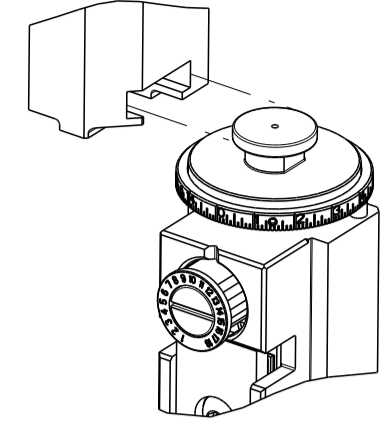


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151967-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151967-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151967-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151967-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151967-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.57 mm [.062]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, TWIN LEAF			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.125-.156 IN [3.18-3.96 mm]		Ø.035-.055 IN [0.89-1.40 mm]	
TERMINAL APPLICATION SPECIFICATION	114-9004		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
583616-1	583616-8	5-583616-3	531476-4
583616-2	1-583616-0	531476-1	5-531476-4
583616-3	5-583616-2	531476-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.92+/-0.05 [.036+/- .002]	8.8
26 AWG	0.86+/-0.05 [.034+/- .002]	9.4
28 AWG	0.81+/-0.05 [.032+/- .002]	9.8

- 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.
- 6. GRIND TO LENGTH AT ASSEMBLY.
- 7. 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)

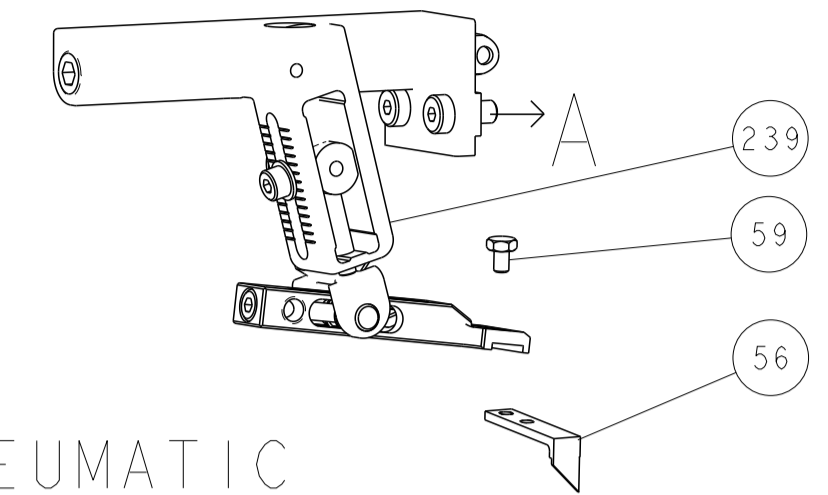
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A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-19-006381	19APR2019	FJ	TE
		C		ECR-19-007054	02MAY2019	TB	TE
		D		ECR-22-133757	24MAR2022	TB	RK
		E		ECR-22-137767	02MAY2022	JWC	TE

-	1	1	1	1	2280441-1	INSERT, SHEAR	283	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	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	
-	2	2	2	2	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	
-	1	1	1	1	356885-4	STOP, SHEAR	237	
-	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	3-240641-0	SPACER	81	
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	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	690463-1	FLOATING SHEAR, REAR	17	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1	1	1	690464-4	SHEAR PLATE, REAR	15	
-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14	
-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	2	2	2	2	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	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1-1803057-2	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	1	1	1	1	690468-2	DEPRESSOR SHEAR, REAR	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-2119784-3	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
-	1	2	2	1	456401-1	CRIMPER, WIRE .042 F PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

