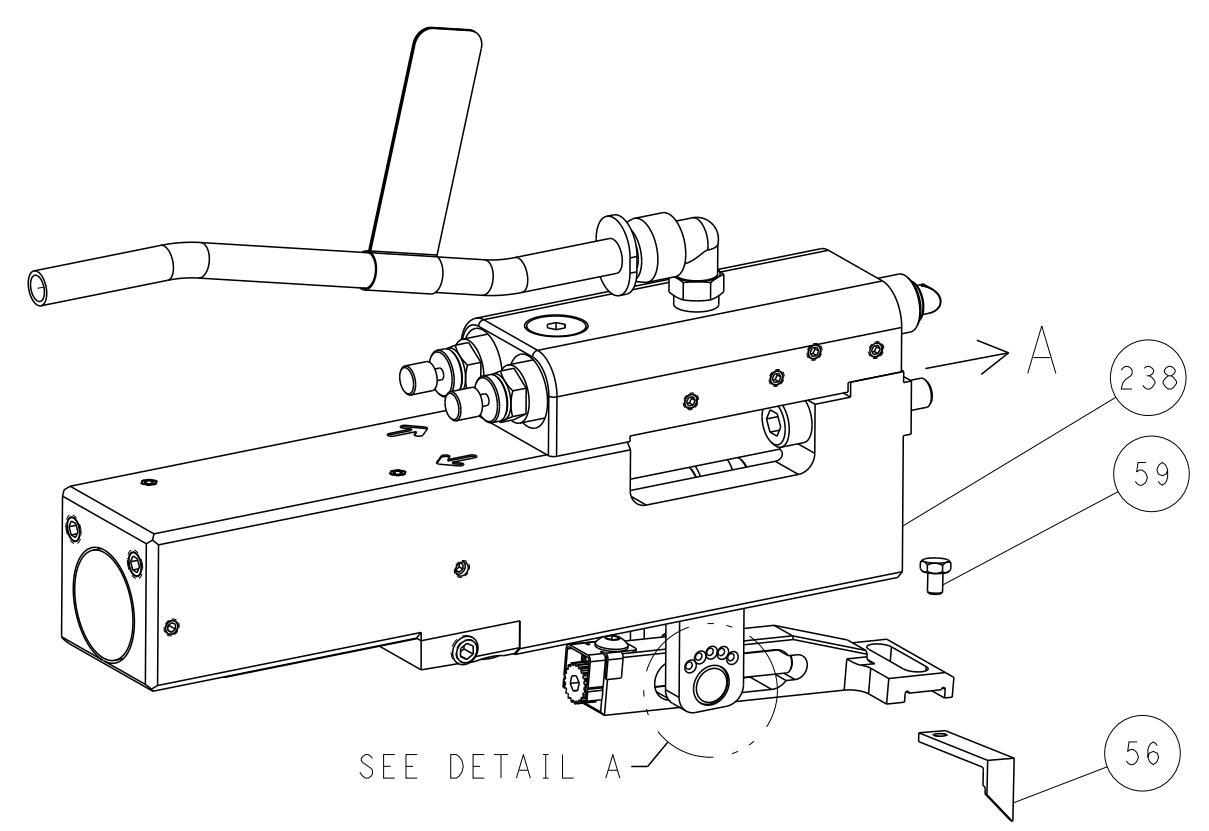
-	1	455888-3	SPACER, CRIMPER	268	
-	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	267	
-	1	1976053-2	LOCATER BLOCK, TERMINAL	266	
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	265	
-	1	1633782-4	FENCE	264	
-	2	22283-1	SPRING, COMPRESSION	263	
-	1	1-690438-0	FRONT STRIP GUIDE	262	
-	1	240792-1	DRAG, TERMINAL	261	
-	1	1803078-2	SPACER, PRECISION	259	
-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	2844940-2	AIR FEED MODULE	238	
-	1	2-1752354-8	STANDOFF,HOLD-DOWN	180	
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN,HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN,HOLDDOWN	174	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	1-1803583-8	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140	
-	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	455888-4	SPACER, CRIMPER	82	
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1803096-1	EXTENSION PLATE	78	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1-2119791-1	DEPRESSOR, WIRE	70	
-	1	2119943-1	WASHER, SPACER	69	
-	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	5018030-1	NUT, HEX, REG, RoHS, M3	58	
-	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57	
-	1	1338683-8	FEED PAWL	56	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1901681-4	HOLDDOWN, TERMINAL	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1752356-6	SUPPORT, TERMINAL	34	
-	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33	
-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-5	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-5	SPACER, CRIMPER	28	
-	1	1320928-6	STRIP GUIDE	24	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	4-22280-7	SPRING, COMPRESSION	12	
-	1	1-356885-3	STOP, SHEAR	11	
-	1	1-2119805-1	SHEAR HOLDER, FRONT	10	
-	1	318059-9	FLOATING SHEAR, FRONT	9	
-	1	1	4-1803054-0	ANVIL, COMBINATION	8
-	-	-	-	7	
-	-	-	-	6	
-	1	1803080-4	DEPRESSOR, SHEAR	5	
-	1	5-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	1	4-2119785-8	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	3-1633860-0	CRIMPER, WIRE	1
-	77	-22	PART NO	DESCRIPTION	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		DWN C. CHEN 28APR2013 CHK U. GUO 28APR2013 APVD J. CRUZ 28APR2013 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 3 OF 4 REV C	NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151951 RESTRICTED TO Customer Accessible Production Drawing
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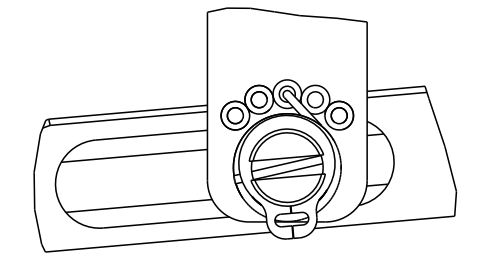
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

