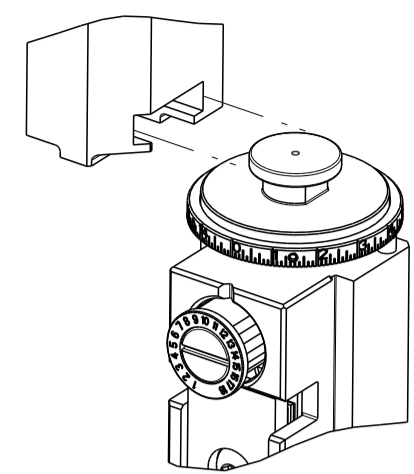


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151316-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151316-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151316-7	A	CRIMP TOOLING KIT	-

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 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

- 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].
- 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	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APPD
		B		ECR-18-004534	26MAR2018	MEH	JDG
		C		ECR-20-005218	08APR2020	FJ	TE
		D		ECR-20-007667	28MAY2020	JAH	GB
		E		ECR-22-153498	22SEP2022	ROY	GEB

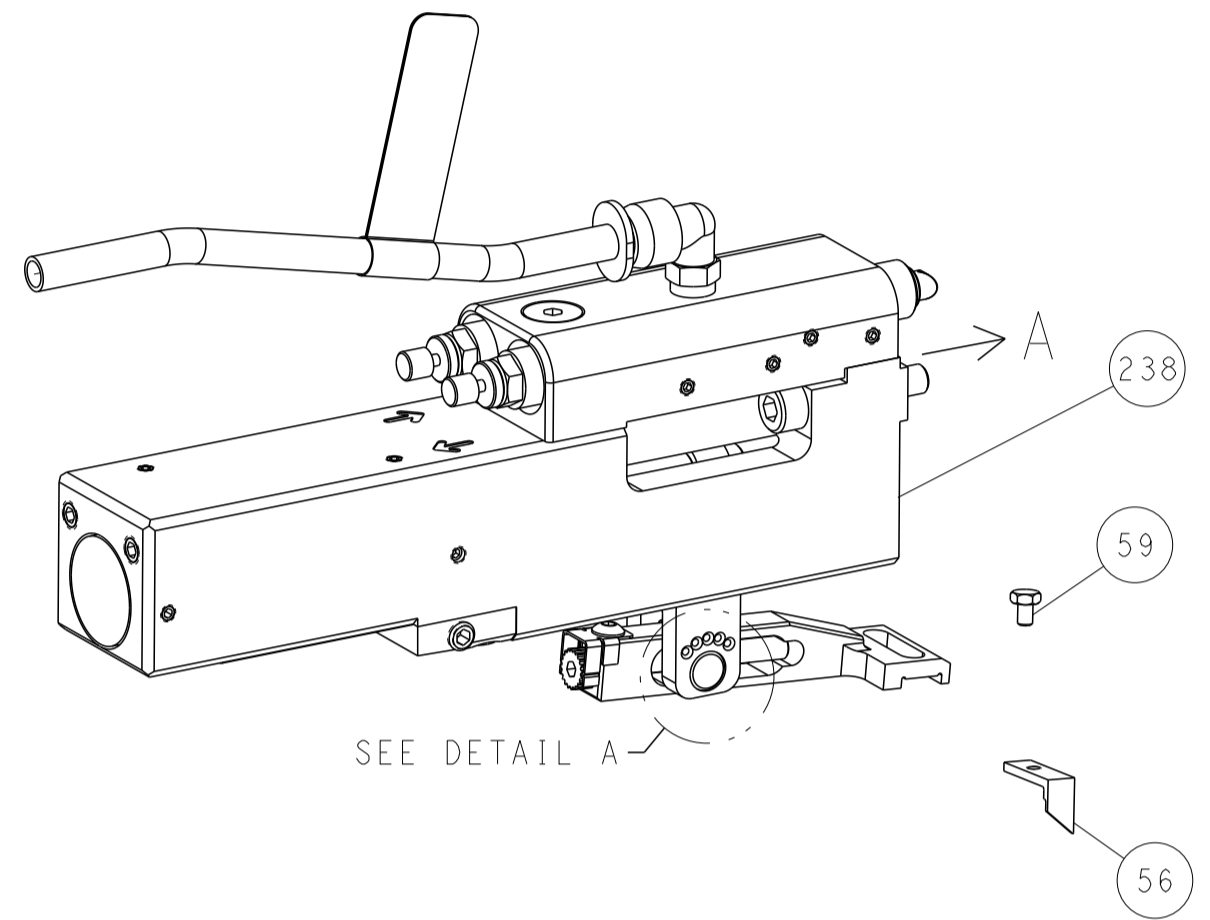
-	1	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	283
-	1	1	1803315-1	LOWER SHEAR, RIGHT	282
-	1	1	1-18028-3	WASHER, FLAT, REG M5	281
-	1	1	1803196-1	STUD, ADJUSTMENT SCREW	280
-	1	1	23238-1	INSERT, COUPLING	278
-	1	1	2030758-3	TUBING, POLYURETHANE	277
-	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	276
-	1	1	986220-2	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
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	53
-	1	1	1-2119830-3	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
-	1	2	1803316-1	ANVIL, COMBINATION	8
-	-	-	-	-	6
-	1	1	6-690518-4	HOLD DOWN, TERMINAL	5
-	-	-	-	-	4
-	1	1	238011-1	BLOCK, CRIMPER SPACER	3
-	1	2	1-1633966-1	CRIMPER, INSULATION O	2
-	1	1	1-455888-3	SPACER, CRIMPER	2
-	1	2	3-456411-0	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:				
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE	1:2	SHEET	1	OF	4	REV	E