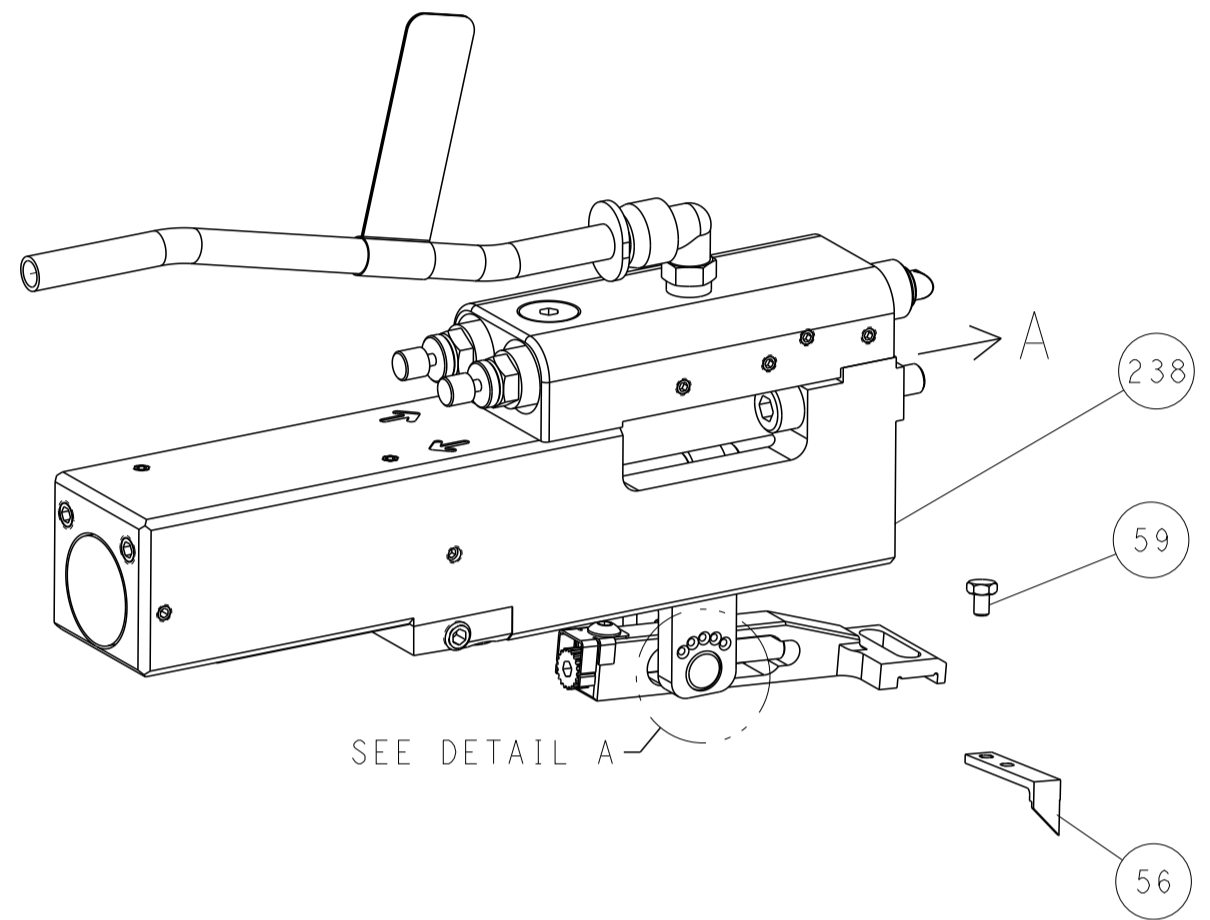
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2151967	1	4	E