### FEED TYPE PNEUMATIC



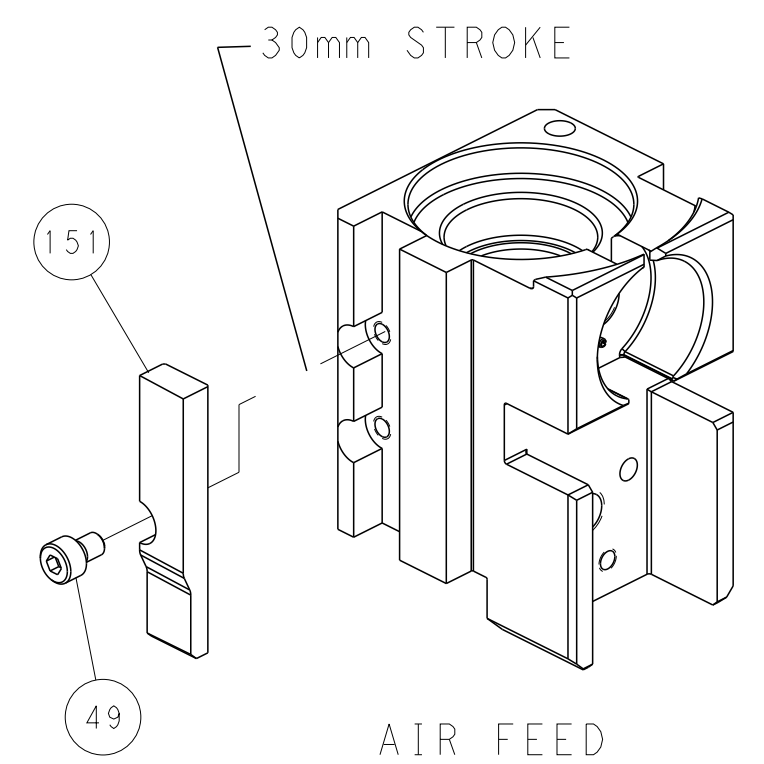
SEE DETAIL A

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