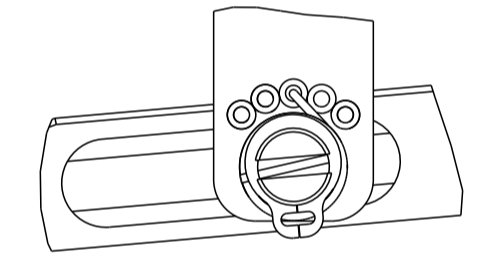
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

# FEED TYPE

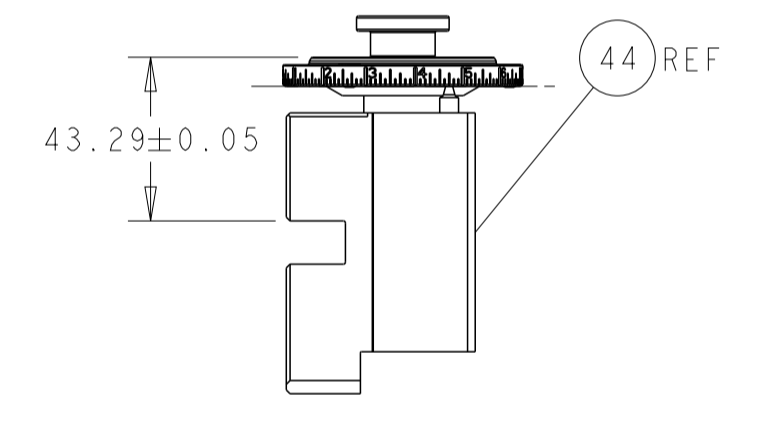
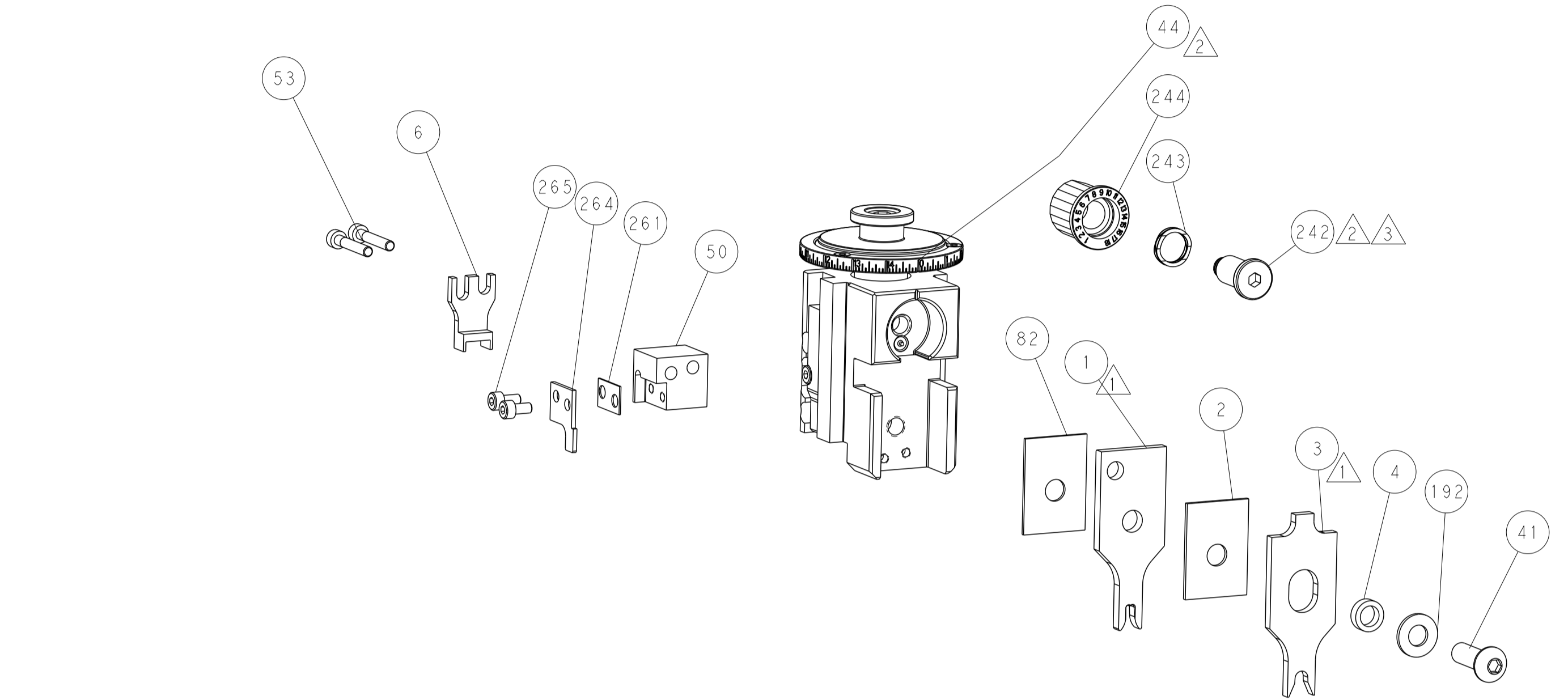
## PNEUMATIC



FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

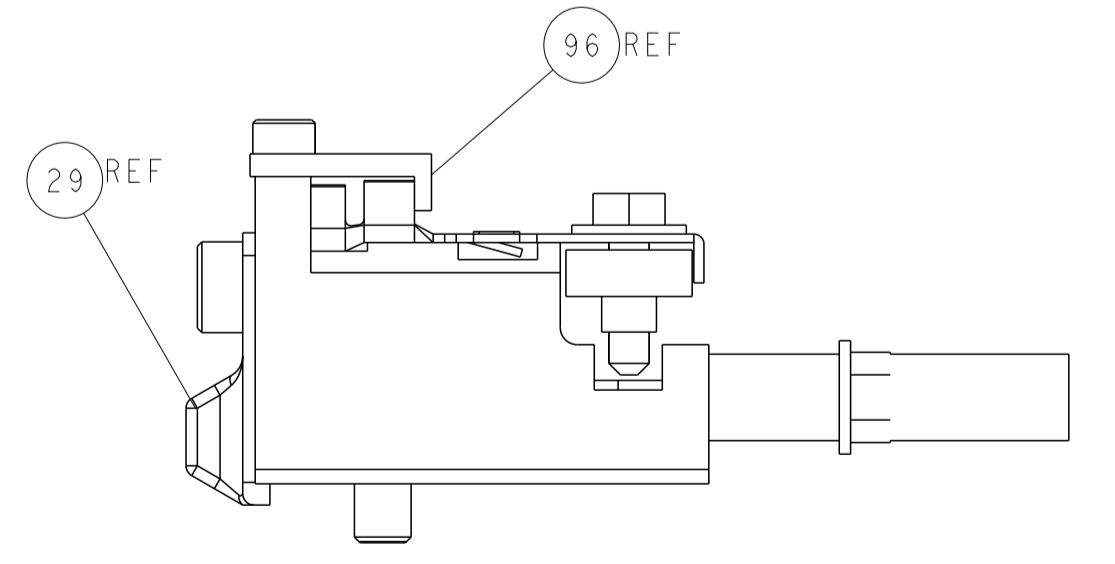