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

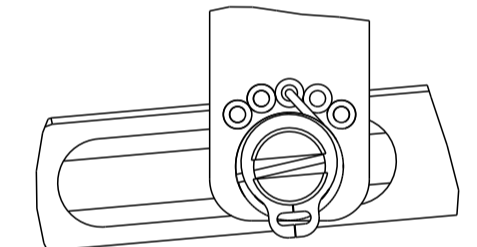
FEED TYPE MECHANICAL



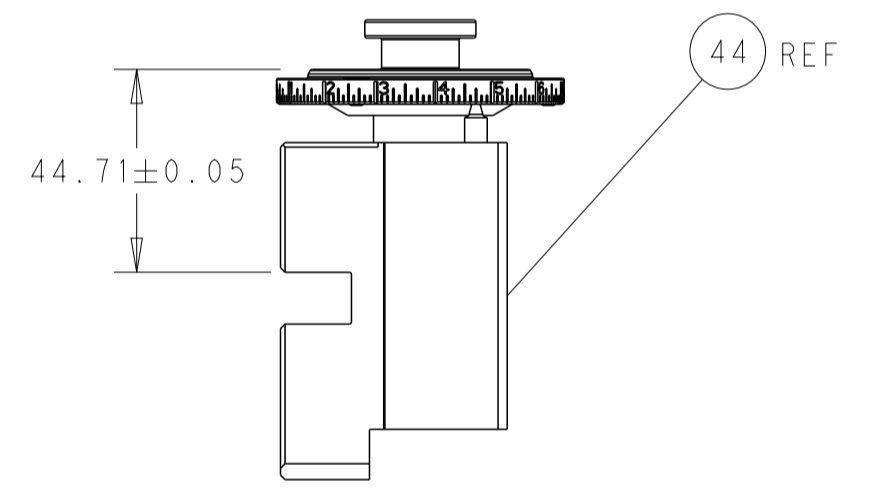
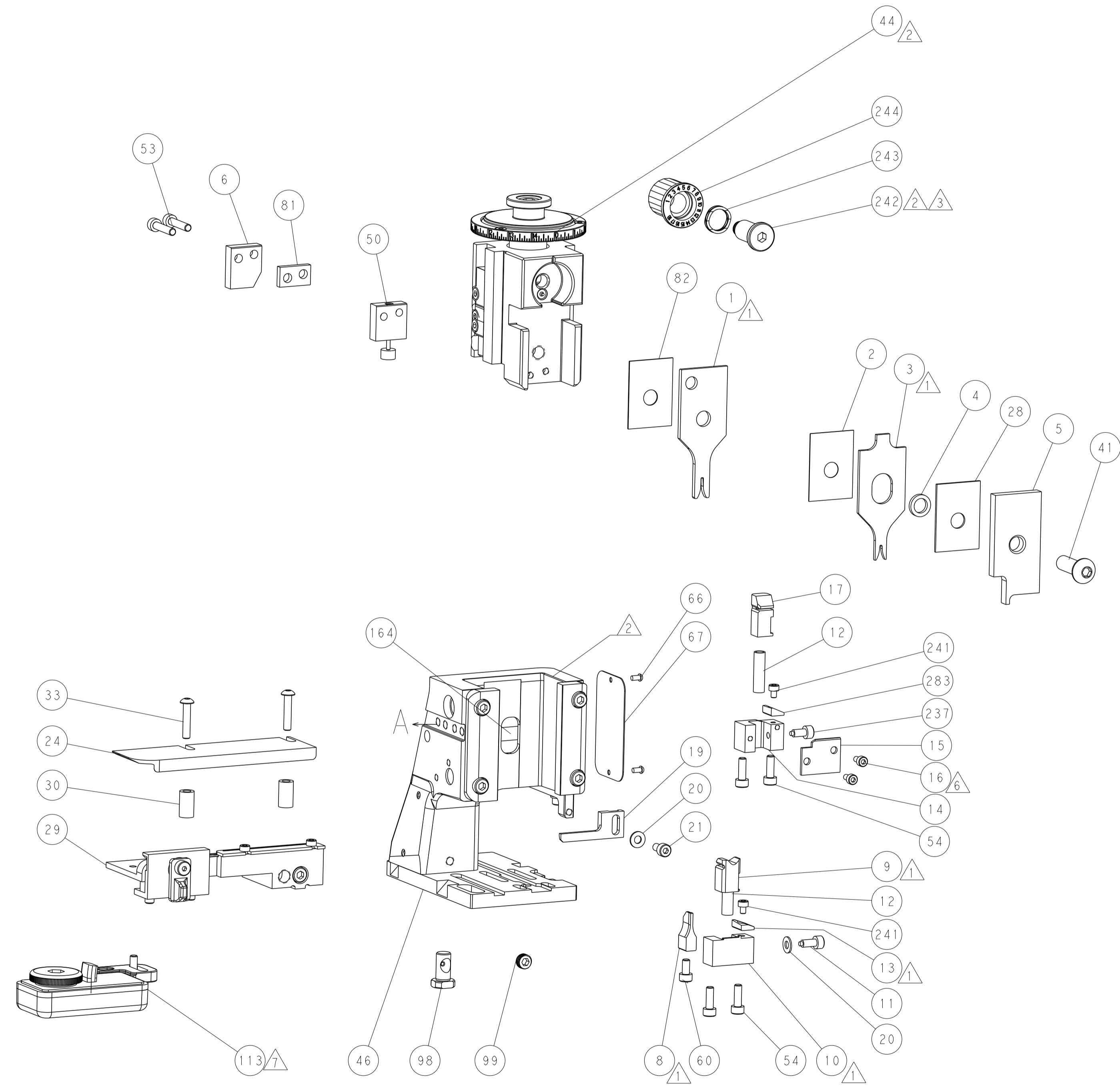
PNEUMATIC



