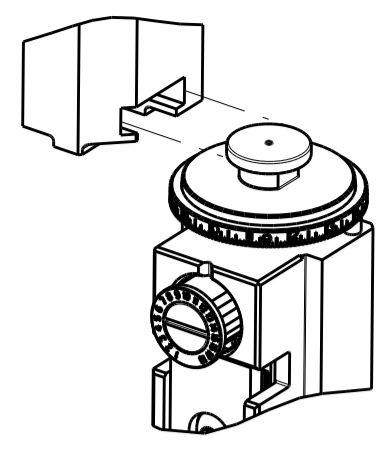


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151696-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151696-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151696-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151696-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151696-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.5MM SYST., CONTACT SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.80 mm [.205-.228 IN]		∅ 3.40mm MAX [.134 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-18031-1		

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
928984-2	928986-3	828920-1		∅ 1.2-2.0 mm
928984-4	928986-4	828920-2		∅ 1.2-2.0 mm
928984-5	928986-5			
928986-2				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.43 +/- 0.05 [.056 +/- .002]	10.6
0.75mm2	1.33 +/- 0.05 [.052 +/- .002]	11.6
0.50mm2	1.23 +/- 0.05 [.048 +/- .002]	12.7

- △ 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- △ WHEN USING TERMINAL 928984 USE ITEM 264 DIM 7.62 (.300)
WHEN USING TERMINAL 928986 USE ITEM 34 DIM 12.70 (.500)
- △ 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)

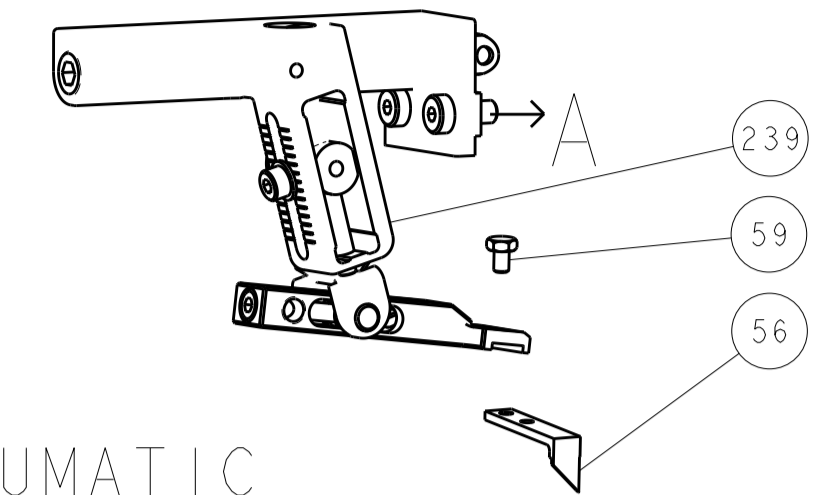
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		D		ECR-18-013199	20AUG2018	FL	TE
		E		ECR-19-009659	20JUN2019	FJ	TE
		F		ECR-20-015814	09NOV2020	JWC	GB

7	-	1	1	1	1	1752356-4	SUPPORT, TERMINAL	264
	-	1	1	1	1	455888-2	SPACER, CRIMPER	263
	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	262
	-	1	1	1	1	2119943-1	WASHER, SPACER	261
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	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
	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
8	-	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	455888-4	SPACER, CRIMPER	82
	-	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
6	-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	690753-2	SPACER, TONKER	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
7	-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-5	SPACER, CRIMPER	28
	-	1	1	1	1	1320928-6	STRIP GUIDE	24
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-3	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	318707-4	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	7-1333204-3	ANVIL, COMBINATION	8
	-	1	1	1	1	6-240641-4	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	3-2119784-1	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	2	2	1	1	1-456405-3	CRIMPER, WIRE PREMIUM	1
	-	77	-72	-71	-2	-1	PART NO	
							DESCRIPTION	ITEM NO