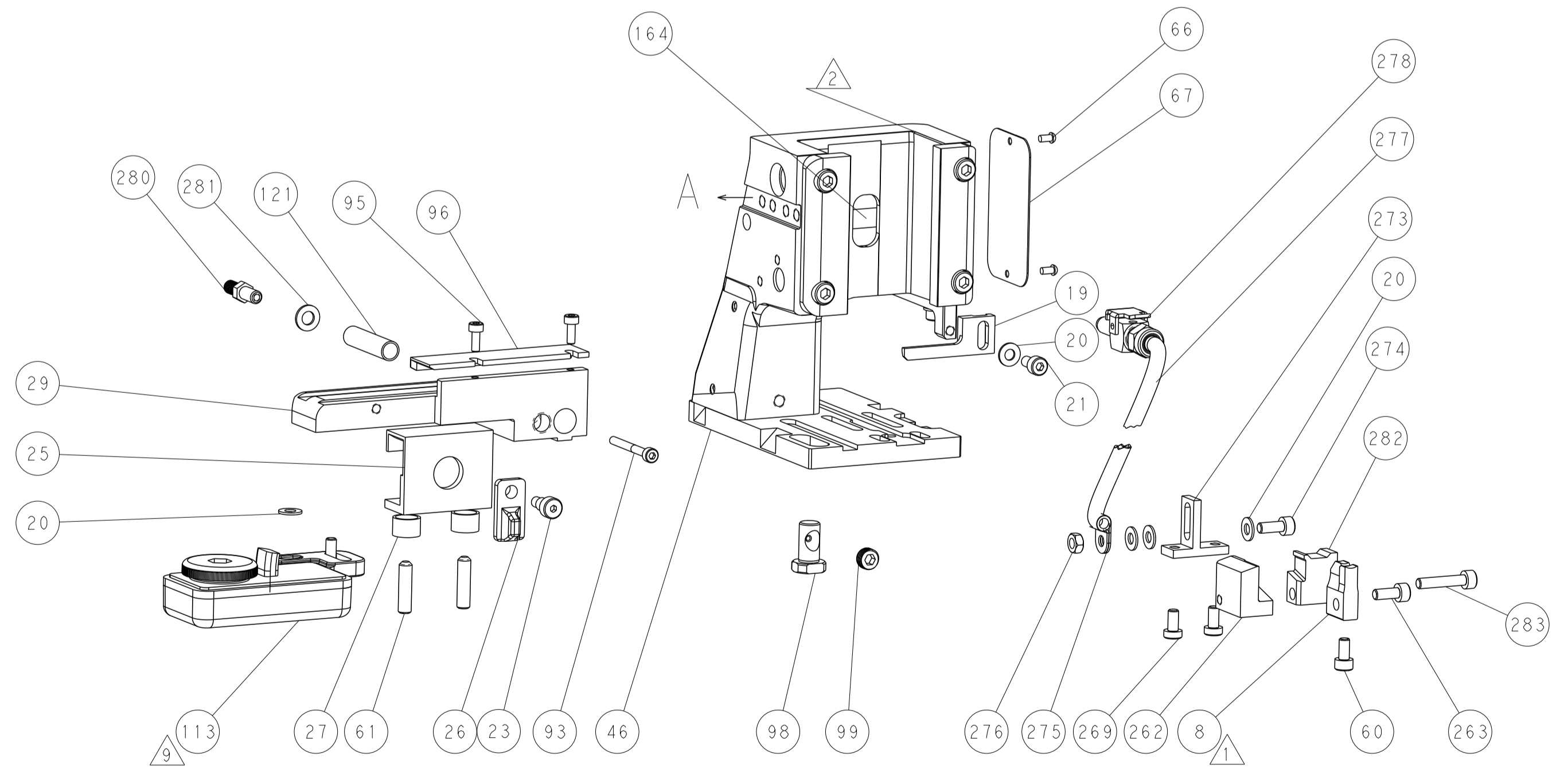
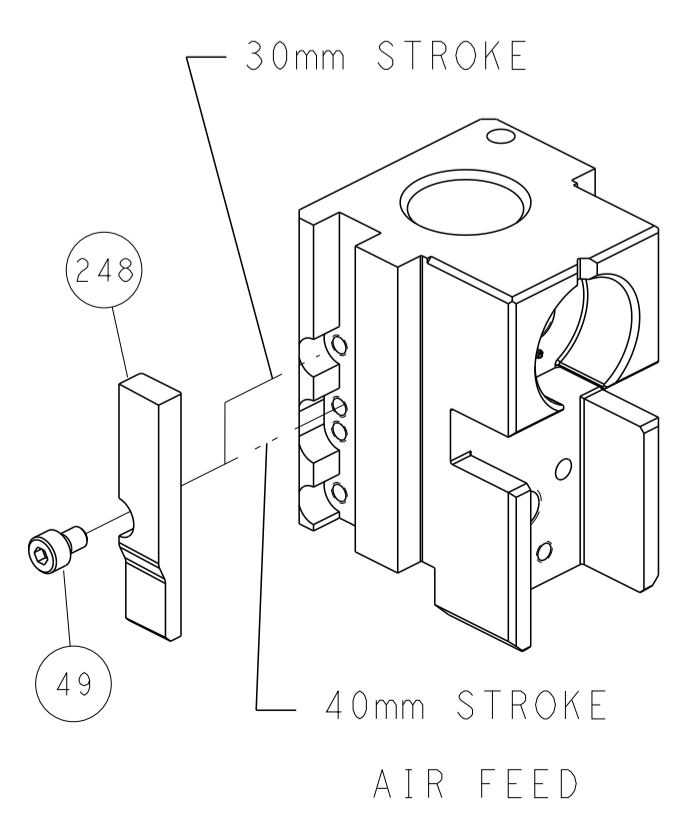