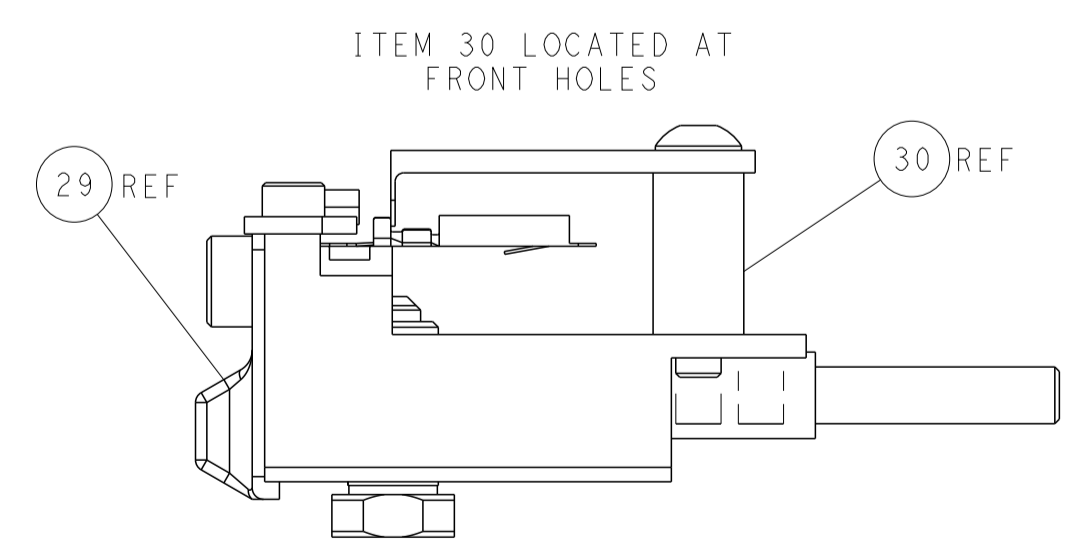
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

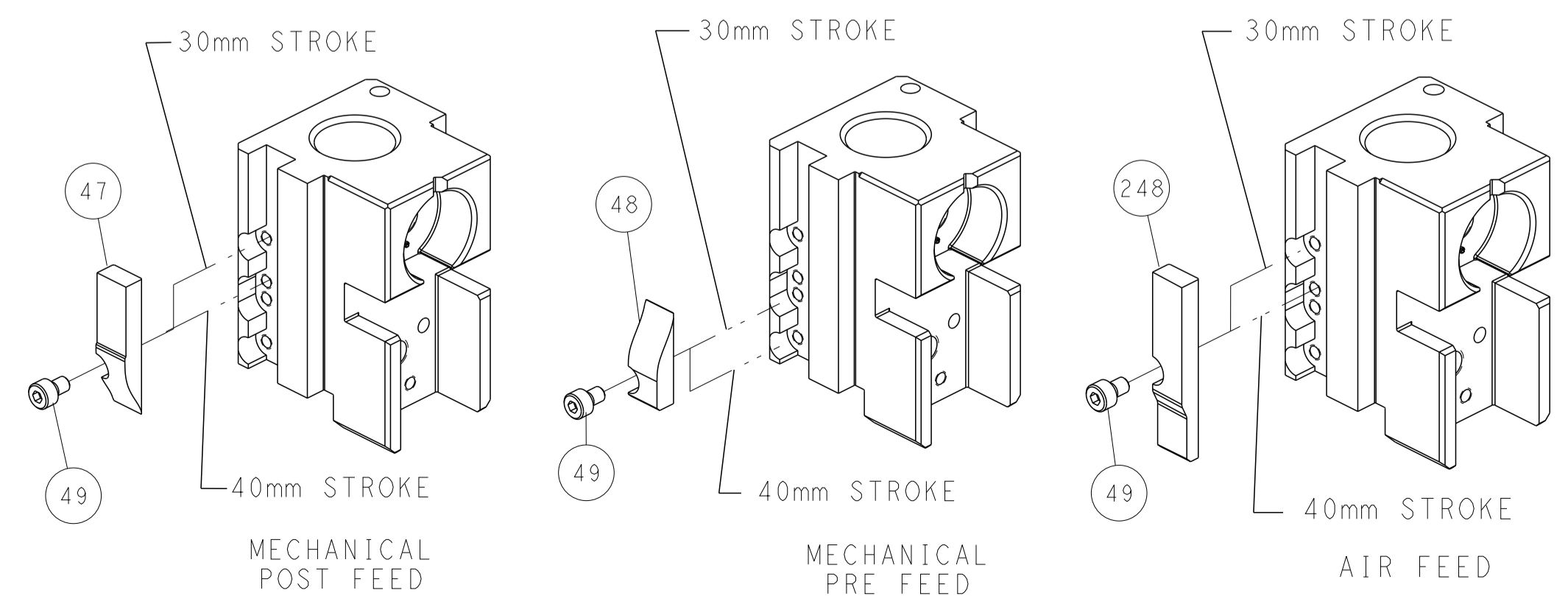


RAM SET-UP



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: STAKEM 29MAY2013		TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 29MAY2013		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD: T. ELBIN 29MAY2013		NAME: Ocean Side Feed Applicator	
		2 PLC ±		PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO:	
		3 PLC ±		APPLICATION SPEC:		A1 00779 ©=2151967	
		4 PLC ±		WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV E	
		ANGLES ±		MATERIAL:		Customer Accessible Production Drawing	
		FINISH:		Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151967-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151967-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151967-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.57 mm [.062]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, TWIN LEAF			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.125-.156 IN [3.18-3.96 mm]		∅.035-.055 IN [0.89-1.40 mm]	
TERMINAL APPLICATION SPECIFICATION	114-9004		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
583616-1	583616-8	5-583616-3	531476-4
583616-2	1-583616-0	531476-1	5-531476-4
583616-3	5-583616-2	531476-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.92 +/- 0.05 [.036 +/- .002]	8.8
26 AWG	0.86 +/- 0.05 [.034 +/- .002]	9.4
28 AWG	0.81 +/- 0.05 [.032 +/- .002]	9.8

- 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.
- 6 GRIND TO LENGTH AT ASSEMBLY.
- 7 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.

