

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151032-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151032-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151032-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.205 [5.21 mm]	0
INSUL	-	-

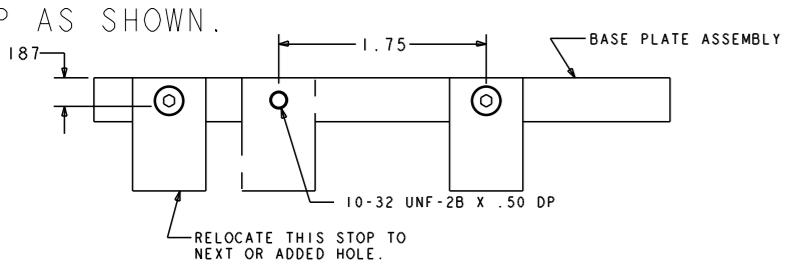
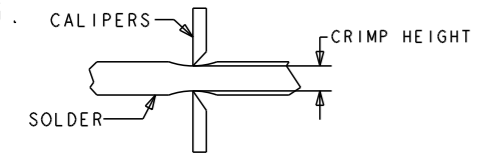
APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.265-.297 IN [6.73-7.54 mm]		∅ .160	.160-.160
TERMINAL APPLICATION SPECIFICATION	114-2123 Rev G		

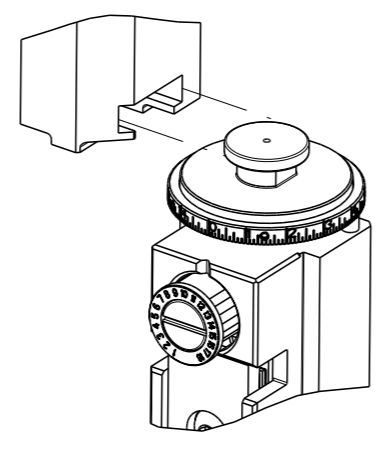
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-350815-2	3-520116-2	3-520140-2	5-520150-2
5-350815-2	3-520124-2	3-520140-4	6-520150-2
3-350819-2	9-520124-2	5-520140-2	3-520276-2
5-350819-2	9-520140-2	9-520140-2	9-520276-2
3-520106-2		3-520150-2	3-521142-2
		3-521150-2	3-1969626-1

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
14 AWG	0.075+/-0.002 [1.91+/-0.05]	6.4	.187 IN [4.750mm]
16, (2)18, OR (3)20	0.070+/-0.002 [1.78+/-0.05]	7.7	.187 IN [4.750mm]

- 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. TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 5. ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- 6. ITEMS 5 AND 9 OR ITEMS 10 AND 22 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 OR ITEM 43 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- 7. FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- 8. GROUP 1 TERMINALS: ∅.160 IN [4.06mm] MAX INSULATION  
GROUP 2 TERMINALS: ∅.260 IN [6.60mm] MAX INSULATION
- 9. USE ITEMS 5, 9, OR 42 WITH GROUP 1 TERMINALS  
USE ITEMS 10, 22, OR 43 WITH GROUP 2 TERMINALS
- 10. TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
- 11. IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
- 12. ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- 13. ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- 14. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 15. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.



ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



**\*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			
A	66	REV	DATE	BY	CHKD
		C2	15-NOV-2015	JH	JDG
		D	16-NOV-2016	TB	CT
		E	13-NOV-2018	JAH	CT
		F	29-MAR-2019	LG	TE