DETAIL A



RAM SET-UP

## CAM POSITION



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 UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2000 BY TYCO ELECTRONICS CORPORATION. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2000 BY TYCO ELECTRONICS CORPORATION. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2000 BY TYCO ELECTRONICS CORPORATION.</small>		DWN R. KNEPPER 21-Oct-15 CHK G. BAILEY 21-Oct-15 APVD T. ELBIN 21-Oct-15	NAME Ocean Side Feed Applicator
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	SIZE A1 00779 CAGE CODE 2151316 DRAWING NO ©=2151316	RESTRICTED TO Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV E

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151316-2	E	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 [1.40]	F
INSUL	5.59 mm [2.20]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POWER RING			
WIRE STRIP LENGTH 5.95-6.75 mm [2.34-.266 IN]		INSULATION DIAMETER RANGE Ø2.79-4.06 mm [1.110-.160 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2087			
TERMINALS APPLIED			
TE TERMINAL 63166-1	TE TERMINAL 63166-2	TE TERMINAL 63166-4	TE TERMINAL 63166-5
521843-1	521844-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 14 AWG	3.07 +/- 0.05 [1.21 +/- .002]	3.7
12 AWG	2.90 +/- 0.05 [1.14 +/- .002]	5.1
14 AWG	2.64 +/- 0.05 [1.04 +/- .002]	8.0
16 AWG	2.46 +/- 0.05 [1.097 +/- .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 [1.734-.766 IN].
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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	CHKD	APVD
A	66					