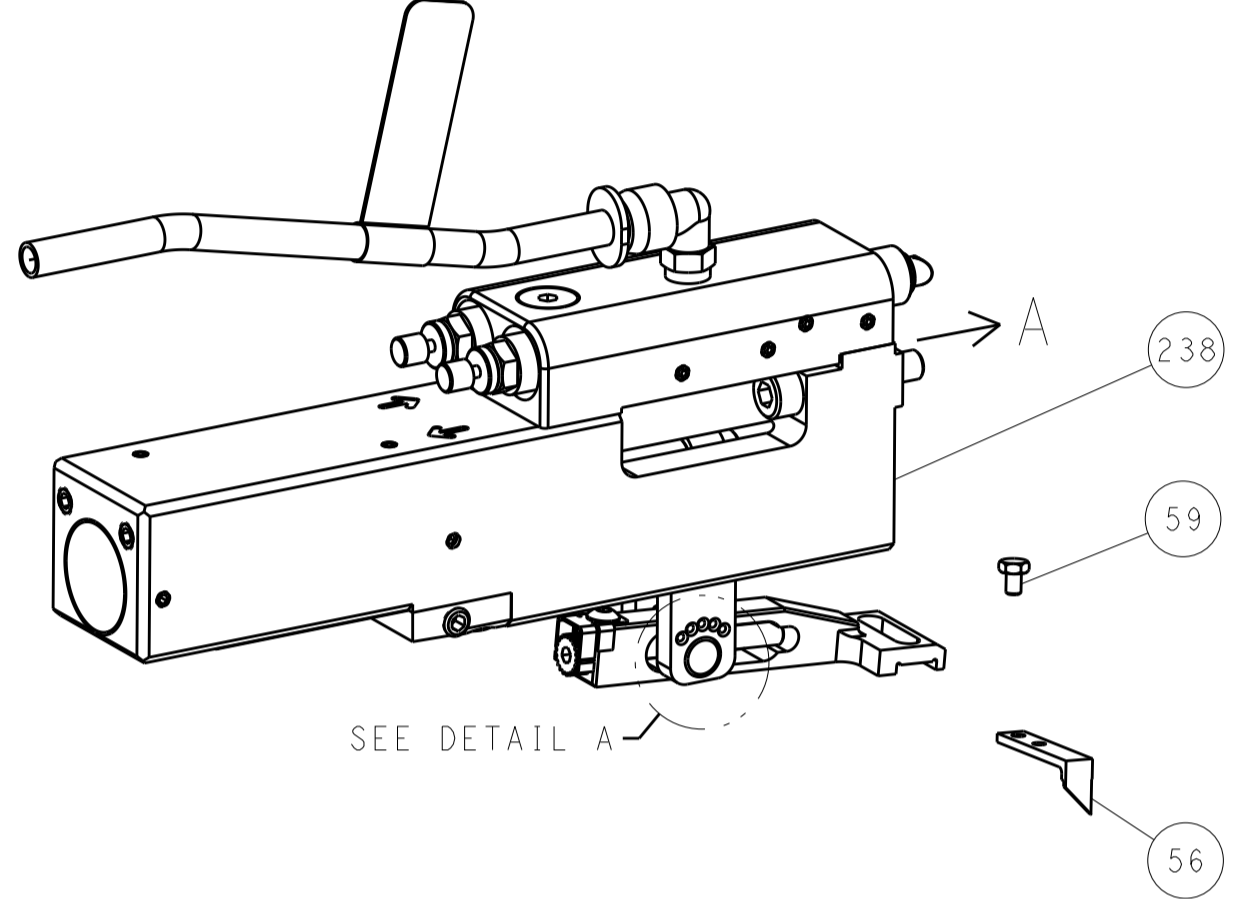
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		FINISH		APVD	31 JUL 2012	NAME
MATERIAL		FINISH		PRODUCT SPEC		SIZE
				APPLICATION SPEC		CAGE CODE
				WEIGHT		DRAWING NO
				SCALE		RESTRICTED TO
				Customer Accessible Production Drawing		REV F