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

-	1	1	2280441-1	INSERT, SHEAR	283
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	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
-	1	1	356885-4	STOP, SHEAR	237
-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	3-240641-0	SPACER	81
-	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
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	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	690463-1	FLOATING SHEAR, REAR	17
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	690464-4	SHEAR PLATE, REAR	15
-	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1-1803057-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	1	1	690468-2	DEPRESSOR SHEAR, REAR	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1-2119784-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	456401-1	CRIMPER, WIRE .042 F PREMIUM	1

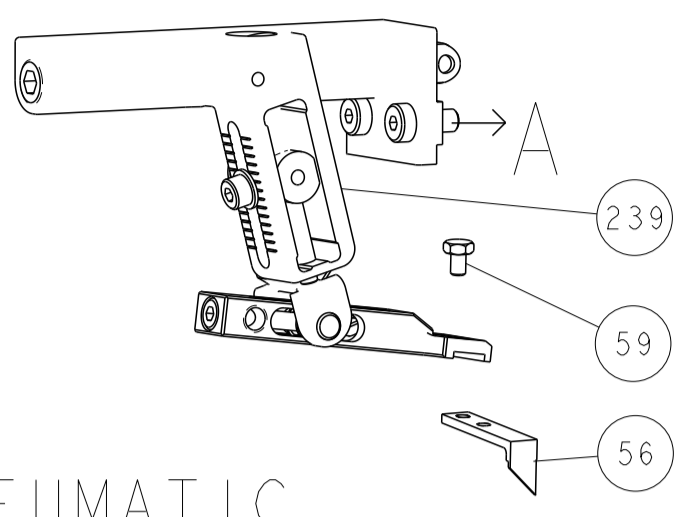
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO. 29MAY2013	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
ANGLES	FINISH	MATERIAL		WEIGHT	
APPLICATOR DATA		APPLICATOR INSTRUCTIONS		SCALE 1:2 SHEET 3 OF 4 REV E	

