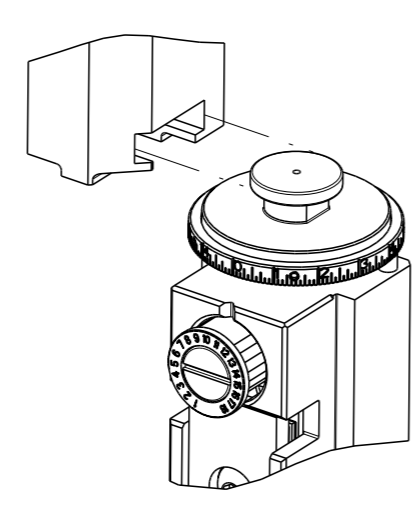


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151316-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151316-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151316-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.59 mm [.220]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: POWER RING

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.95-6.75 mm [.234-.266 IN]	Ø2.79-4.06 mm [.110-.160 IN]

TERMINAL APPLICATION SPECIFICATION 114-2087

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63166-1	63166-2	63166-4	63166-5
521843-1	521844-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 14 AWG	3.07+/-0.05 [.121+/- .002]	3.7
12 AWG	2.90+/-0.05 [.114+/- .002]	5.1
14 AWG	2.64+/-0.05 [.104+/- .002]	8.0
16 AWG	2.46+/-0.05 [.097+/- .002]	10.4

- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- WIRE STRIP LENGTHS LISTED ARE FOR AWG WIRE. WIRE STRIP LENGTHS FOR HOUSEHOLD WIRE IS: 18.65-19.45 mm [.734-.766 IN].
- CUT TO LENGTH AT ASSEMBLY.
- REMOVE ITEMS 51 & 52 WHEN RUNNING TERMINALS 521843-1 & 521844-1.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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 A DIST 66

REV	DATE	DESCRIPTION	DATE	OWN	APVD
A1	15JUN2016	ECR-16-008694		MR	TE
B	26MAR2018	ECR-18-004534		MEH	JDG
C	08APR2020	ECR-20-005218		FJ	TE
D	28MAY2020	ECR-20-007667		JAH	GB

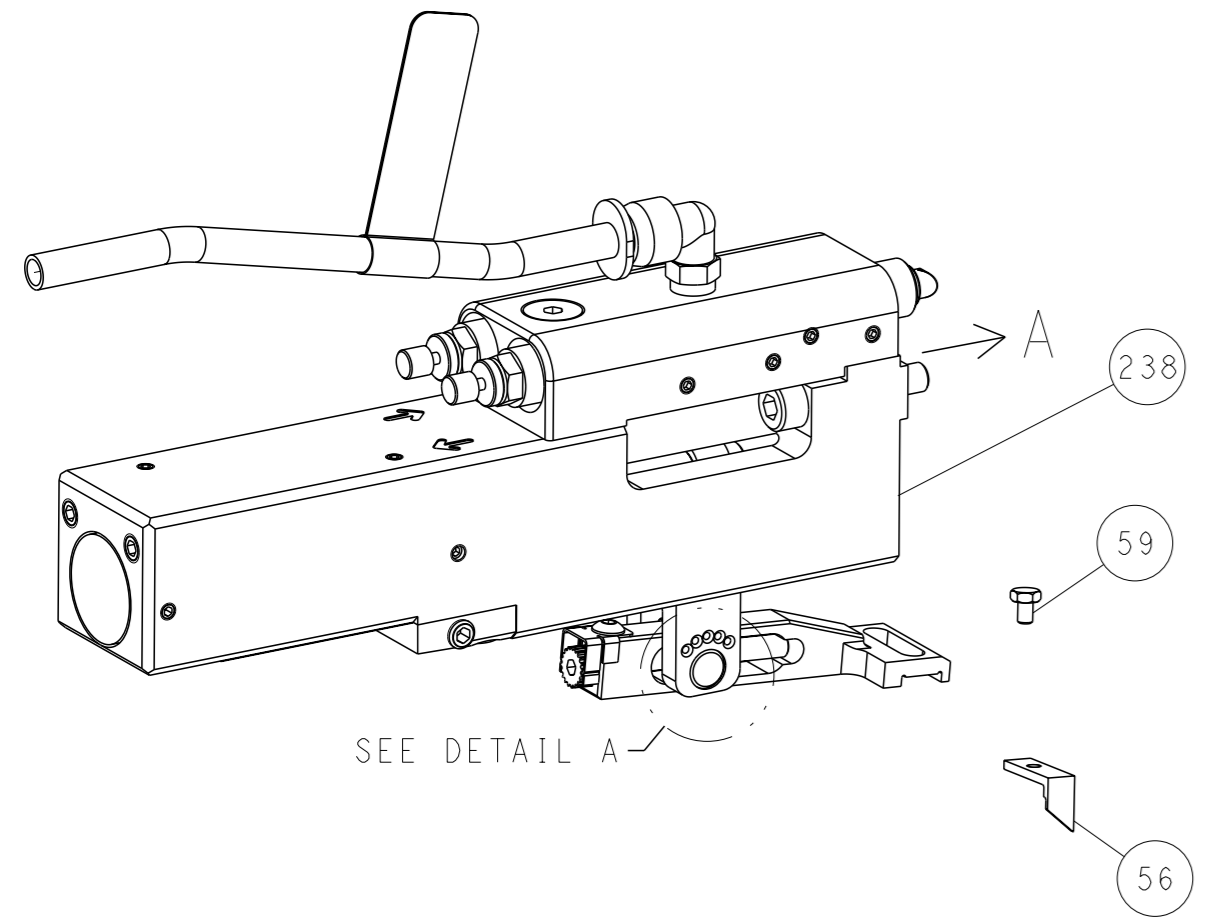
-	1	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	283
-	1	1	1803315-1	LOWER SHEAR, RIGHT	282
-	1	1	1-18028-3	WASHER, FLAT, REG M5	281
-	1	1	1803196-1	STUD, ADJUSTMENT SCREW	280
-	1	1	23238-1	INSERT, COUPLING	278
-	1	1	2030758-3	TUBING, POLYURETHANE	277
-	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	276
-	1	1	986220-2	CLAMP, CABLE, BLACK	275
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	274
-	1	1	1803319-1	SUPPORT, AIR BLAST	273
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	269
-	1	1	3-18031-6	SCR, SET, CUP POINT M2.5 X 3.0	266
-	2	2	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	265
-	1	1	1803313-1	SLUG BLADE	264
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	263
-	1	1	1803312-1	LOWER SHEAR, LEFT	262
-	1	1	9-240641-0	SPACER	261
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-4	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	2844940-1	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-22281-6	SPRING, COMPRESSION	121
-	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	1803310-1	STRIP GUIDE, FRONT	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-7	SCR, SKT HD CAP, RoHS, M3 X 30	93
-	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
-	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	1338683-9	FEED PAWL	56
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-6	BUMPER, HOLD DOWN	51
-	1	1	1803311-1	HOLDER, SLUG BLADE	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1803309-2	PLATE, STRIP GUIDE	29
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	3-690754-8	DRAG, SPECIAL	25
-	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
-	5	5	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	-	-	-	-	10
-	-	-	-	-	9
-	-	-	-	-	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	1-1633966-1	CRIMPER, INSULATION O	3
-	1	1	1-455888-3	SPACER, CRIMPER	2
-	1	2	3-456411-0	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	
-	-	-	-	DESCRIPTION	
-	-	-	-	ITEM NO	

DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN R. KNEPPER 21-Oct-15 CHK G. BAILEY 21-Oct-15 APVD T. ELBIN 21-Oct-15 NAME Ocean Side Feed Applicator SIZE CASE CODE DRAWING NO RESTRICTED TO A1 00779 ©=2151316 Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV D	
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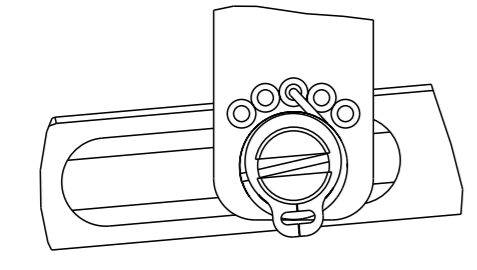
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-

FEED TYPE

PNEUMATIC

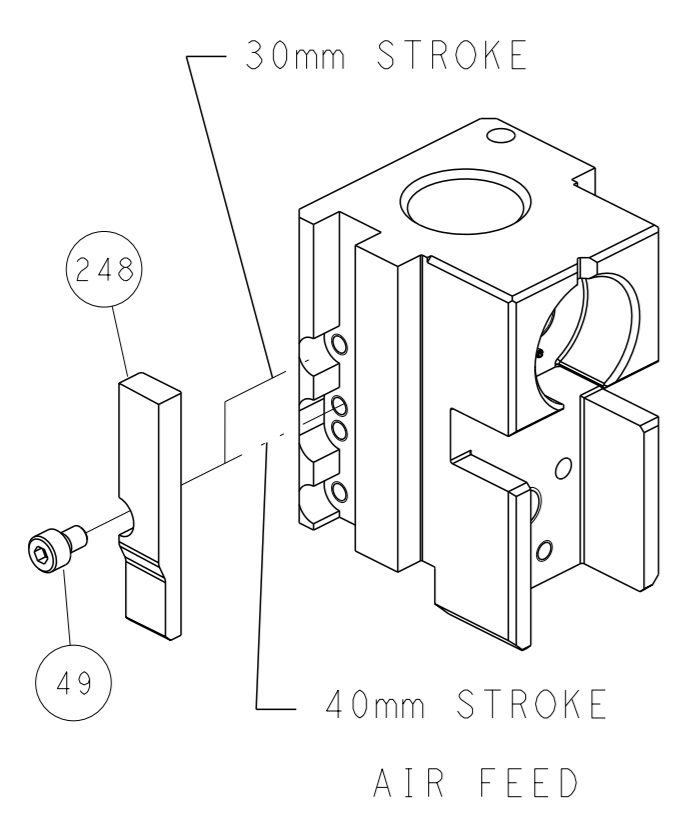


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

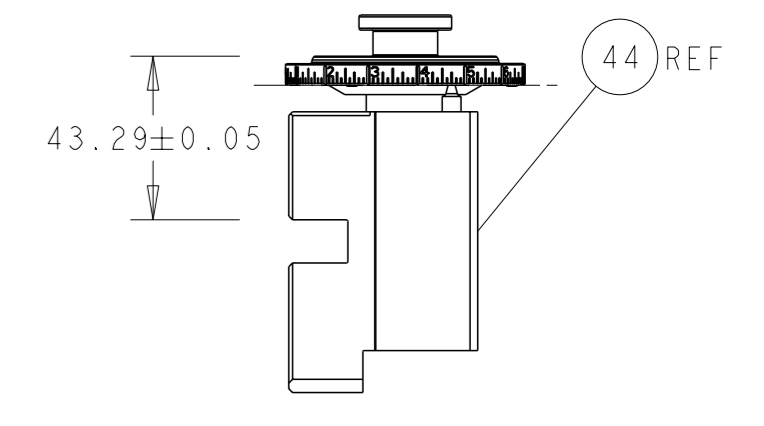
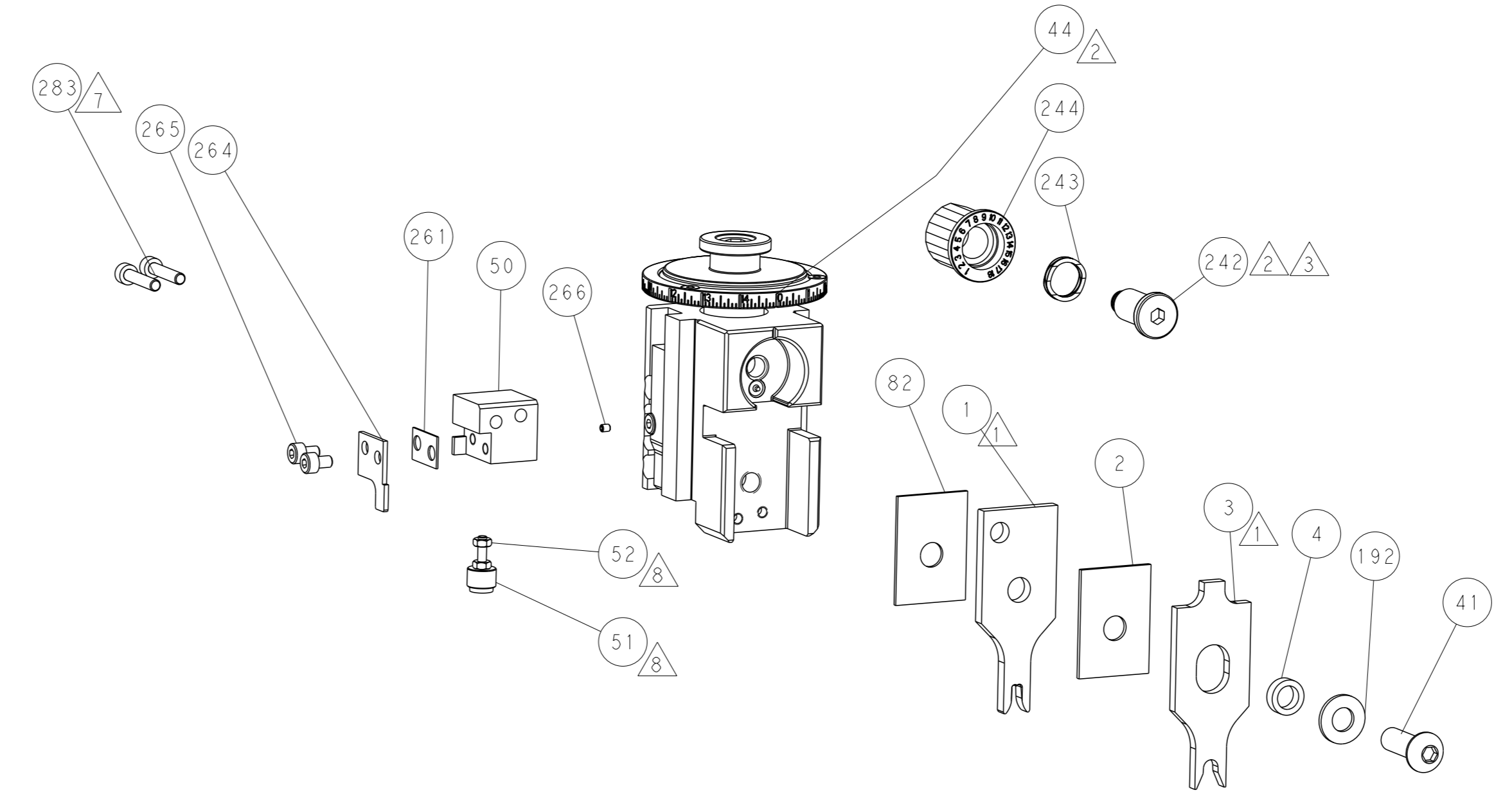