LOC	DIST	REV	DATE	BY	APPV
A	66				

FEED TYPE MECHANICAL



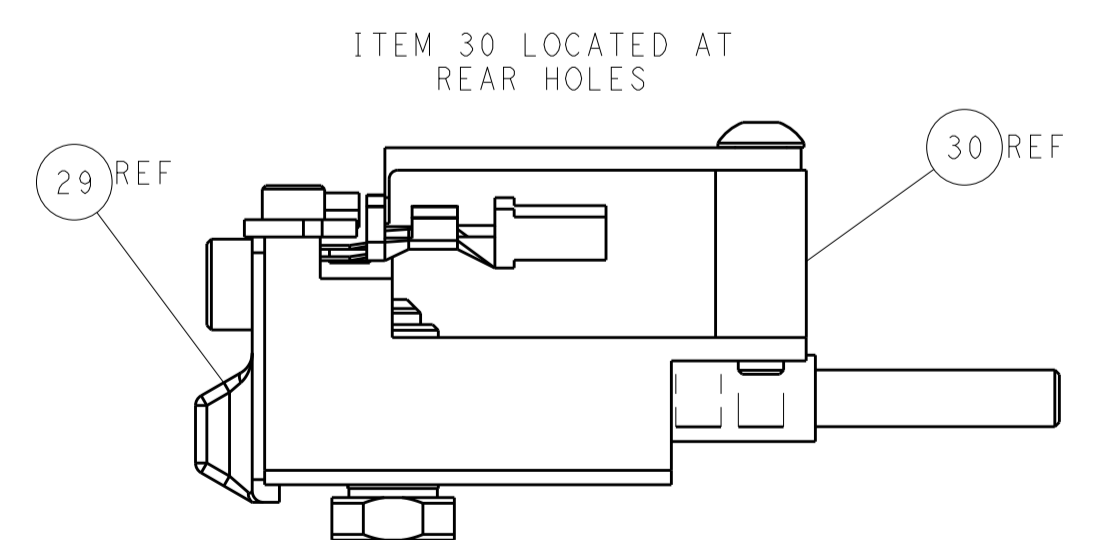
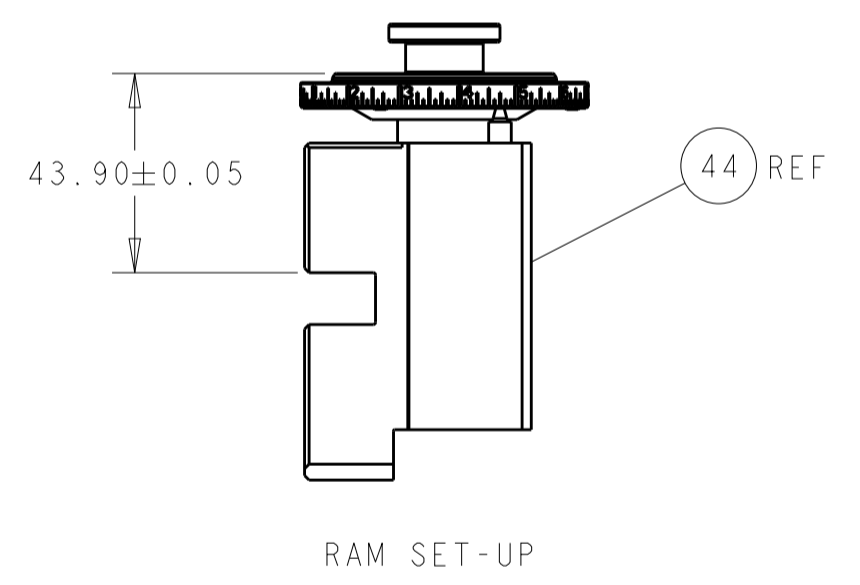
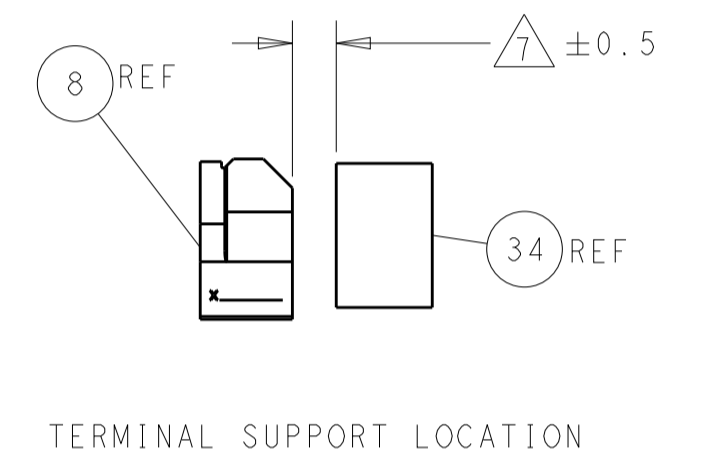
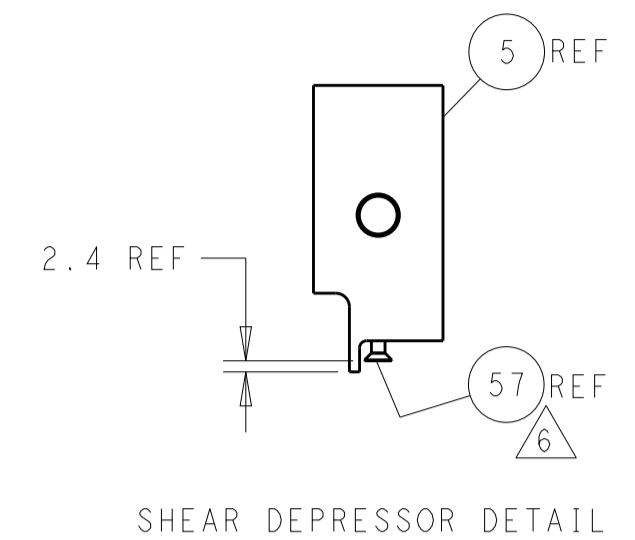
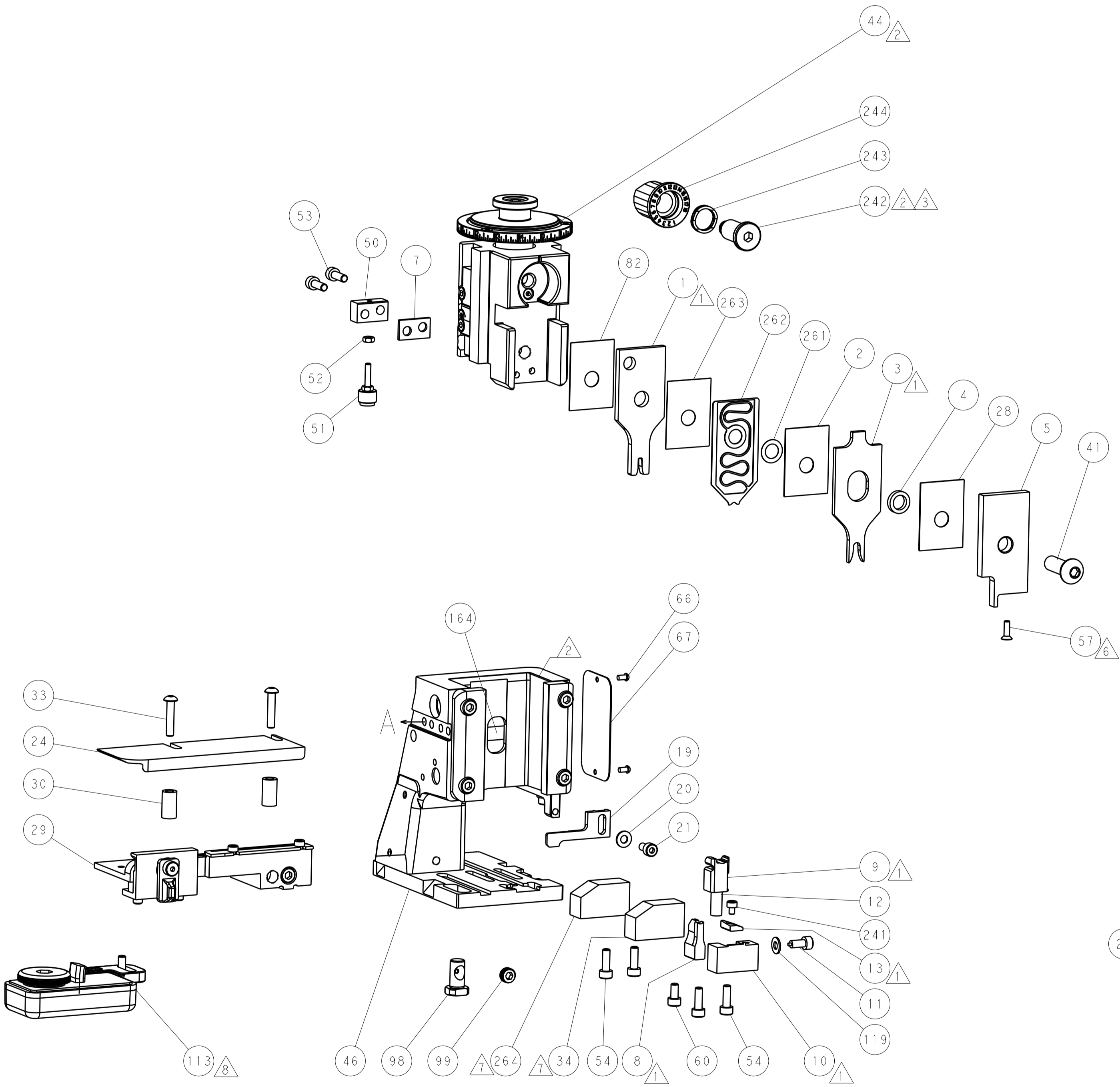
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN: Y. YIN 31 JUL 2012 CHK: G. BAILEY 31 JUL 2012 APVD: S. XI 31 JUL 2012 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151696 RESTRICTED TO: F	
MATERIAL: - FINISH: -		WEIGHT: - SCALE: 1:2 SHEET: 2 OF 4 REV: F	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151696-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151696-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151696-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.5MM SYST., CONTACT SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.80 mm [1.205-.228 IN]		3.40mm MAX [1.134 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-18031-1		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
928984-2	928986-3	828920-1	
928984-4	928986-4	828920-2	
928984-5	928986-5		
928986-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.43 +/- 0.05 [1.056 +/- .002]	10.6
0.75mm2	1.33 +/- 0.05 [1.052 +/- .002]	11.6
0.50mm2	1.23 +/- 0.05 [1.048 +/- .002]	12.7