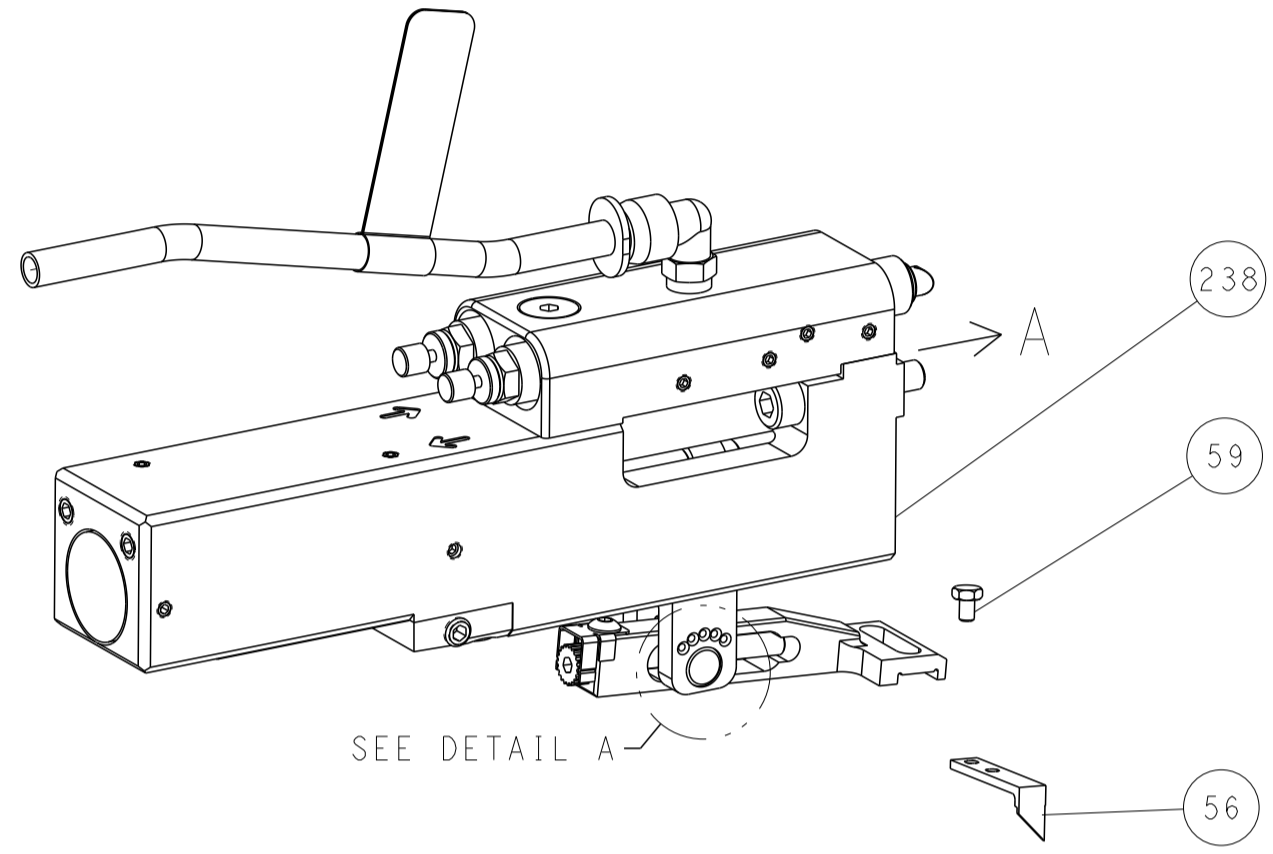
Customer Accessible Production Drawing

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

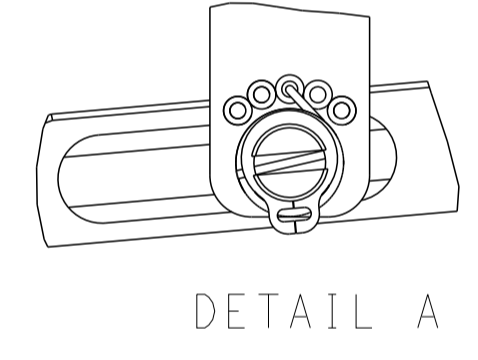
FEED TYPE MECHANICAL



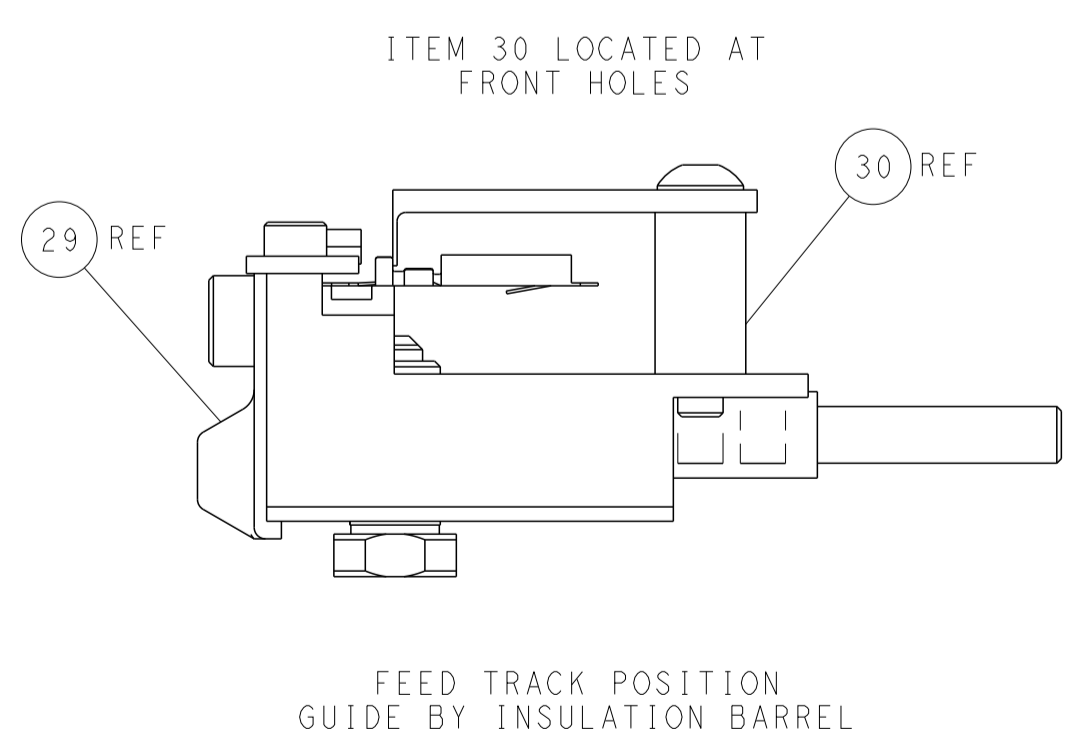
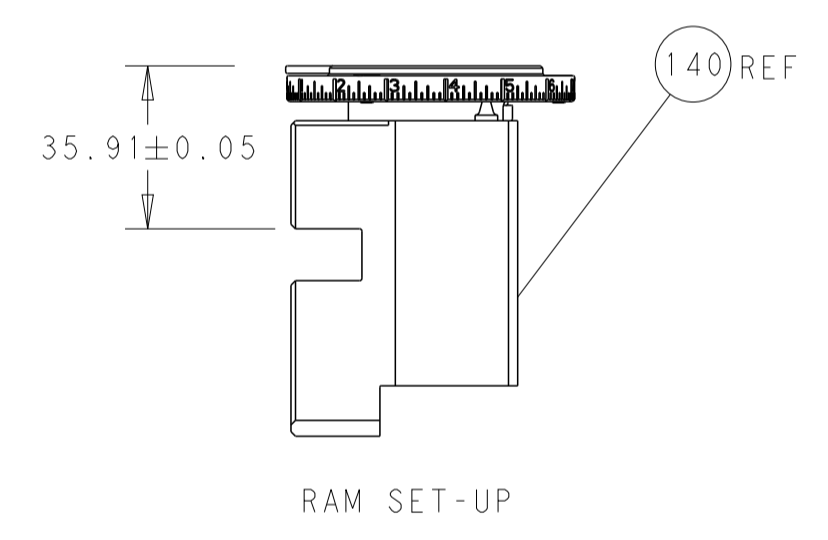