DETAIL A

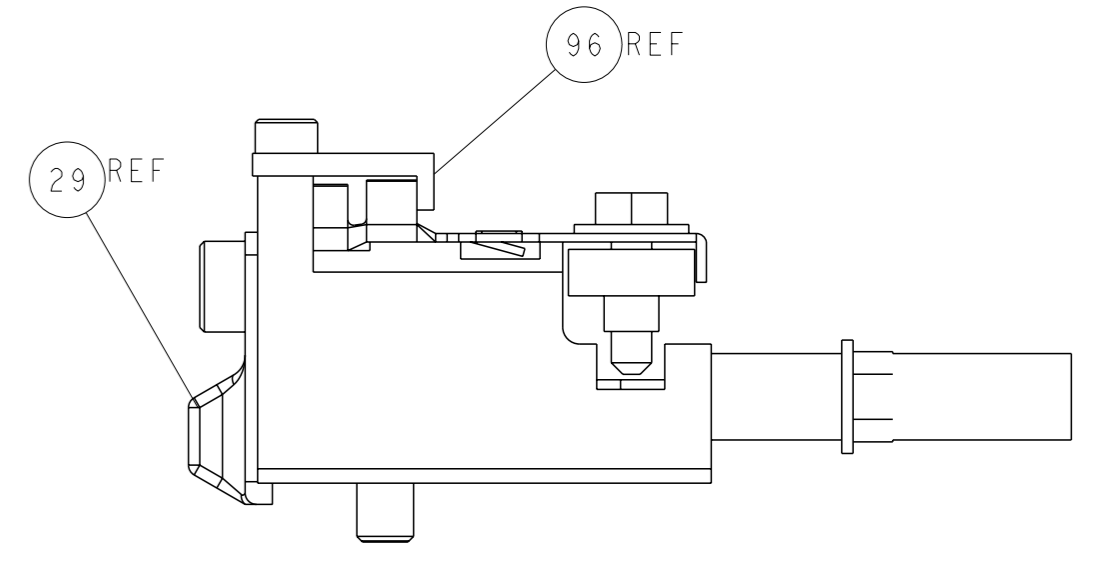
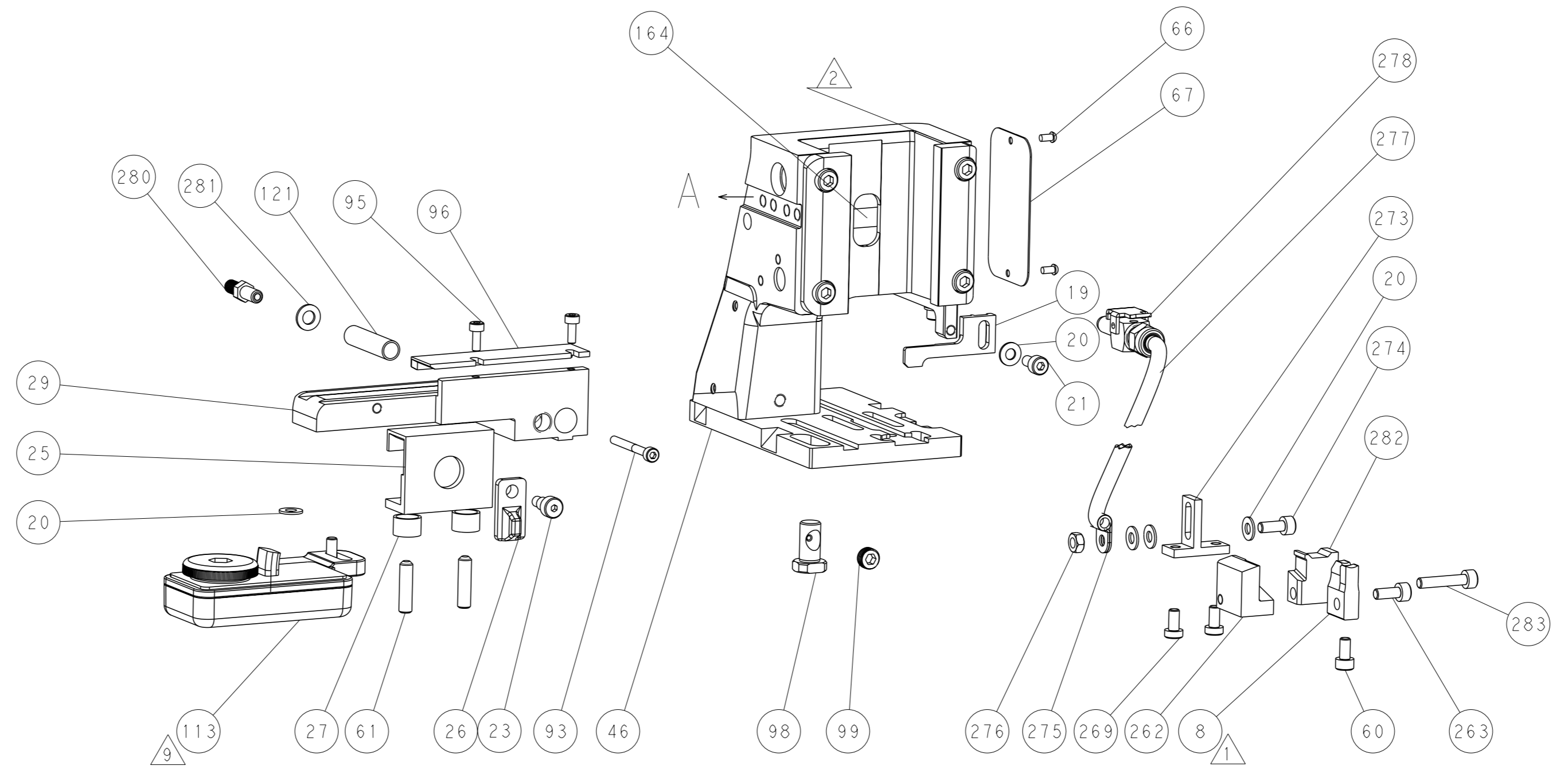
CAM POSITION



AIR FEED



RAM SET-UP



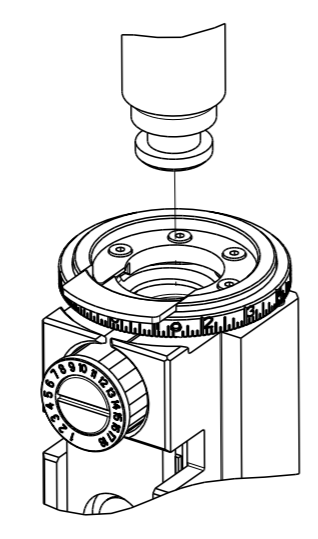
FEED TRACK POSITION
GUIDE BY WIRE BARREL