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- WHEN USING TERMINAL 928984 USE ITEM 264 DIM 7.62 (.300) WHEN USING TERMINAL 928986 USE ITEM 34 DIM 12.70 (.500)
- 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.

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					

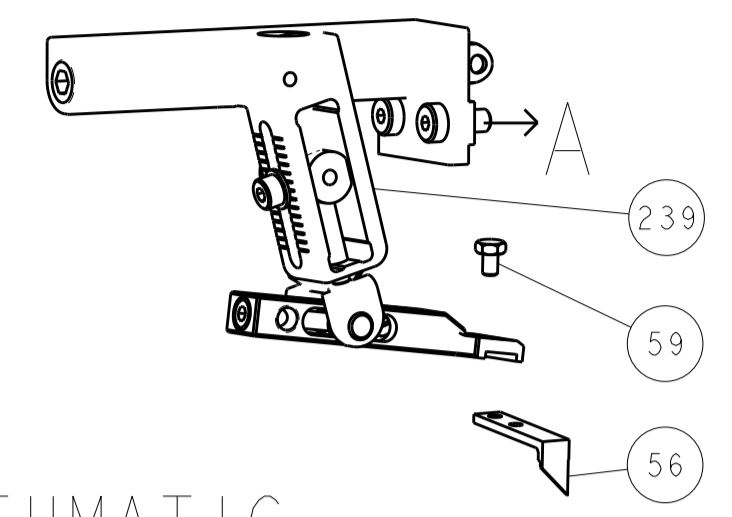
REVISIONS						
REV	DATE	DESCRIPTION	DATE	BY	CHKD	APVD
-	-	SEE SHEET 1	-	-	-	-
-	1	1	1752356-4	SUPPORT, TERMINAL		264
-	1	1	455888-2	SPACER, CRIMPER		263
-	1	1	2119791-9	DEPRESSOR, WIRE		262
-	1	1	2119943-1	WASHER, SPACER		261
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	1	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
-	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	1-18028-2	WASHER, FLAT, REG M4		119
-	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	455888-4	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0		57
-	1	1	1338685-1	PAWL, FEED		56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3		52
-	1	1	811242-5	BUMPER, HOLD DOWN		51
-	1	1	690753-2	SPACER, TONKER		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
-	1	1	1752356-6	SUPPORT, TERMINAL		34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	1	2844992-1	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	2119806-1	INSERT, SHEAR		13
-	1	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1	1-356885-3	STOP, SHEAR		11
-	1	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	1	318707-4	FLOATING SHEAR, FRONT		9
-	1	1	7-1333204-3	ANVIL, COMBINATION		8
-	1	1	6-240641-4	SPACER		7
-	-	-	-	-		6
-	1	1	2119781-5	DEPRESSOR, SHEAR		5
-	1	1	238011-9	BLOCK, CRIMPER SPACER		4
-	1	1	3-2119784-1	CRIMPER, INSULATION O PREMIUM		3
-	1	1	455888-5	SPACER, CRIMPER		2
-	1	1	1-456405-3	CRIMPER, WIRE PREMIUM		1