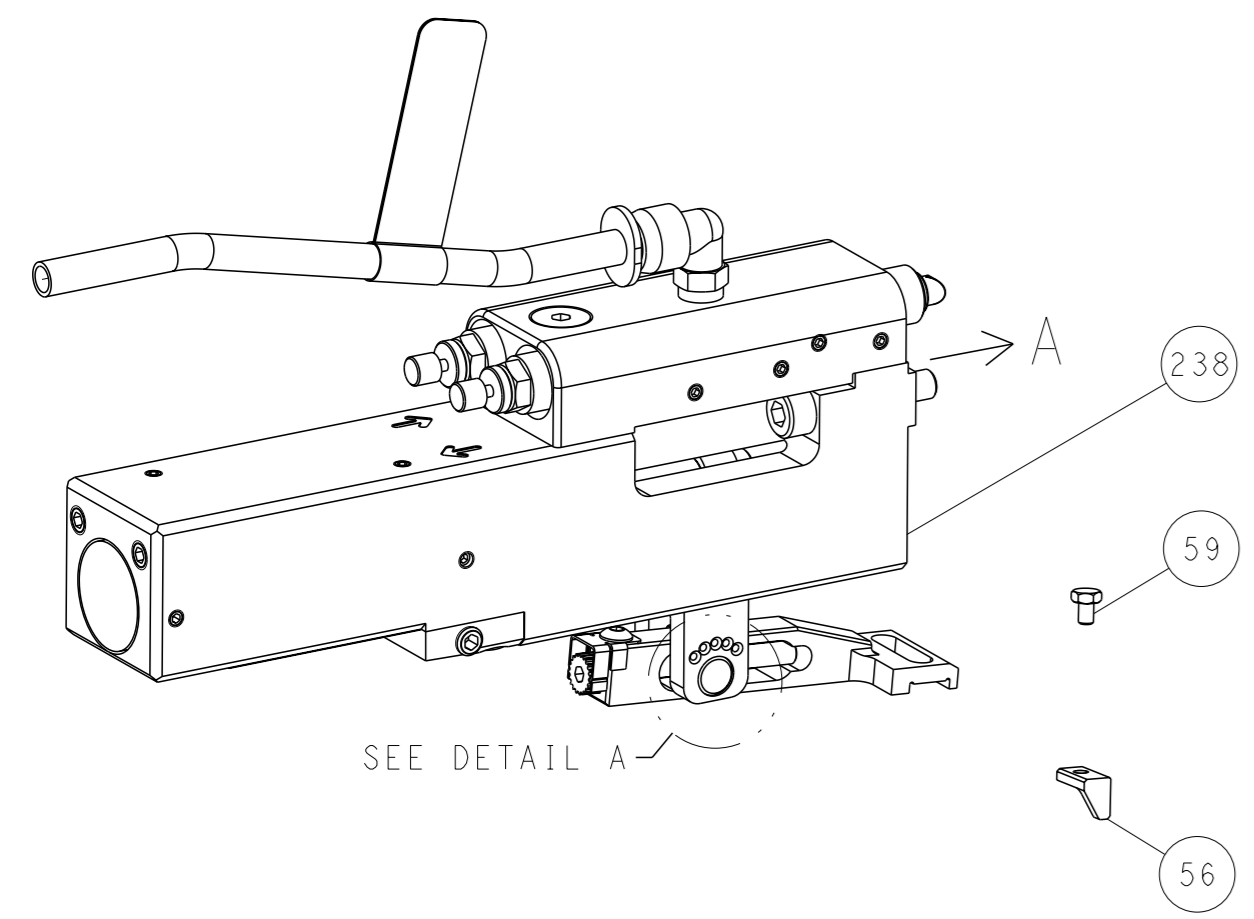
REF	REF	DESCRIPTION	DATE	OWN	APVD
3	-	462992-5	GUARD ASSY		257
3	-	679532-1	INSERT, GUARD		256
2	-	189728-1	BRACKET, SPACER		255
2	-	568681-1	SPACER, BASE PLATE		253
-	1	2119641-1	FEED CAM, AIR FEED		248
-	1	18023-1	SCR, SKT HD CAP M3 X 5.0		241
-	1	2844940-2	AIR FEED MODULE		238
-	1	1-18028-0	WASHER, FLAT, REG M8		192
-	REF	994970-2	COUNTER, MAGNETIC		164
-	1	1-22281-8	SPRING, COMPRESSION		121
-	1	2844908-1	SCREW, LOCKING		99
-	1	2844907-1	POST, LOCKING		98
-	1	1-690438-0	FRONT STRIP GUIDE		96
-	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65		93
-	1	455888-4	SPACER, CRIMPER		82
-	1	240641-6	SPACER		81
-	1	1803607-3	DOCUMENTATION PACKAGE		71
-	1	2161332-1	DEPRESSOR, WIRE FUNNEL		70
-	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR		69
-	2	1-18028-4	WASHER, FLAT, REG M3		68
-	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	2079383-4	SCR, BHSC, RoHS (M4 X 8)		60
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	1	462427-2	FINGER, FEED		56
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12		54
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		53
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	1-1803583-9	APPLICATOR BASIC ASSEMBLY, SF		46
-	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC		44
9	-	462433-7	SUPPORT, INSULATION		43
9	-	462433-6	SUPPORT, INSULATION		42
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	2	5-22278-1	SPRING, COMPRESSION		33
-	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5		30
-	1	2161336-2	PLATE, REAR STRIP GUIDE		29
-	2	22281-9	SPRING, COMPRESSION		27
-	1	356835-1	LEVER, DRAG RELEASE		26
-	1	240792-1	DRAG, TERMINAL		25
-	1	684042-4	GUIDE, STRIP, FRONT		24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
9	6	462431-5	WIRE FUNNEL		22
-	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	463460-3	HOLD DOWN, TERMINAL		18
1	-	469542-3	REAR FLOATING SHEAR		17
-	4	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6		16
1	-	2161335-2	SHEAR PLATE, REAR		15
-	1	2119862-2	SHEAR HOLDER, REAR		14
1	-	2280441-1	INSERT, SHEAR		13
-	1	3-22280-3	SPRING, COMPRESSION		12
-	1	356885-4	STOP, SHEAR		11
9	-	462843-6	TERMINAL SUPPORT		10
9	-	462843-5	TERMINAL SUPPORT		9
1	2	464282-2	ANVIL, SAND-BLASTED 16-14		8
5	-	803925-2	GUIDE, CARRIER SCRAP		7
-	1	2-690468-5	DEPRESSOR SHEAR, REAR		6
9	6	462431-4	WIRE FUNNEL		5
-	1	238011-1	BLOCK, CRIMPER SPACER		4
1	2	464281-1	CRIMPER, SEMI FLAT 16-14		1

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

OWN	B. WEAVER	17OCT2011
CHK	G. HOFNER	17OCT2011
APVD	T. ELBIN	17OCT2011
NAME		
OCEAN SIDE FEED APPLICATOR		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151032
Customer Accessible Production Drawing		
SCALE	1:1	SHEET 1 OF 4
REV	F	

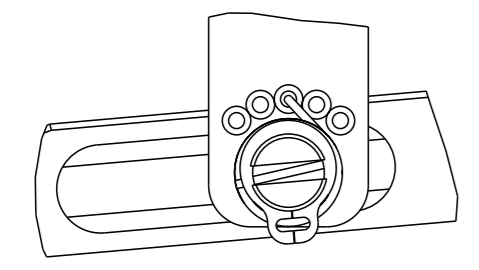
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