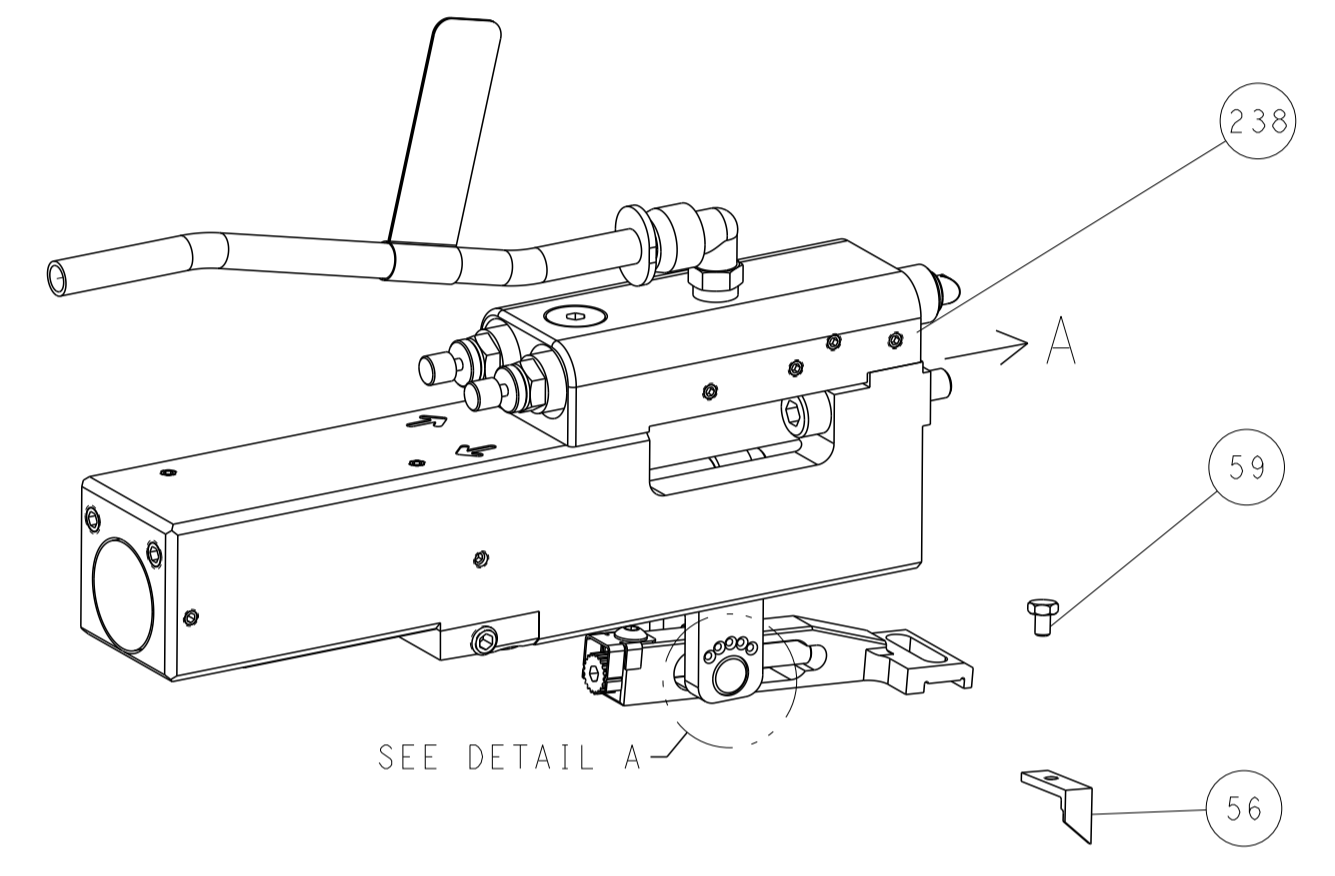
REVISIONS						
REV	DATE	DESCRIPTION	DATE	BY	CHKD	APVD
-	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20			283
-	1	1803315-1	LOWER SHEAR, RIGHT			282
-	1	1-18028-3	WASHER, FLAT, REG M5			281
-	1	1803196-1	STUD, ADJUSTMENT SCREW			280
-	1	23238-1	INSERT, COUPLING			278
-	1	2030758-3	TUBING, POLYURETHANE			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
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			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
3	-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
-	1	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
7	-	1	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
-	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25			53
-	1	1-2119830-3	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
-	1	6-690518-4	HOLD DOWN, TERMINAL			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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±
	ANGLES	FINISH					
MATERIAL				WEIGHT			
THE DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRONIC INDUSTRY IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWG: R. KNEPPER 21-Oct-15 CHK: G. BAILEY 21-Oct-15 APVD: T. ELBIN 21-Oct-15		NAME: TE Connectivity Harrisburg, PA 17105-3608	
SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151316				APPLICATION SPEC: - PRODUCT SPEC: -		SCALE: 1:2 SHEET: 3 OF 4 REV: E	