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

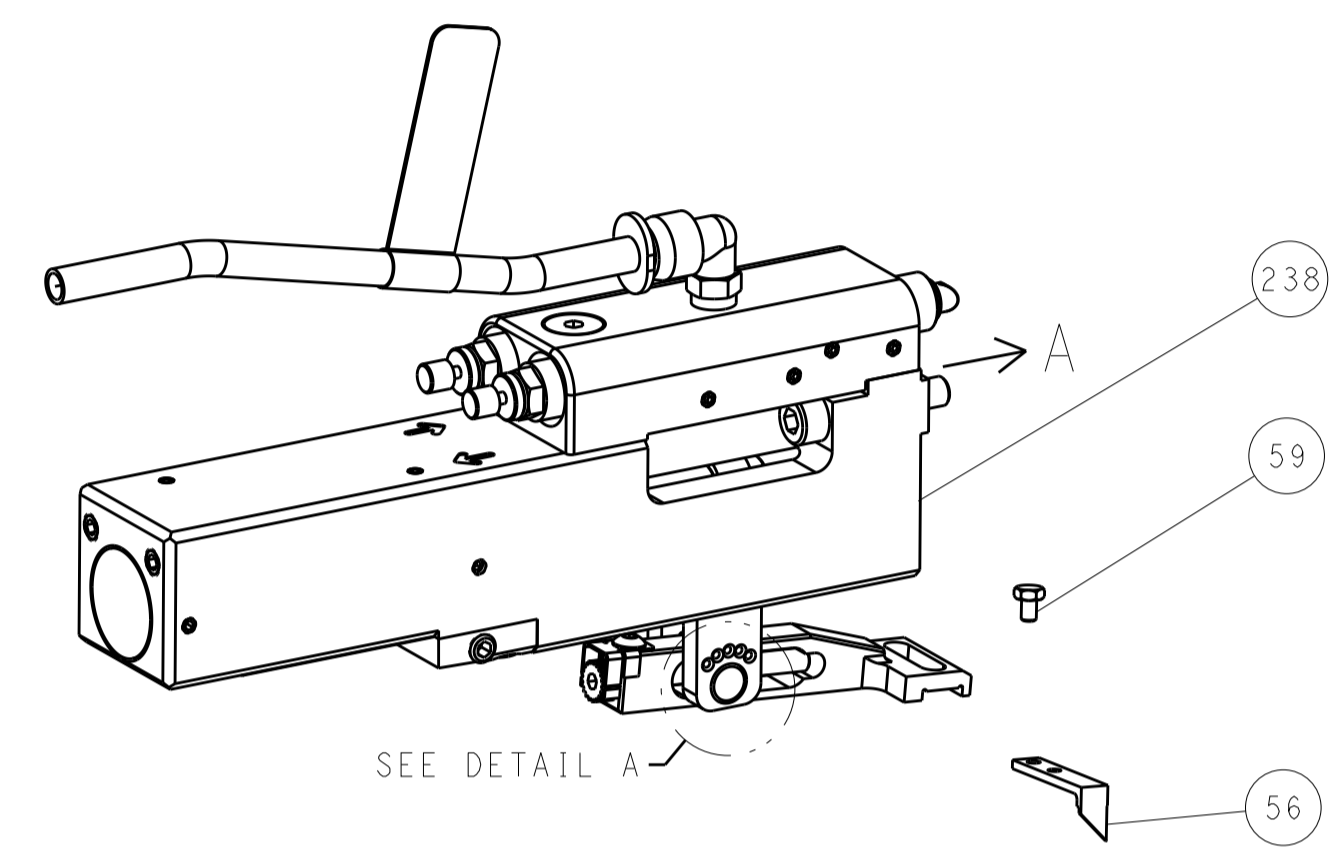
DATE	31 JUL 2012	CHKD	G. BAILEY	DATE	31 JUL 2012	APVD	S. XI
NAME	Ocean Side Feed Applicator						
SIZE	A1	CAGE CODE	00779	DRAWING NO	C=2151696		RESTRICTED TO
SCALE	1:2	SHEET	3	OF	4	REV	F