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 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: R. KNEPPER CHK: G. BAILEY APVD: J. ELBIN PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	DATE: 21-Oct-15 DATE: 21-Oct-15 DATE: 21-Oct-15 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151316 SHEET: 2 of 4 REV: D	TE Connectivity Harrisburg, PA 17105-3608
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151316-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151316-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.59 mm [.220]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POWER RING			
WIRE STRIP LENGTH 5.95-6.75 mm [.234-.266 IN]		INSULATION DIAMETER RANGE Ø2.79-4.06 mm [.110-.160 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2087			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63166-1	63166-2	63166-4	63166-5
521843-1	521844-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 14 AWG	3.07+/-0.05 [.121+/-0.002]	3.7
12 AWG	2.90+/-0.05 [.114+/-0.002]	5.1
14 AWG	2.64+/-0.05 [.104+/-0.002]	8.0
16 AWG	2.46+/-0.05 [.097+/-0.002]	10.4



- 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. WIRE STRIP LENGTHS LISTED ARE FOR AWG WIRE. WIRE STRIP LENGTHS FOR HOUSEHOLD WIRE IS: 18.65-19.45 mm [.734-.766 IN].
- 7. CUT TO LENGTH AT ASSEMBLY.
- 8. REMOVE ITEMS 51 & 52 WHEN RUNNING TERMINALS 521843-1 & 521844-1.
- 9. TERMINAL LUBRICANT IS RECOMMENDED.
- 10. 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
-	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		283
-	1	1803315-1	LOWER SHEAR, RIGHT		282
-	1	1-18028-3	WASHER, FLAT, REG M5		281
-	1	1803196-1	STUD, ADJUSTMENT SCREW		280
-	1	23238-1	INSERT, COUPLING		278
-	1	2030758-3	TUBING, POLYURETHANE		277
-	1	5018030-2	NUT, HEX, REG, RoHS, M4		276
-	1	986220-2	CLAMP, CABLE, BLACK		275
-	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		274
-	1	1803319-1	SUPPORT, AIR BLAST		273
-	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8		269
-	1	3-18031-6	SCR, SET, CUP POINT M2.5 X 3.0		266
-	2	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0		265
-	1	1803313-1	SLUG BLADE		264
-	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		263
-	1	1803312-1	LOWER SHEAR, LEFT		262
-	1	9-240641-0	SPACER		261
-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
3	-	2119083-1	RETAINER, INSULATION DIAL		242
-	1	2844940-1	AIR FEED MODULE		238
-	1	1-18028-0	WASHER, FLAT, REG M8		192
-	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
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC		140
-	1	1-22281-6	SPRING, COMPRESSION		121
9	-	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	2844908-1	SCREW, LOCKING		99
-	1	2844907-1	POST, LOCKING		98
-	1	1803310-1	STRIP GUIDE, FRONT		96
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
-	1	2168083-7	SCR, SKT HD CAP, RoHS, M3 X 30		93
-	1	1-455888-0	SPACER, CRIMPER		82
-	1	1803607-3	DOCUMENTATION PACKAGE		71
-	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0		61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	1	1338683-9	FEED PAWL		56
7	-	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		53
8	-	5018030-1	NUT, HEX, REG, RoHS, M3		52
8	-	811242-6	BUMPER, HOLD DOWN		51
-	1	1803311-1	HOLDER, SLUG BLADE		50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	1	1803309-2	PLATE, STRIP GUIDE		29
-	2	22283-1	SPRING, COMPRESSION		27
-	1	356835-1	LEVER, DRAG RELEASE		26
-	1	3-690754-8	DRAG, SPECIAL		25
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	5	1-18028-2	WASHER, FLAT, REG M4		20
-	1	2119533-1	STRIPPER, SIDE FEED		19
-	-	-	-		10
-	-	-	-		9
1	1	1803316-1	ANVIL, COMBINATION		8
-	-	-	-		7
-	-	-	-		6
-	-	-	-		5
-	1	238011-1	BLOCK, CRIMPER SPACER		4
1	1	1-1633966-1	CRIMPER, INSULATION O		3
-	1	1-455888-3	SPACER, CRIMPER		2
1	1	3-456411-0	CRIMPER, WIRE PREMIUM		1
-77	-22	PART NO	DESCRIPTION		ITEM NO