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

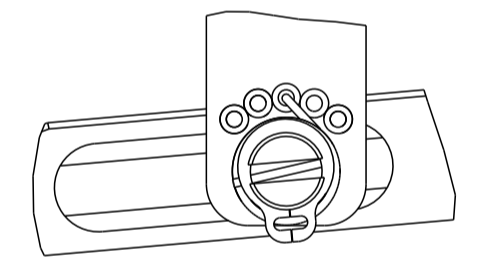
# FEED TYPE

## PNEUMATIC



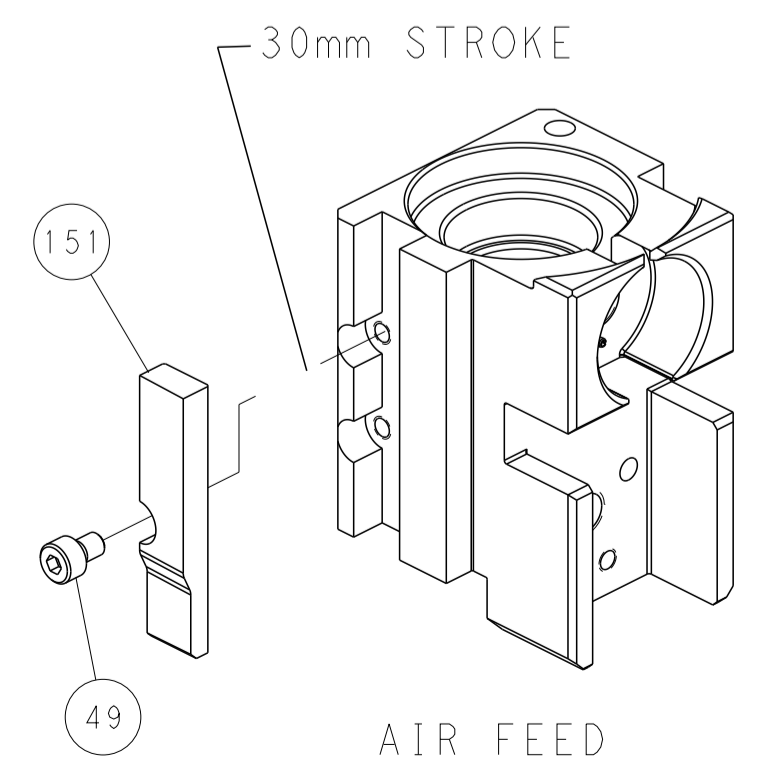
SEE DETAIL A

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

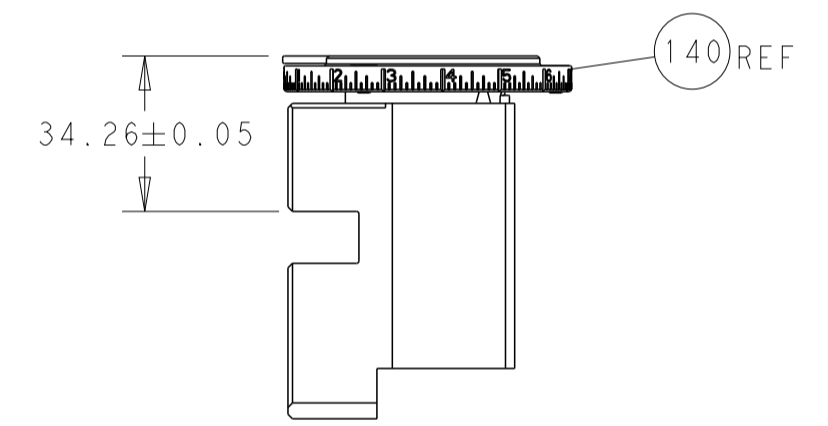
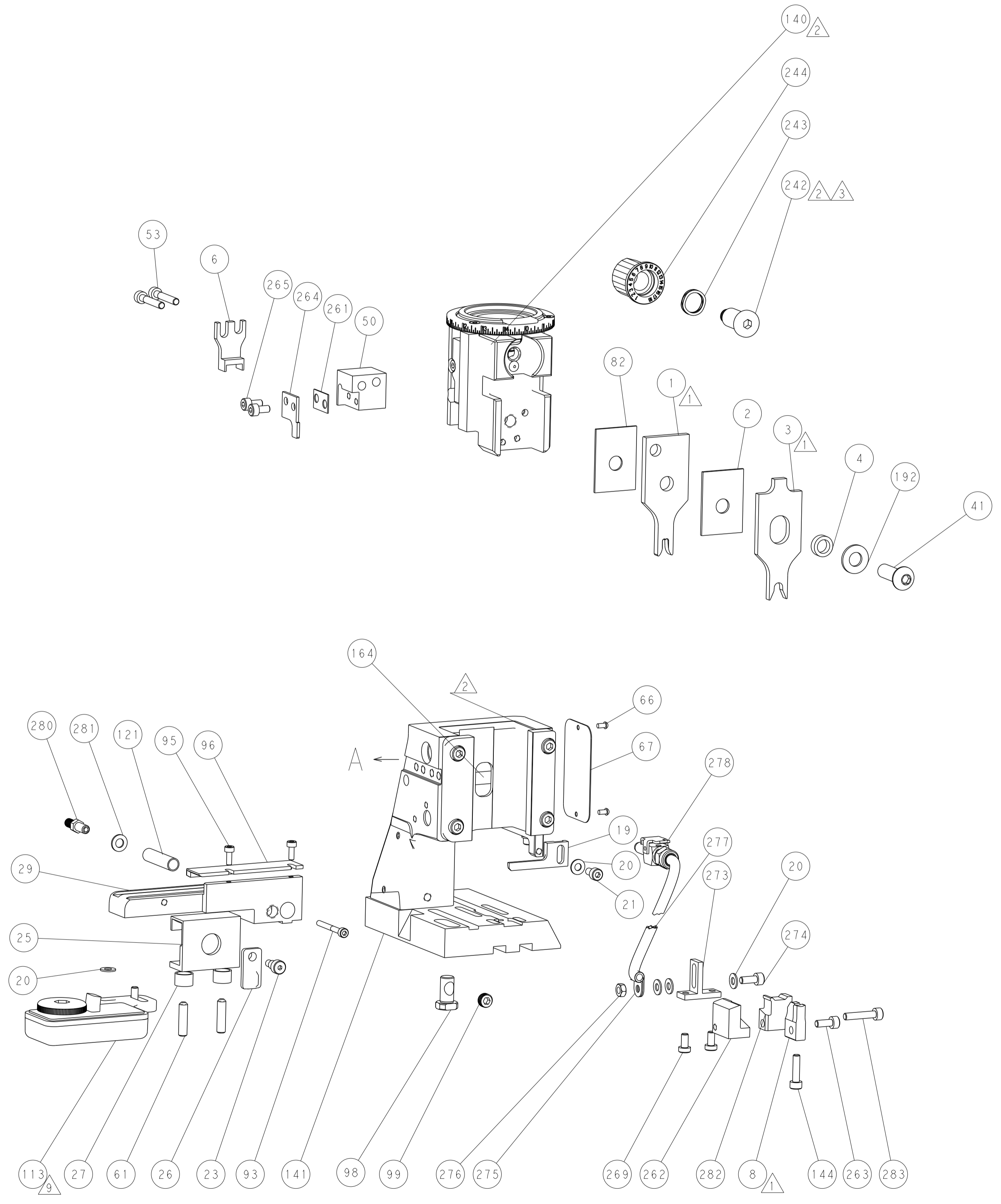