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

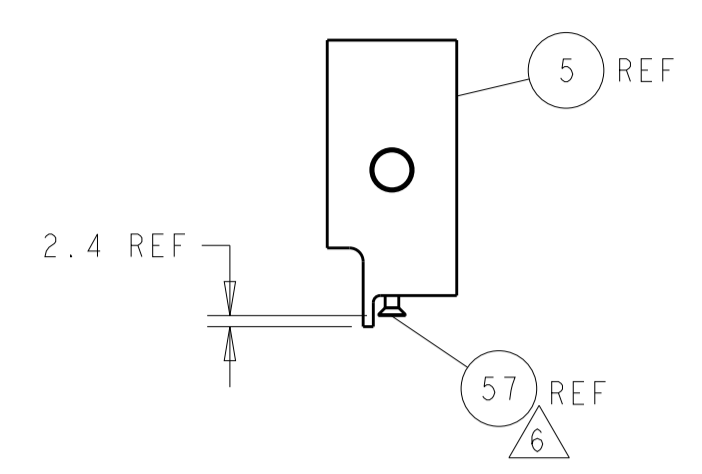
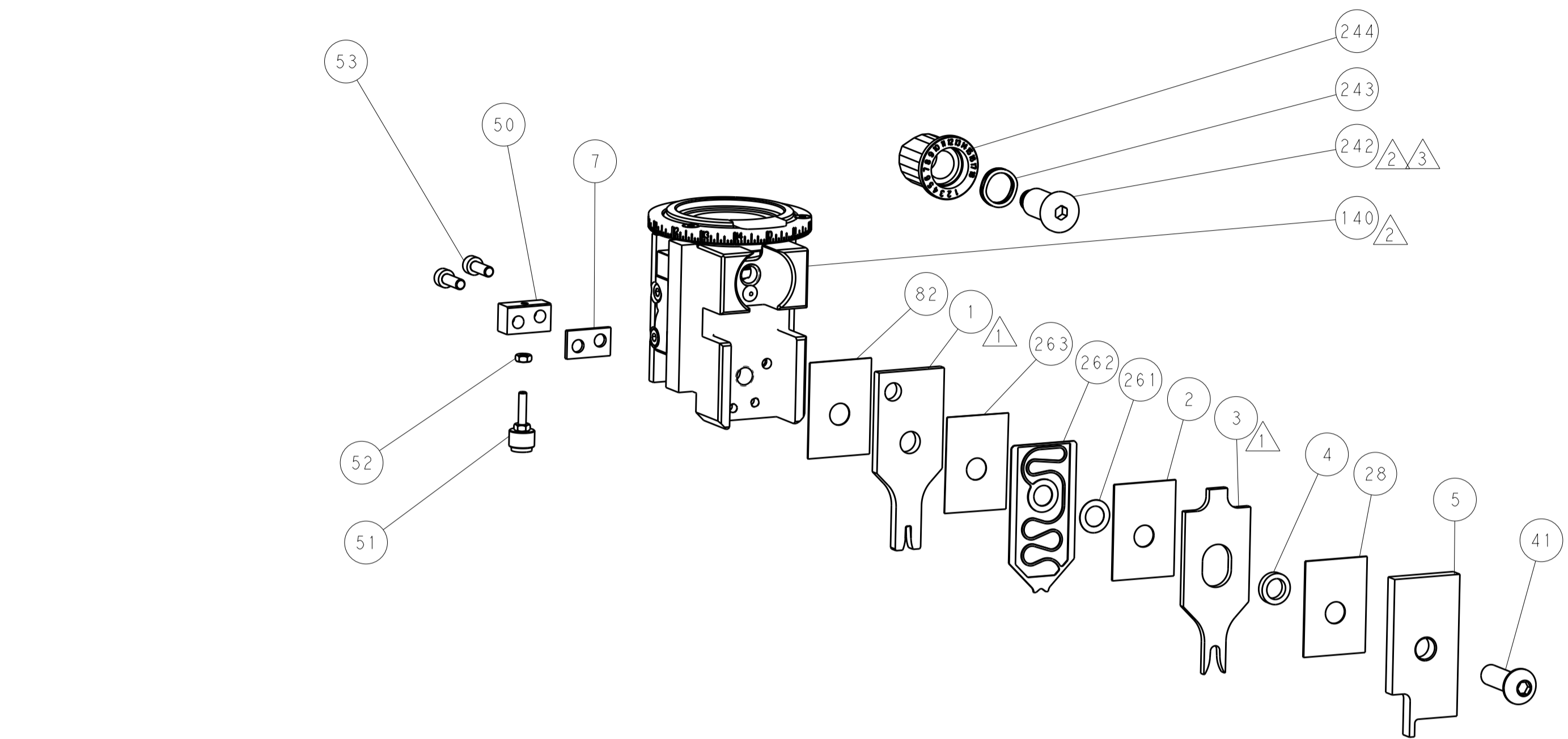
FEED TYPE MECHANICAL