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

STE TE Connectivity
Harrisburg, PA 17105-3608

Ocean Side Feed Applicator

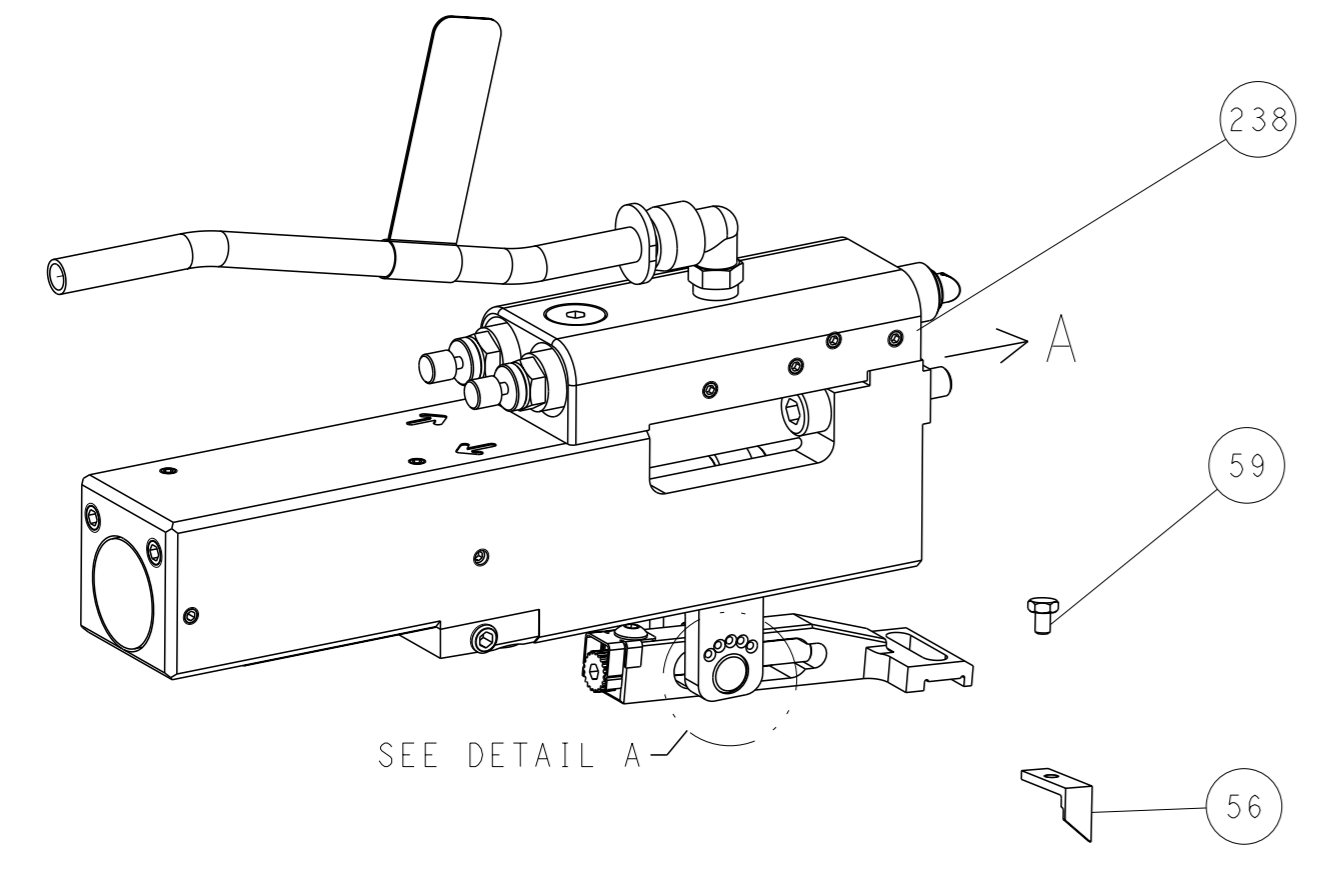
SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151316

Customer Accessible Production Drawing SCALE: 1:2 SHEET 3 OF 4 REV D

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

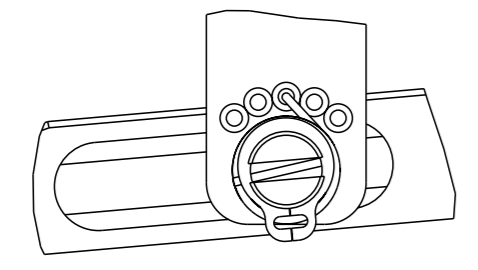
FEED TYPE

PNEUMATIC



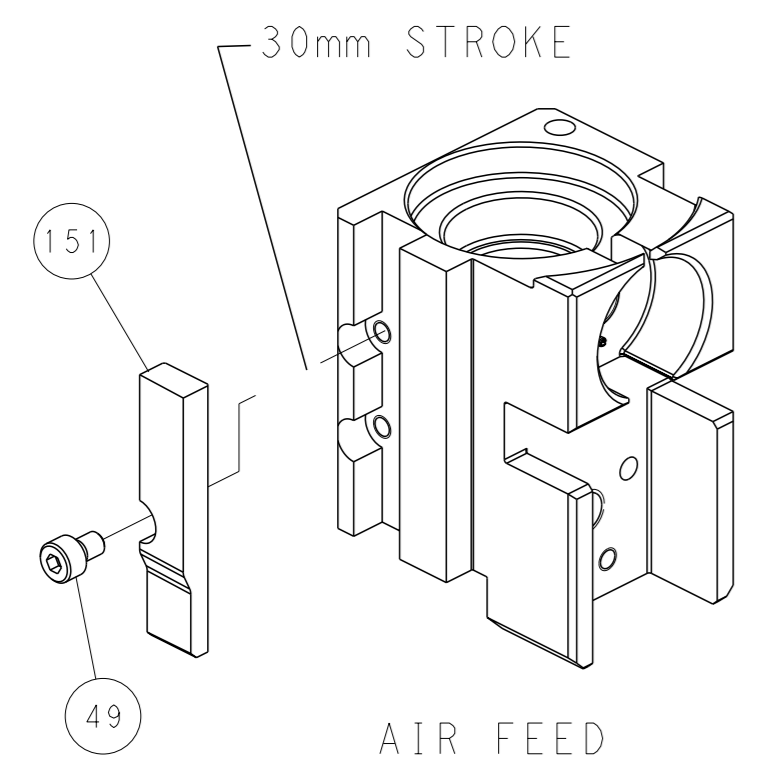
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