DETAIL A

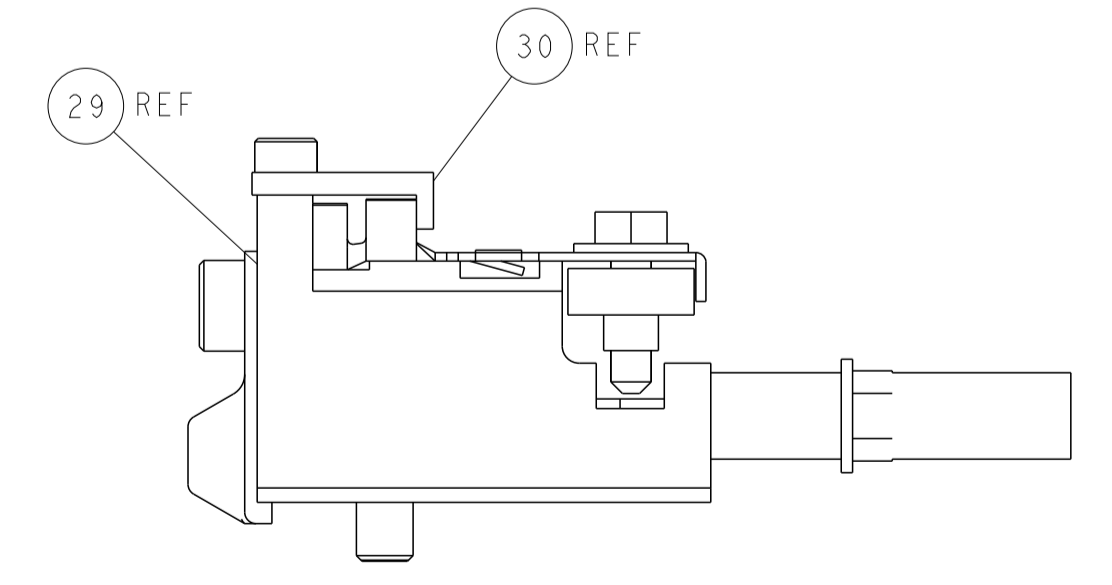
## CAM POSITION



AIR FEED



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151316 SHEET 4 OF 4 REV E