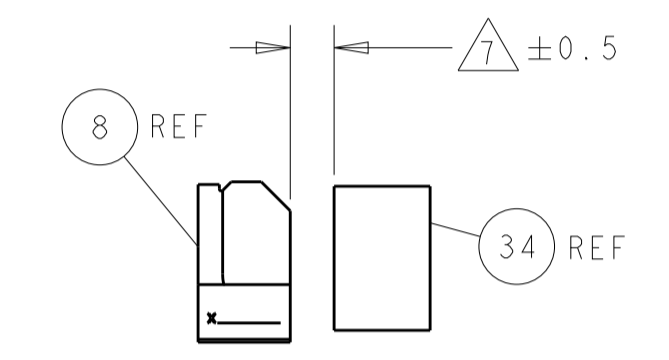
PNEUMATIC



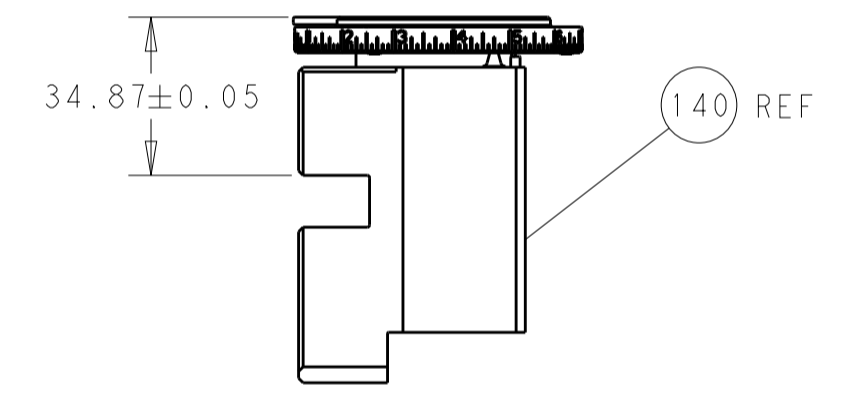
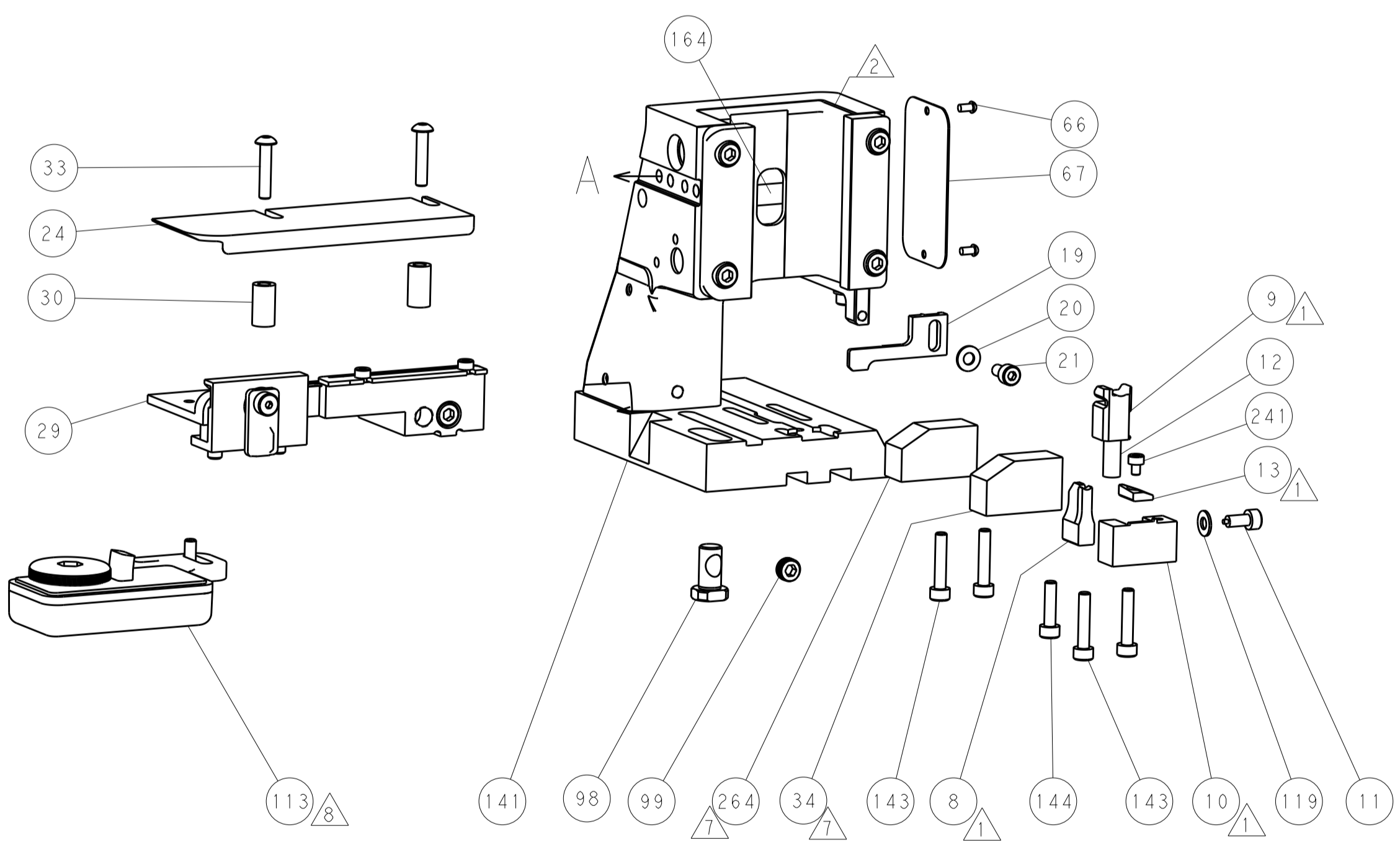
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