### FEED TYPE PNEUMATIC



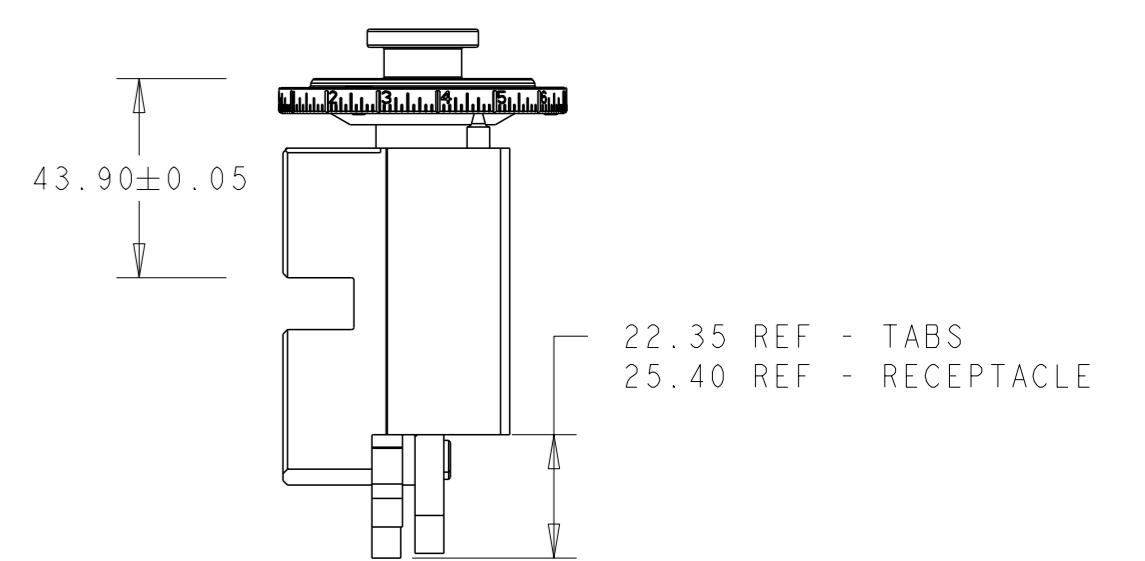
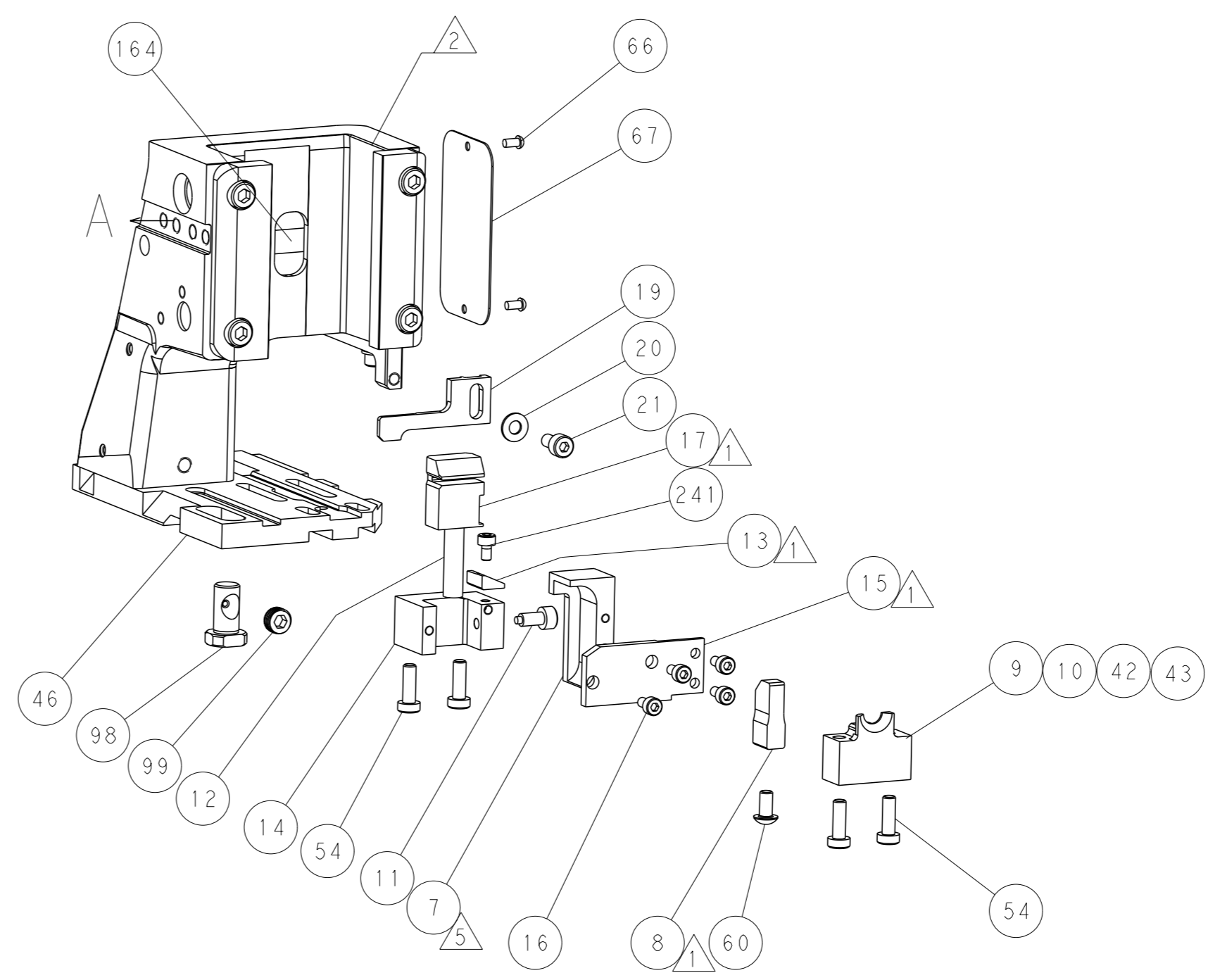