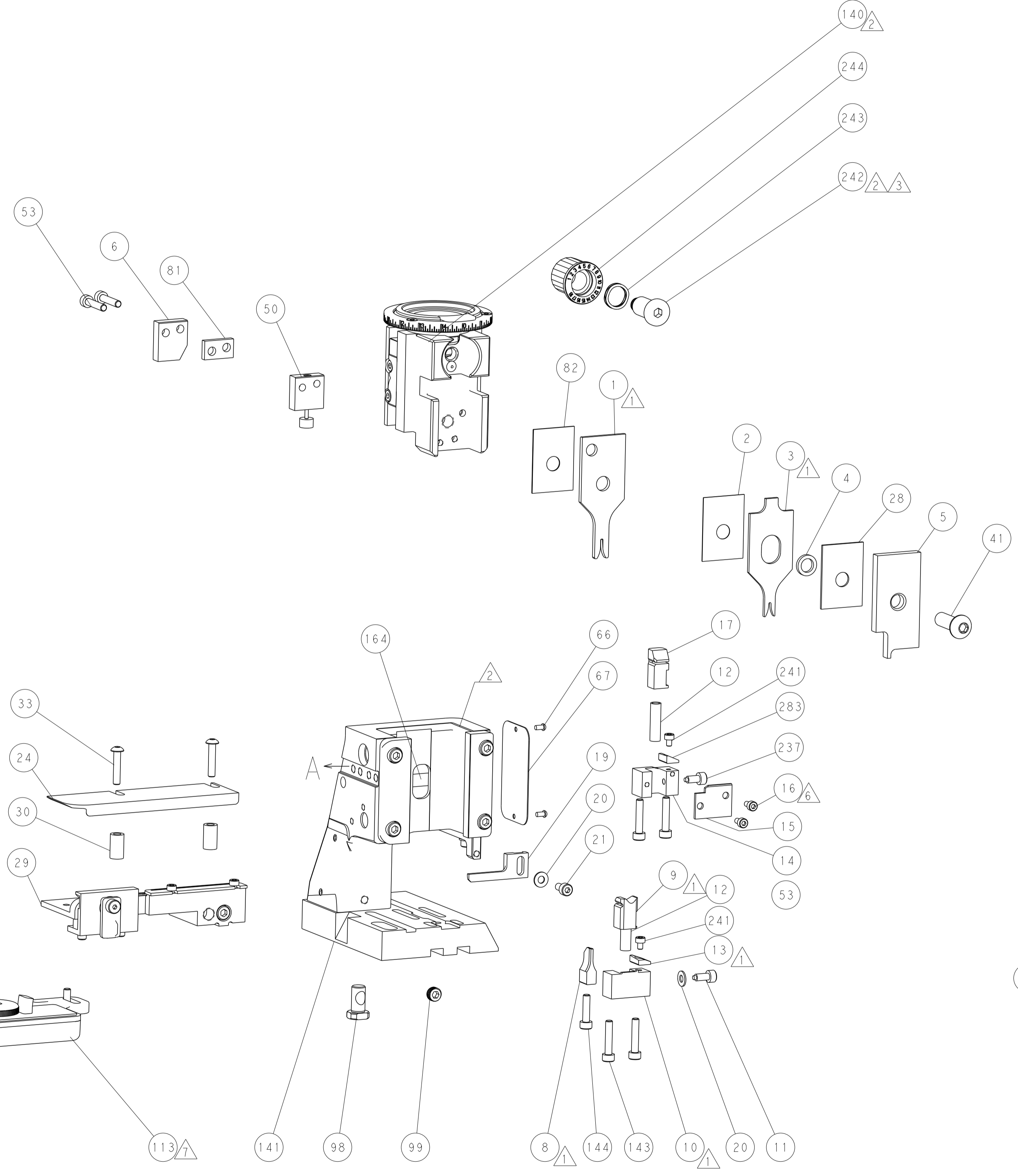
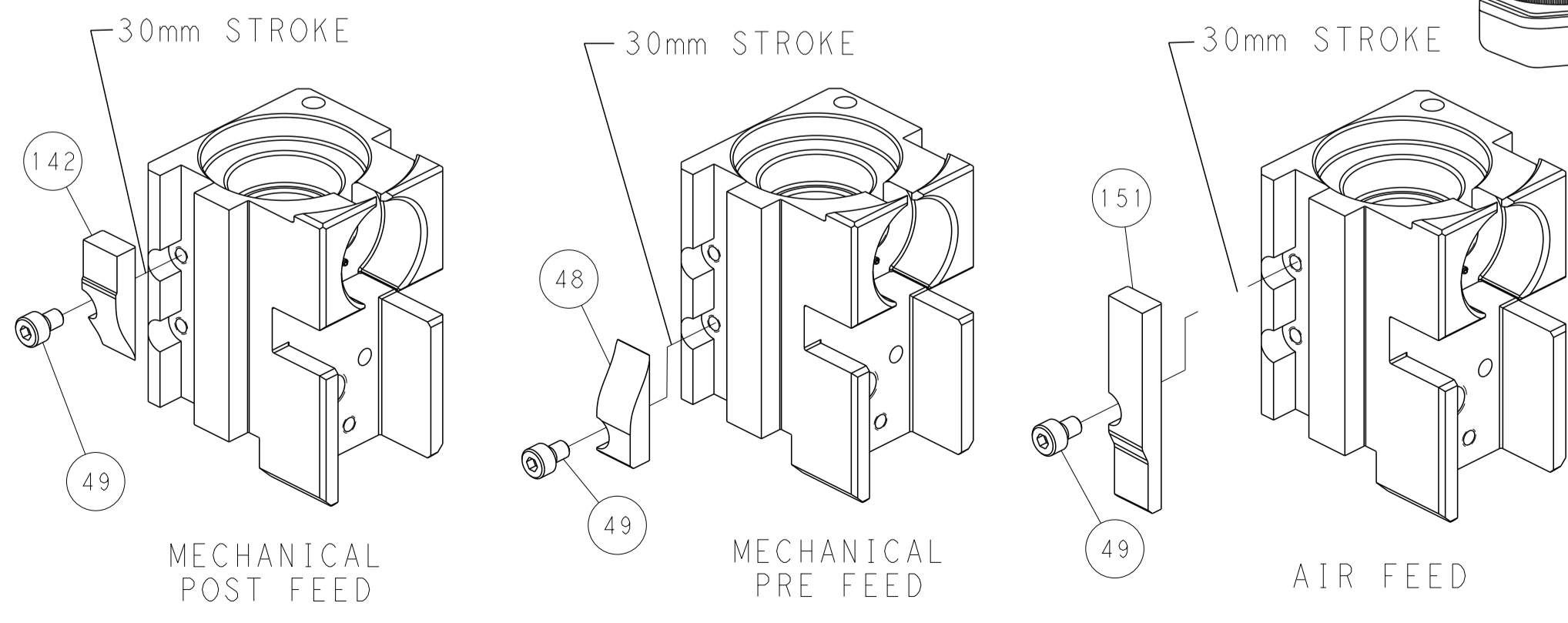
PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		TE Connectivity	
mm	0 PLC	±		CHK	STAKEM	29MAY2013	Harrisburg, PA 17105-3608
	1 PLC	±		CHK	G. BAILEY	29MAY2013	
	2 PLC	±		APVD	T. ELBIN	29MAY2013	
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
	FINISH						
MATERIAL				NAME	Ocean Side Feed Applicator		
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				WEIGHT	A1	00779	©=2151967
				Customer Accessible Production Drawing	SCALE	1:2	SHEET 4 OF 4 REV E