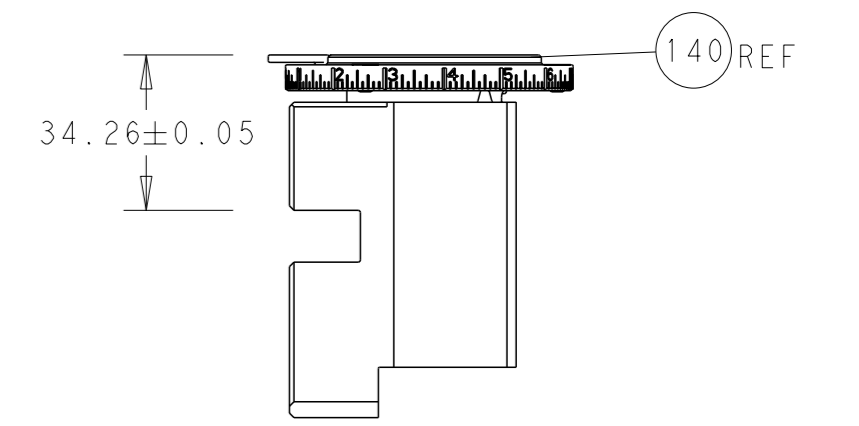
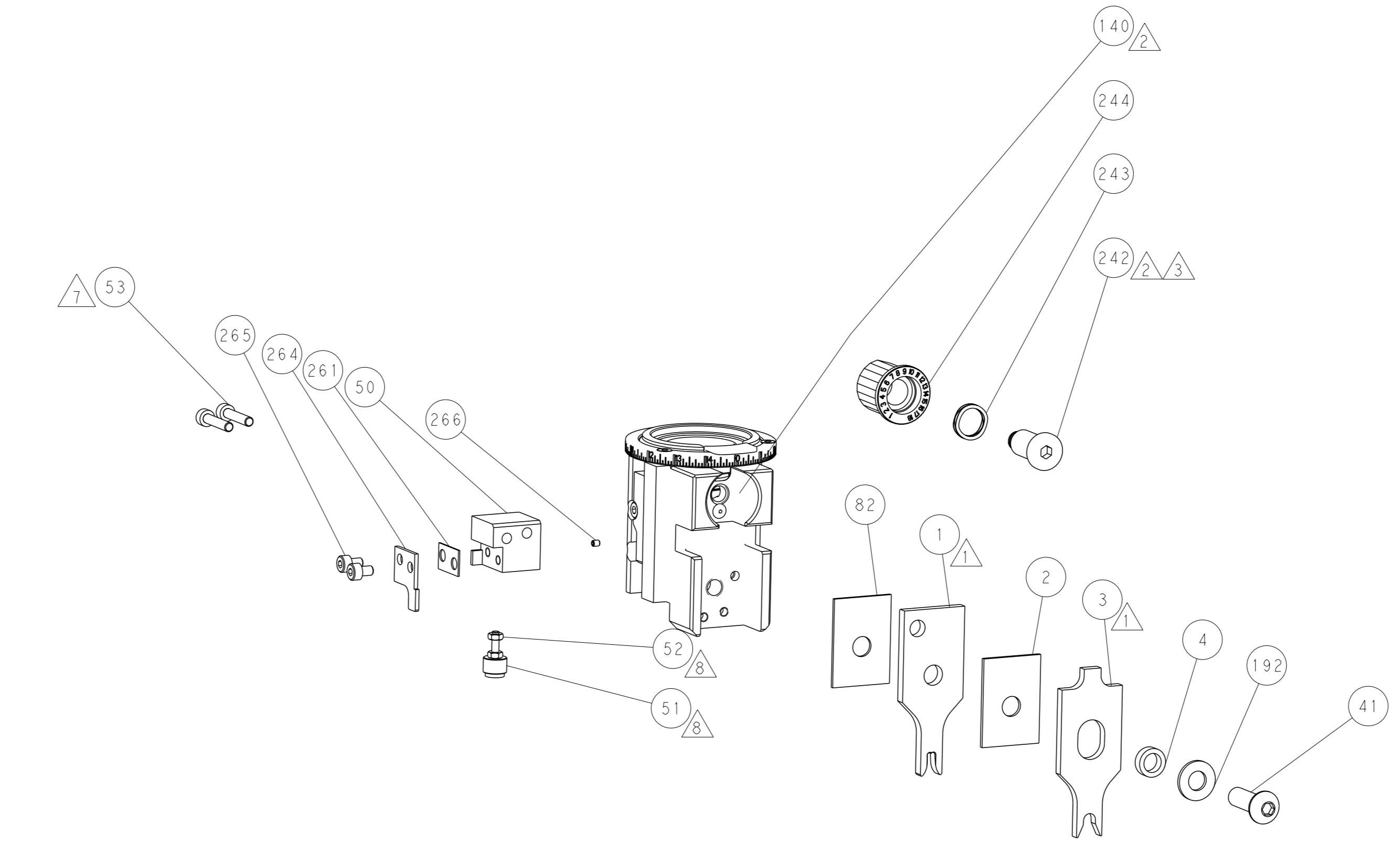