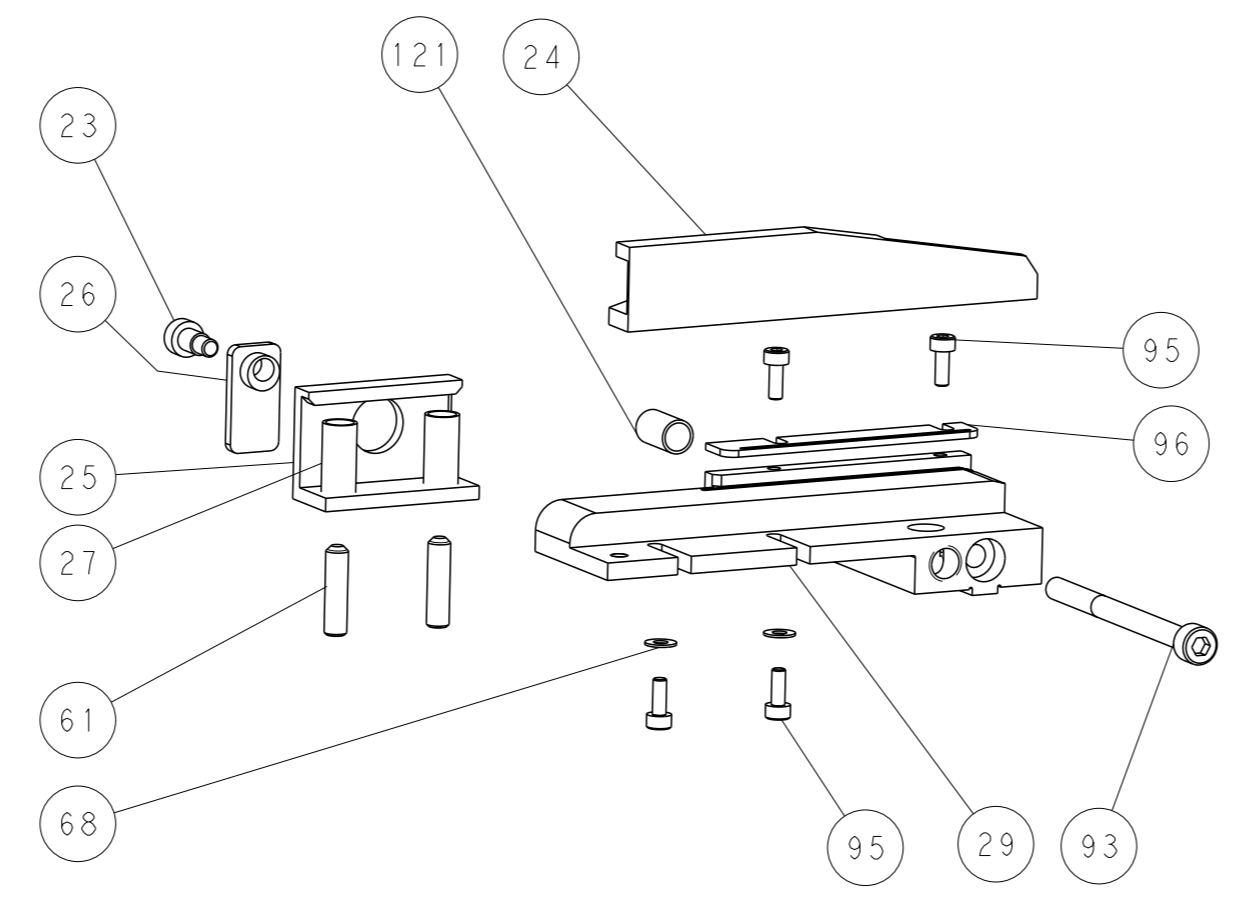
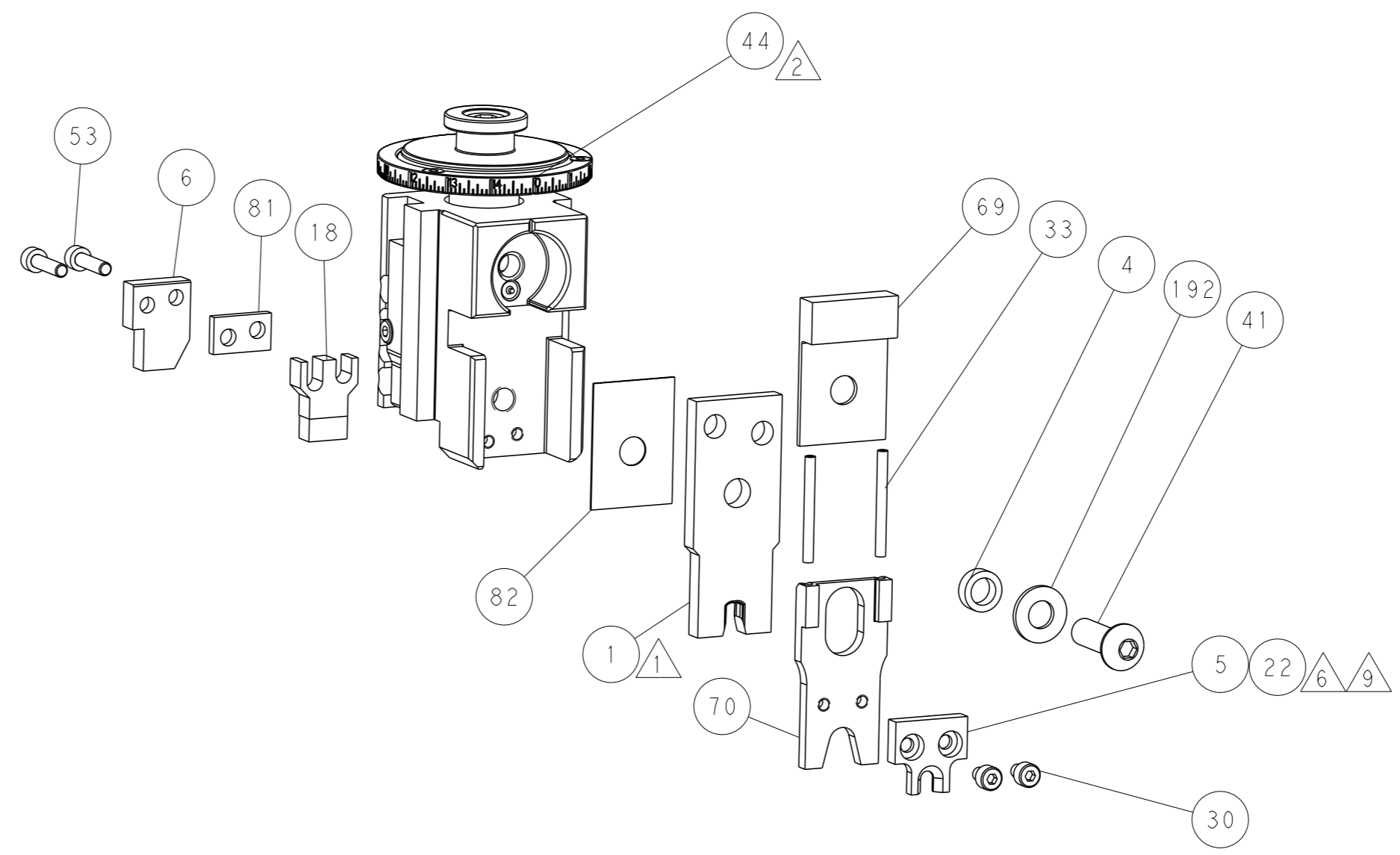
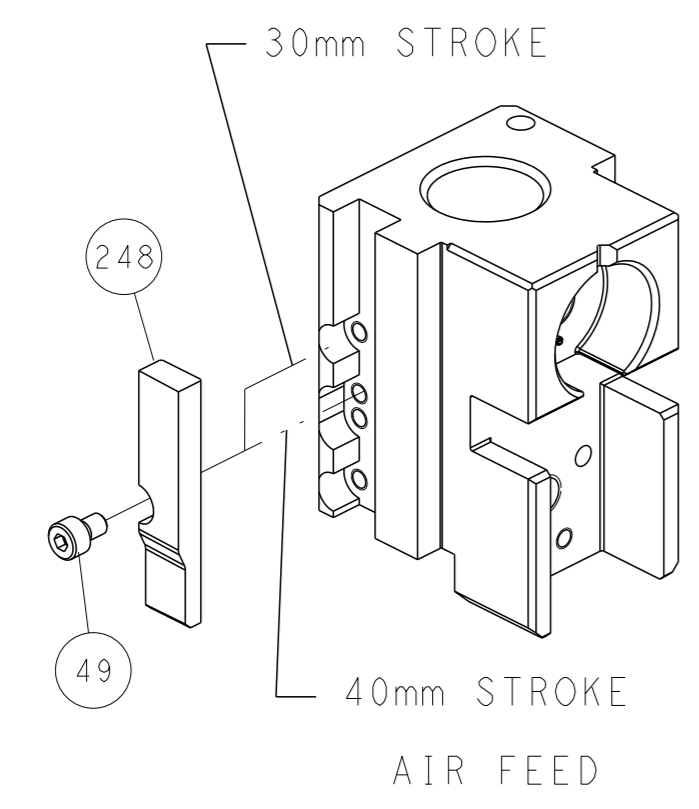
SEE DETAIL A