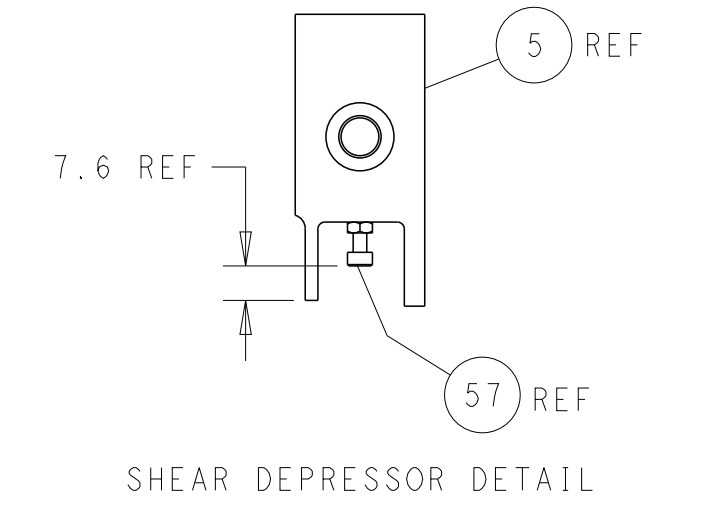
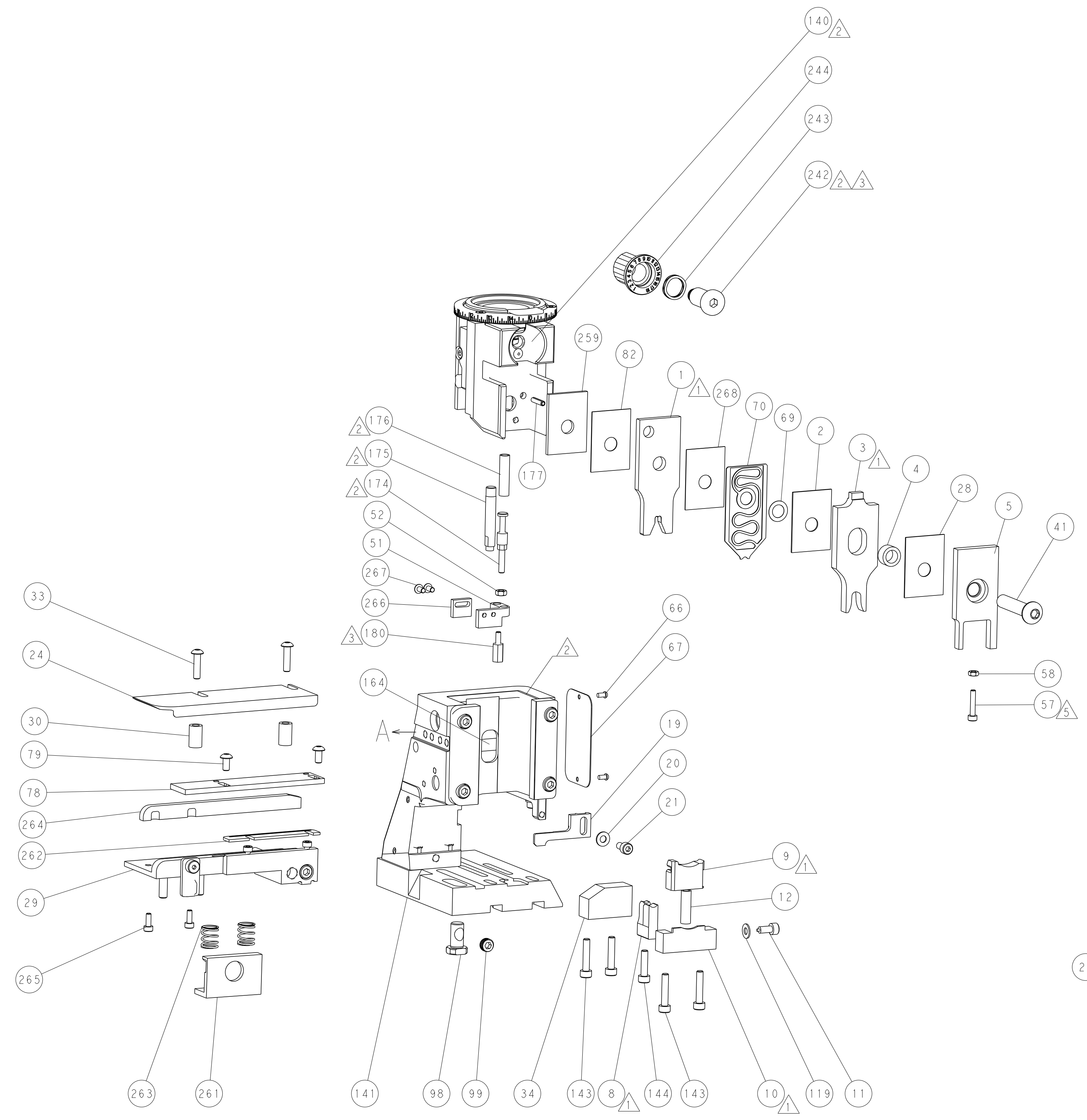