SHEAR DEPRESSOR DETAIL

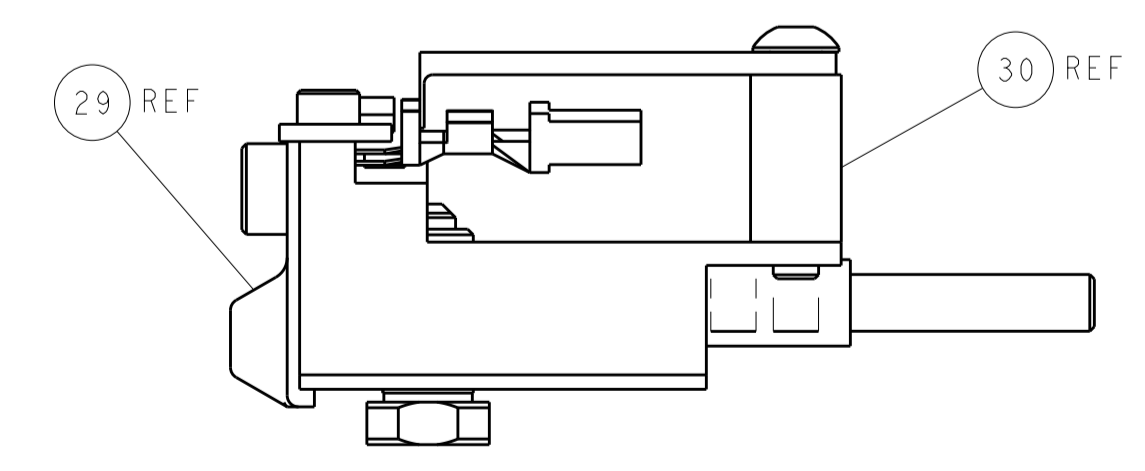


TERMINAL SUPPORT LOCATION



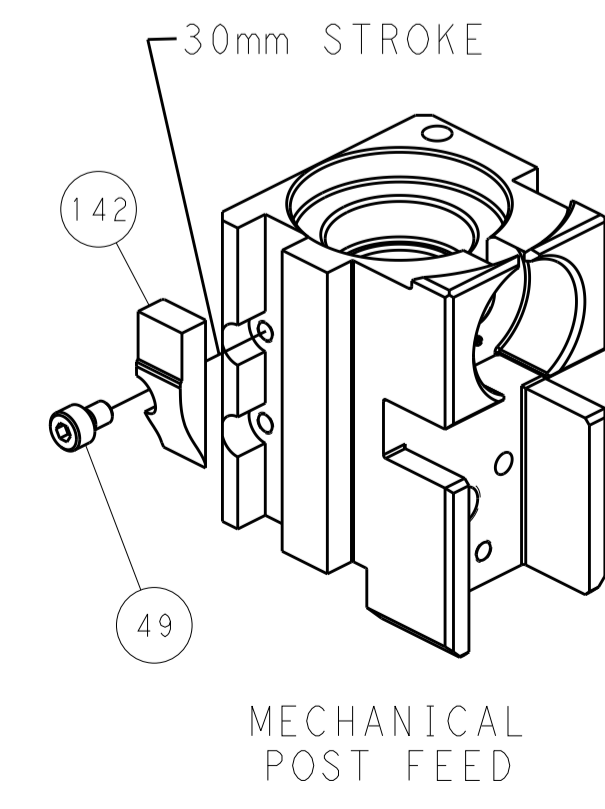
RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES

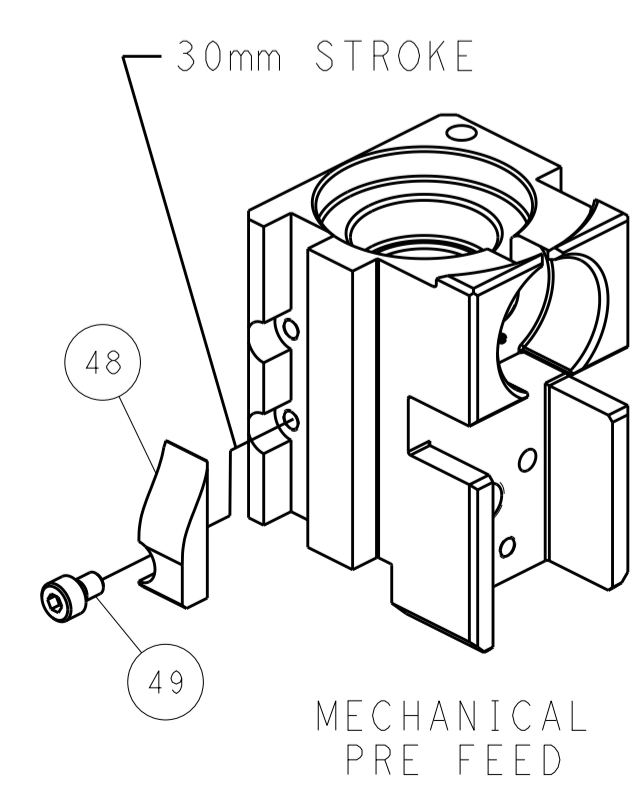


FEED TRACK POSITION GUIDE BY INSULATION BARREL

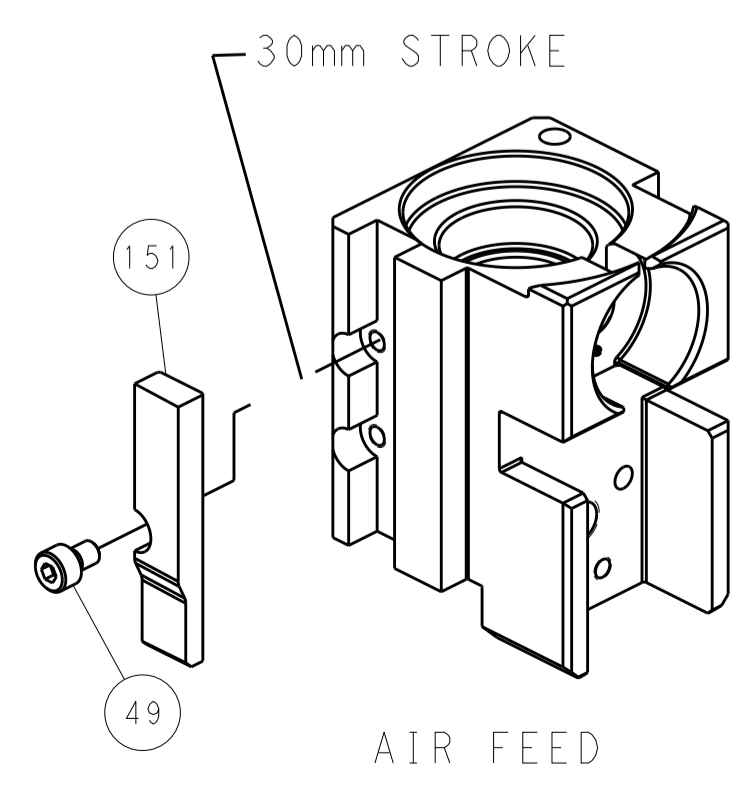
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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:		DWN	31 JUL 2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	31 JUL 2012	
	3 PLC ±	4 PLC ±	5 PLC ±	APVD	31 JUL 2012	NAME Ocean Side Feed Applicator
	6 PLC ±	7 PLC ±	8 PLC ±	S. XI		
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing	1:2	RESTRICTED TO