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

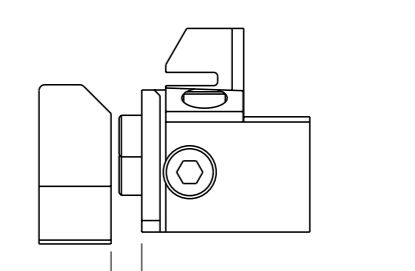


DETAIL A

### CAM POSITIONS



RAM & HOLD-DOWN SET-UP



LOWER TOOLING SET-UP

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

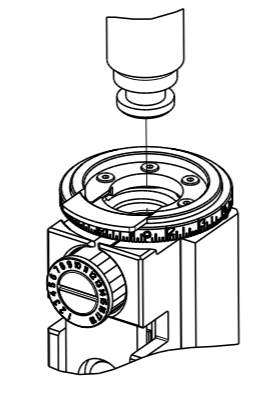
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2011. IT IS SUBJECT TO CHANGE AND THE USER SHOULD CONTACT THE DESIGNING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 17OCT2011 CHK: G. HOFNER 17OCT2011 APVD: T. ELBIN 17OCT2011	TE Connectivity Harrisburg, 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: ©=2151032	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: F
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER		REVISION	DESCRIPTION	FEED TYPE
2-2151032-2		F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151032-7		A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.205 [5.2] mm	Ø
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

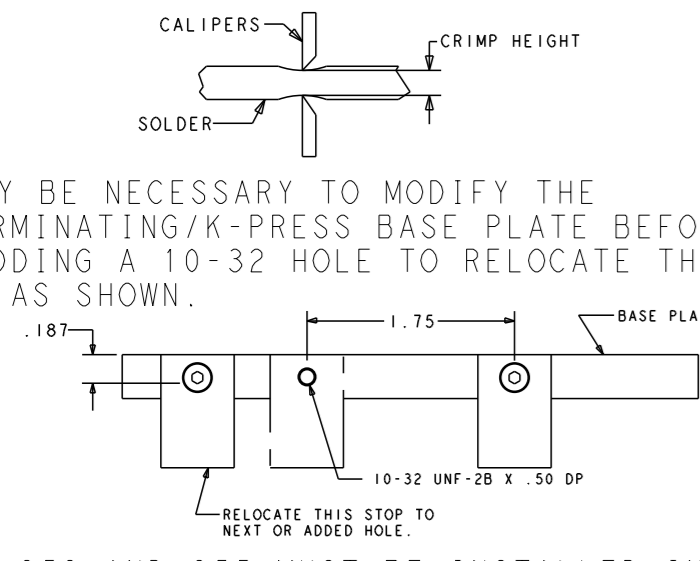
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH .265-.297 IN [6.73-7.54 mm]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION 114-2123 Rev G			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-350815-2	3-520116-2	3-520140-2	5-520150-2
5-350815-2	3-520124-2	3-520140-4	6-520150-2
3-350819-2	9-520124-2	5-520140-2	3-520276-2
5-350819-2		9-520140-2	9-520276-2
3-520106-2		3-520150-2	3-521142-2
		3-521150-2	3-1969626-1

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14 AWG	0.075+/-0.002 [1.91+/-0.05]	6.4	.187 IN [4.750mm]
16, (2)18, OR (3)20	0.070+/-0.002 [1.78+/-0.05]	7.7	.187 IN [4.750mm]

- 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 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 5 ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- 6 ITEMS 5 AND 9 OR ITEMS 10 AND 22 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 OR ITEM 43 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- 7 FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- 8 GROUP 1 TERMINALS: Ø.160 IN [4.06mm] MAX INSULATION  
GROUP 2 TERMINALS: Ø.260 IN [6.60mm] MAX INSULATION
- 9 USE ITEMS 5, 9, OR 42 WITH GROUP 1 TERMINALS  
USE ITEMS 10, 22, OR 43 WITH GROUP 2 TERMINALS
- 10 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



- 11 IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
- 12 ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- 13 ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- 14 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 15. 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)