DETAIL A

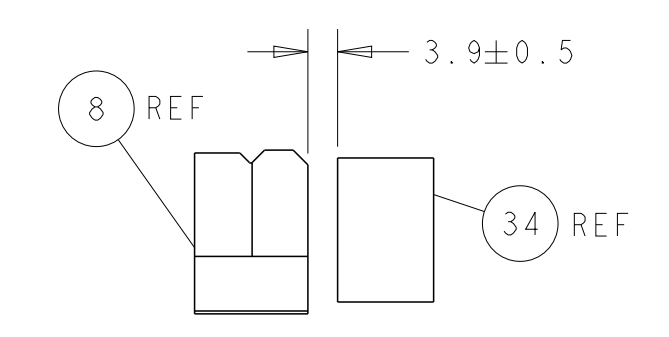
### CAM POSITION



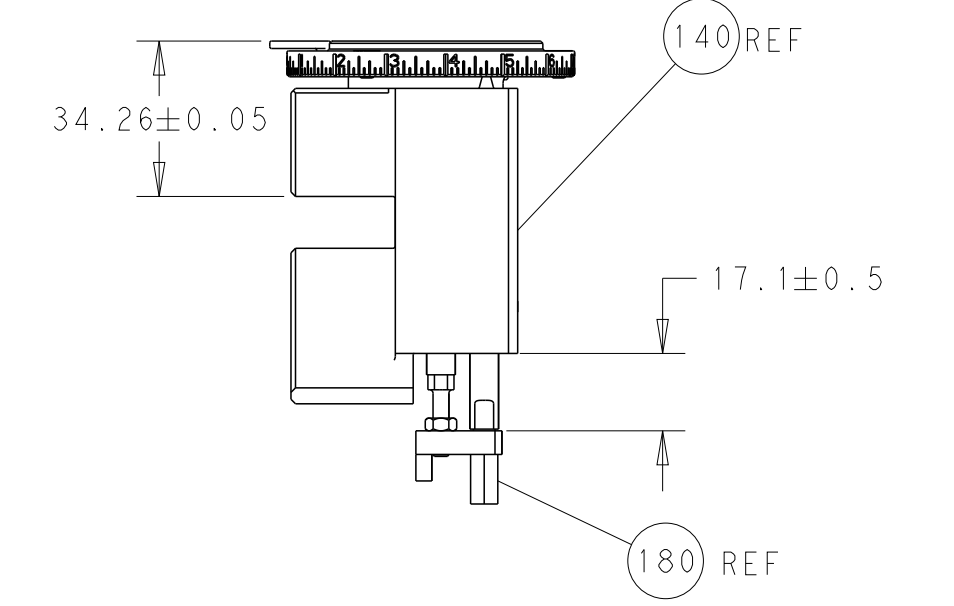
AIR FEED



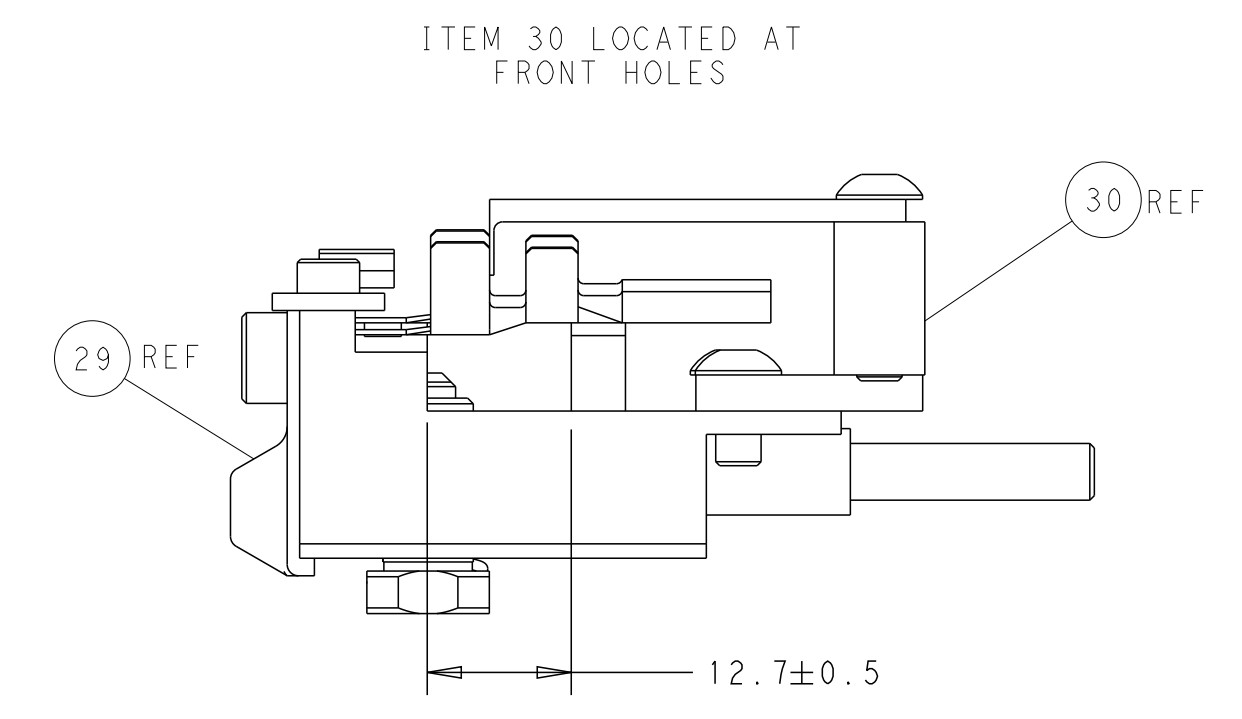
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION 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 ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151951 SCALE: 1:2 SHEET: 4 OF 4 REV: C	RESTRICTED TO: -
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	