DETAIL A

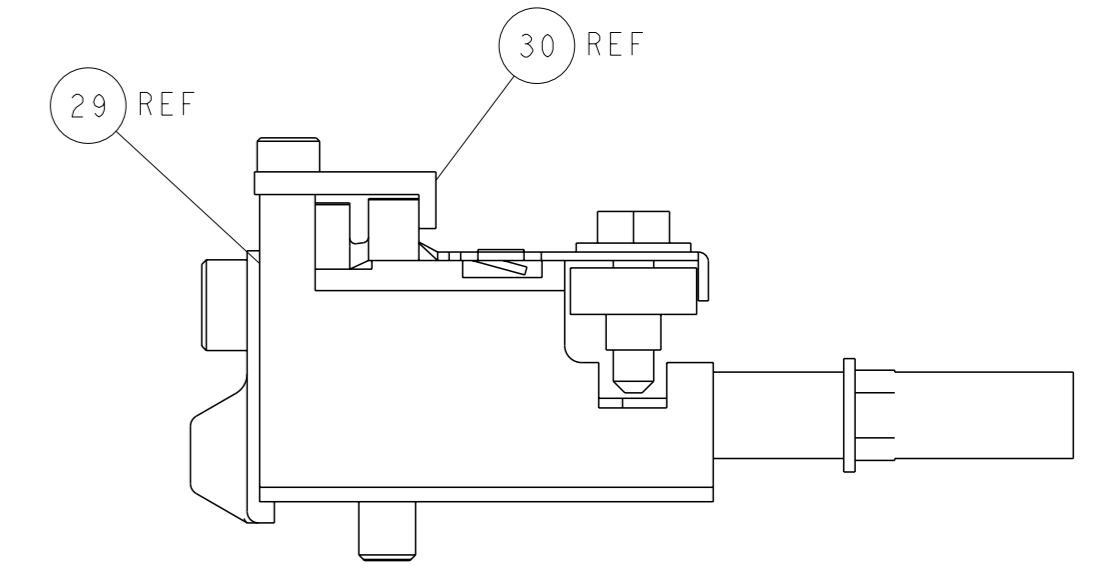
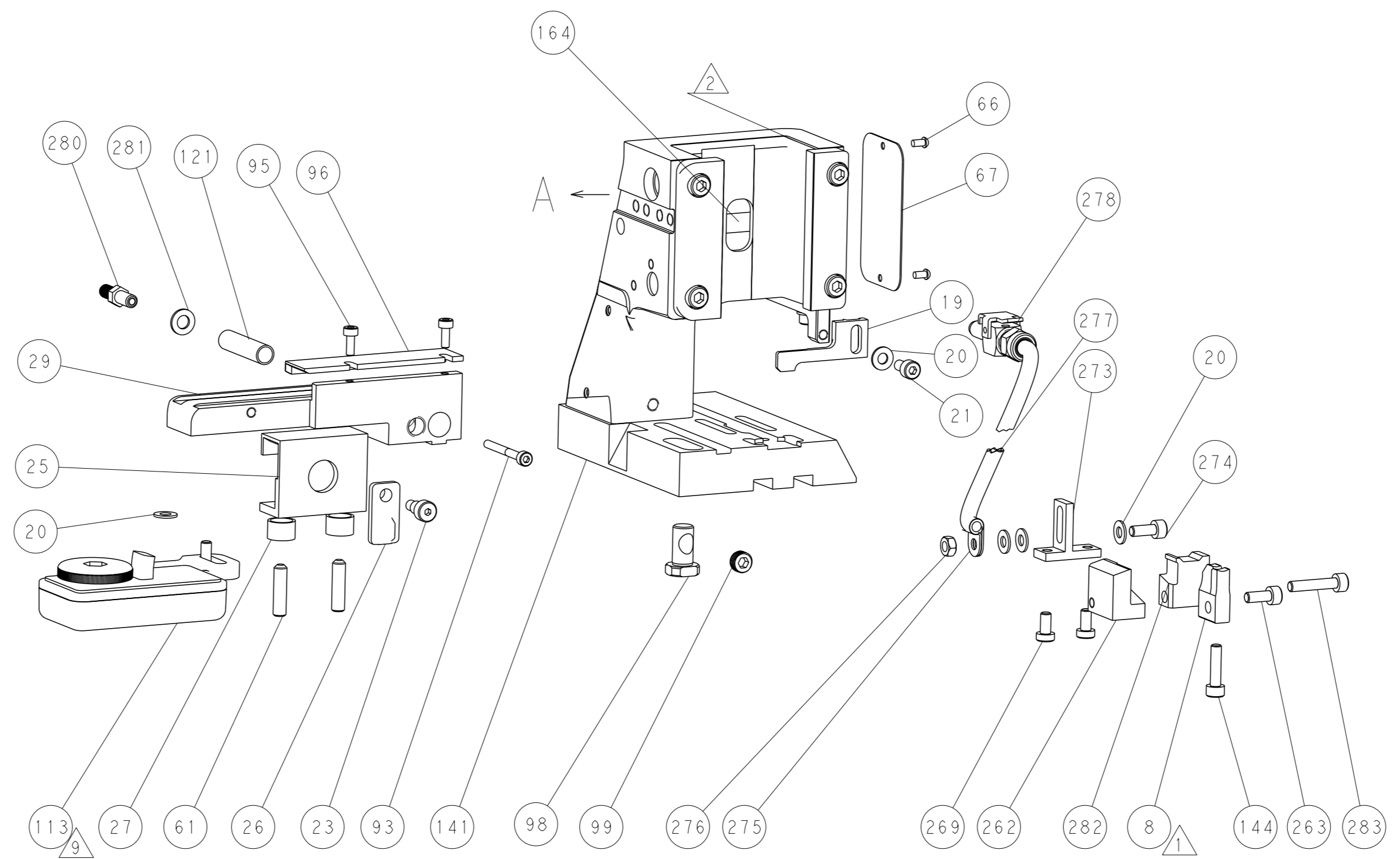
CAM POSITION



AIR FEED



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. KNEPPER CHK: G. BAILEY APVD: J. ELBIN	DATE: 21-Oct-15 DATE: 21-Oct-15 DATE: 21-Oct-15	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: 2151316 SCALE: 1:2	RESTRICTED TO: - SHEET: 4 of 4 REV: D	CUSTOMER ACCESSIBLE PRODUCTION DRAWING