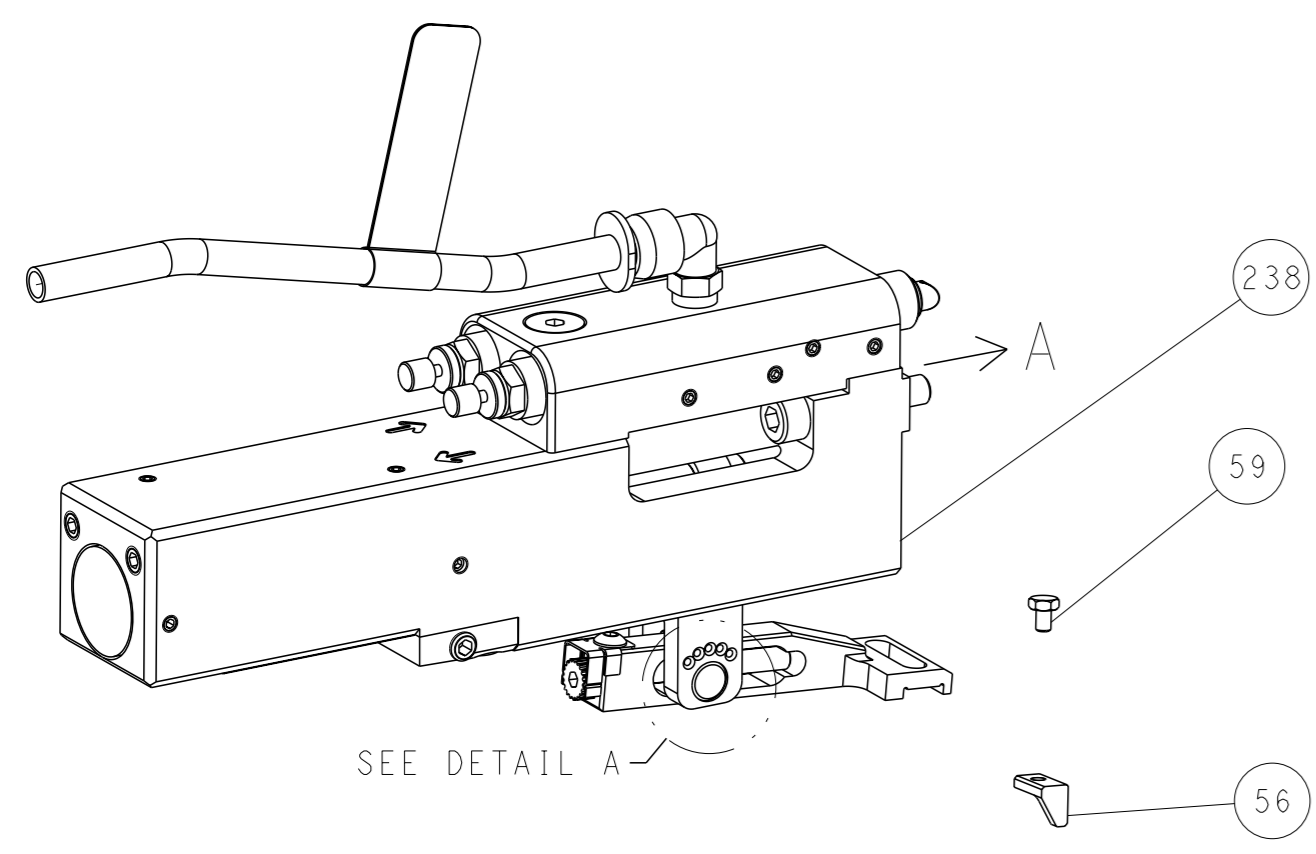
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

REF	QTY	PART NO	DESCRIPTION	ITEM NO
-	REF	462992-5	GUARD ASSY	257
-	REF	679532-1	INSERT, GUARD	256
-	1	189728-1	BRACKET, SPACER	255
-	1	568681-1	SPACER, BASE PLATE	253
-	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241
-	1	2844940-2	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	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	2-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1-22281-8	SPRING, COMPRESSION	121
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	455888-4	SPACER, CRIMPER	82
-	1	240641-6	SPACER	81
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2161332-1	DEPRESSOR, WIRE FUNNEL	70
-	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
-	2	1-18028-4	WASHER, FLAT, REG M3	68
-	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	462427-2	FINGER, FEED	56
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	462433-7	SUPPORT, INSULATION	43
-	1	462433-6	SUPPORT, INSULATION	42
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	5-22278-1	SPRING, COMPRESSION	33
-	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
-	1	2161336-2	PLATE, REAR STRIP GUIDE	29
-	2	22281-9	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	684042-4	GUIDE, STRIP, FRONT	24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	462431-5	WIRE FUNNEL	22
-	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	463460-3	HOLD DOWN, TERMINAL	18
-	1	469542-3	REAR FLOATING SHEAR	17
-	4	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	2161335-2	SHEAR PLATE, REAR	15
-	1	2119862-2	SHEAR HOLDER, REAR	14
-	1	2280441-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	356885-4	STOP, SHEAR	11
-	1	462843-6	TERMINAL SUPPORT	10
-	1	462843-5	TERMINAL SUPPORT	9
-	1	464282-2	ANVIL, SAND-BLASTED 16-14	8
-	1	803925-2	GUIDE, CARRIER SCRAP	7
-	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
-	1	462431-4	WIRE FUNNEL	5
-	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	464281-1	CRIMPER, SEMI FLAT 16-14	1
-77	-22	PART NO	DESCRIPTION	ITEM NO

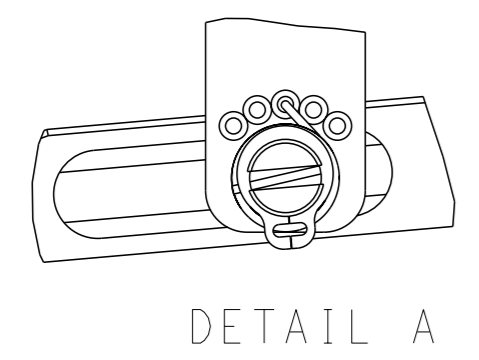
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: B. WEAVER 11OCT2011 CHK: G. HOFENER 11OCT2011 APVD: T. ELBIN 11OCT2011 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -		NAME: STE TE Connectivity Harrisburg, PA 17105-3608 SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151032 RESTRICTED TO: - Customer Accessible Production Drawing SCALE: 1:2 SHEET: 3 of 4 REV: F	
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LOC	DIST	REVISIONS			
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		-	SEE SHEET 1	-	-

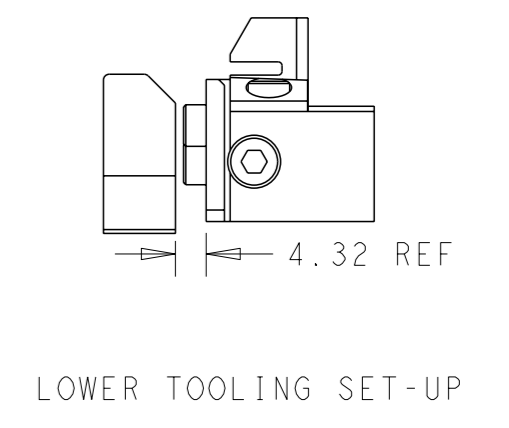
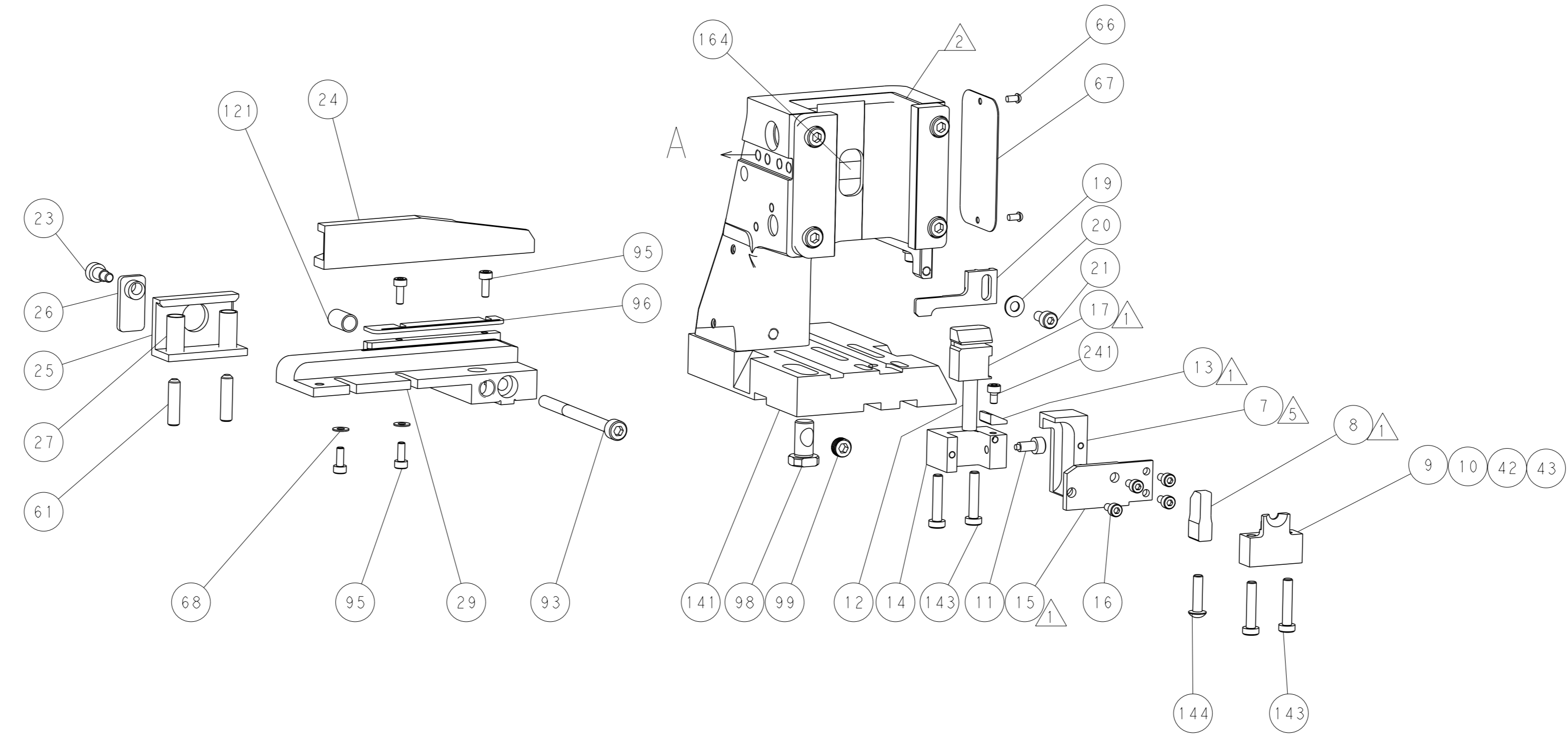
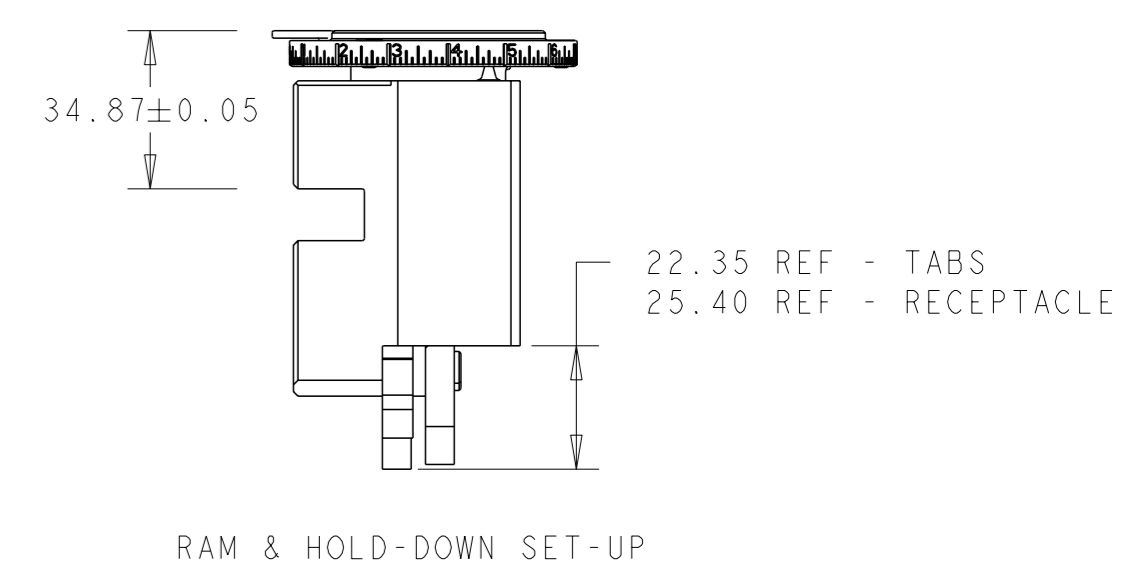
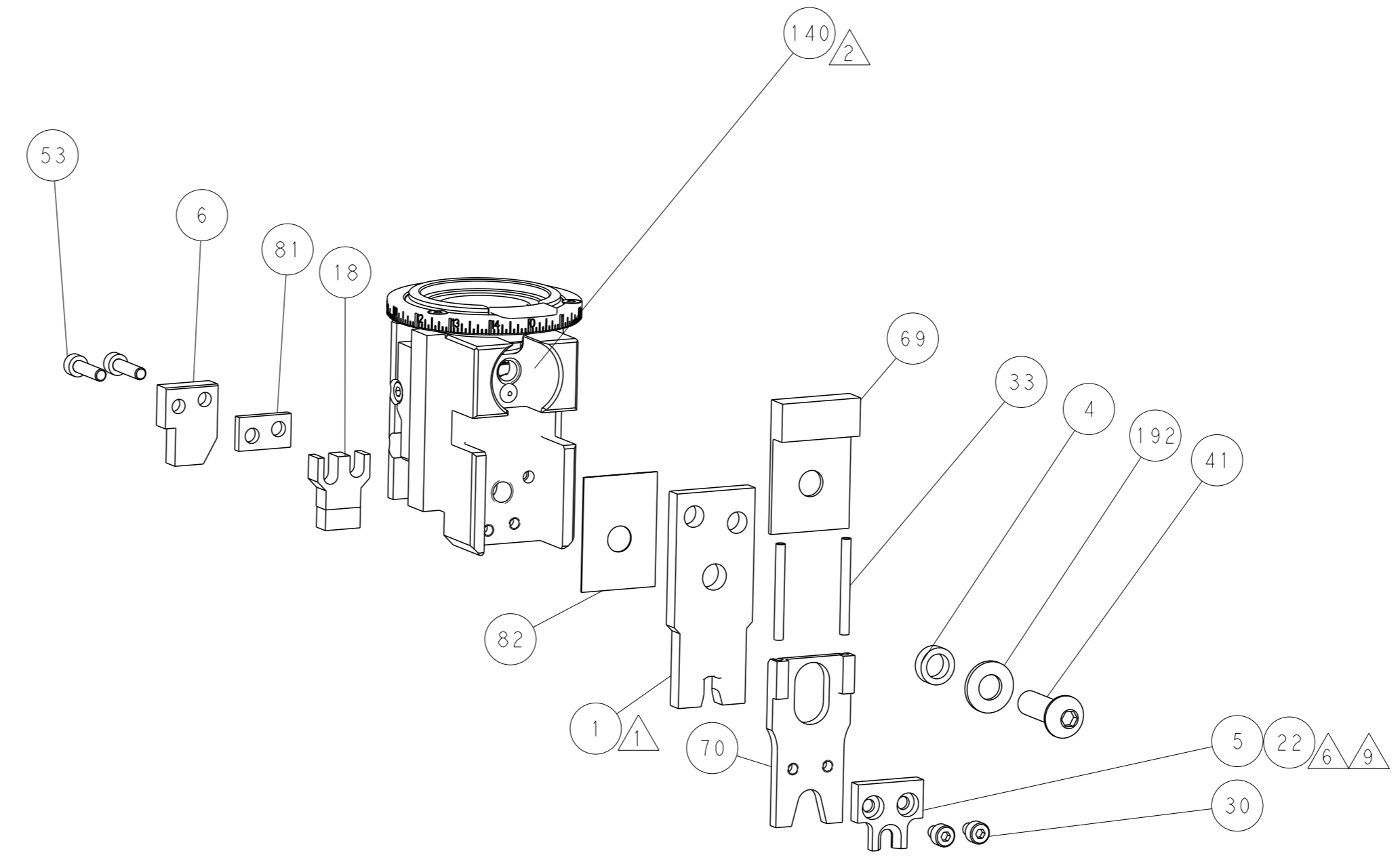
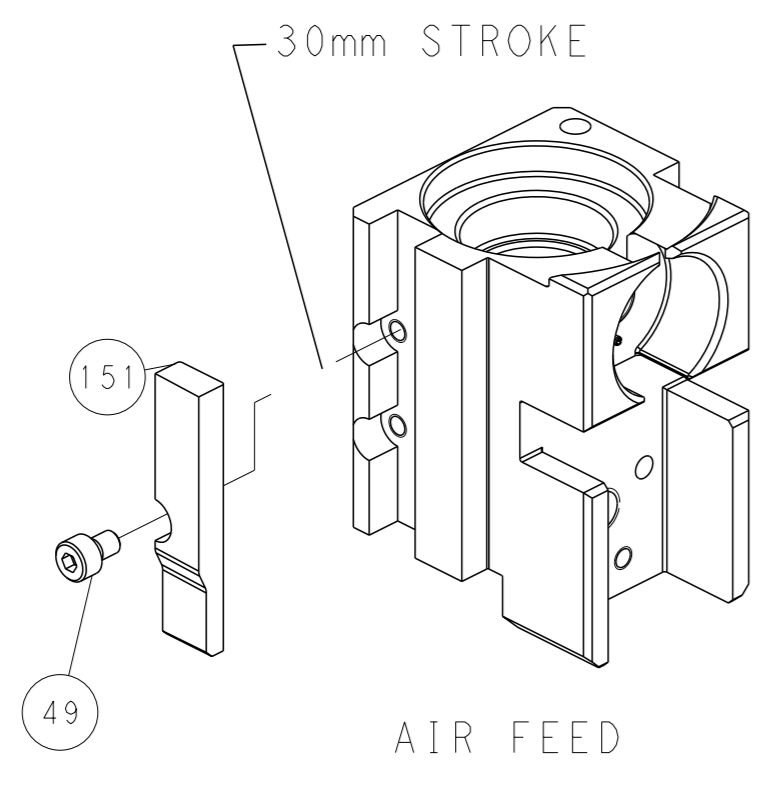
### FEED TYPE PNEUMATIC



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



### CAM POSITION



**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 FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 17OCT2011 CHK: G. HOFNER 17OCT2011 APVD: T. ELBIN 17OCT2011	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: 2151032 SCALE: 1:2 SHEET: 4 of 4 REV: F	RESTRICTED TO:
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing