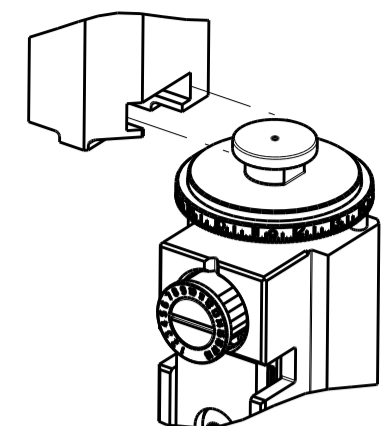


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2151487-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151487-2 | D | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151487-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 4.06 mm [.160] | F |
| INSUL | 5.33 mm [.210] | F |

APPLICATOR INSTRUCTIONS
408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|---------------|------------------------------|-------------|
| TERMINAL NAME: POSITIVE LOCK RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| .189-.213 IN [4.80-5.41 mm] | | ∅.134-.200 IN [3.40-5.08 mm] | |
| TERMINAL APPLICATION SPECIFICATION | (A) 114-20036 | | |
| | (B) 114-20029 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| (A) 790319-3 | (A) 790319-5 | (B) 281829-2 | |
| (A) 790319-4 | (B) 281829-1 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 6.00mm2 | 2.62 +/- 0.05 [1.103 +/- .002] | 3.7 |
| 4.00mm2 | 2.16 +/- 0.05 [1.085 +/- .002] | 8.9 |

- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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 | APPV |
| | | B | ECR-12-020498 | 28NOV2012 | L.Z S.X |
| | | C | REVISED ECR-13-014573 | 17SEP2013 | CC TE |
| | | C1 | ECR-14-004964 | 08APR2014 | YY TE |
| | | D | ECR-20-000951 | 19JAN2020 | FZ TE |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 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 |
| - | 1 | 1 | 18023-1 | SCR, SKT HD CAP M3 X 5.0 | 241 |
| - | 1 | 1 | 2844940-2 | AIR FEED MODULE | 238 |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | 1 | 455888-4 | SPACER, CRIMPER | 120 |
| - | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 693855-8 | FRONT STRIP GUIDE | 96 |
| - | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 95 |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 2119791-5 | DEPRESSOR, WIRE | 70 |
| - | 1 | 1 | 2119943-1 | WASHER, SPACER | 69 |
| - | 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 | 1338685-1 | PAWL, FEED | 56 |
| - | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 |
| - | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 53 |
| - | 1 | 1 | 1803382-6 | HOLD DOWN, SPRING LOADED | 50 |
| - | 1 | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | - | - | 2119653-1 | FEED CAM, POST FEED | 47 |
| - | 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 | 3-1752356-3 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 1-2079383-3 | SCR, BHSC, RoHS (M4 X 25) | 33 |
| - | 2 | 2 | 3-2844962-5 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 2844992-3 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 2 | 2 | 22283-1 | SPRING, COMPRESSION | 27 |
| - | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| - | 1 | 1 | 240792-1 | DRAG, TERMINAL | 25 |
| - | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 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 |
| - | 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 | 1-356885-4 | STOP, SHEAR | 11 |
| - | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 454276-5 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 2 | 1333211-1 | ANVIL, COMBINATION .150-.300 | 8 |
| - | 1 | 1 | 1-240641-1 | SPACER | 7 |
| - | 1 | 1 | 1-2119757-0 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1-238011-7 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 2 | 1-1633961-6 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 |
| - | 1 | 2 | 456414-9 | CRIMPER, WIRE | 1 |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN | CHK | APPV | DATE | DATE | DATE |
|-------------|-----|--|-----|--------|-----------|-------|-----------|-----------|-----------|
| mm | PLC | mm | PLC | Y. YIN | G. BAILEY | S. XI | 12AUG2011 | 12AUG2011 | 12AUG2011 |
| 0 | PLC | ± | PLC | | | | | | |
| 1 | PLC | ± | PLC | | | | | | |
| 2 | PLC | ± | PLC | | | | | | |
| 3 | PLC | ± | PLC | | | | | | |
| 4 | PLC | ± | PLC | | | | | | |
| ANGLES | | ± | | | | | | | |
| MATERIAL | | | | | | | | | |
| | | | | | | | | | |



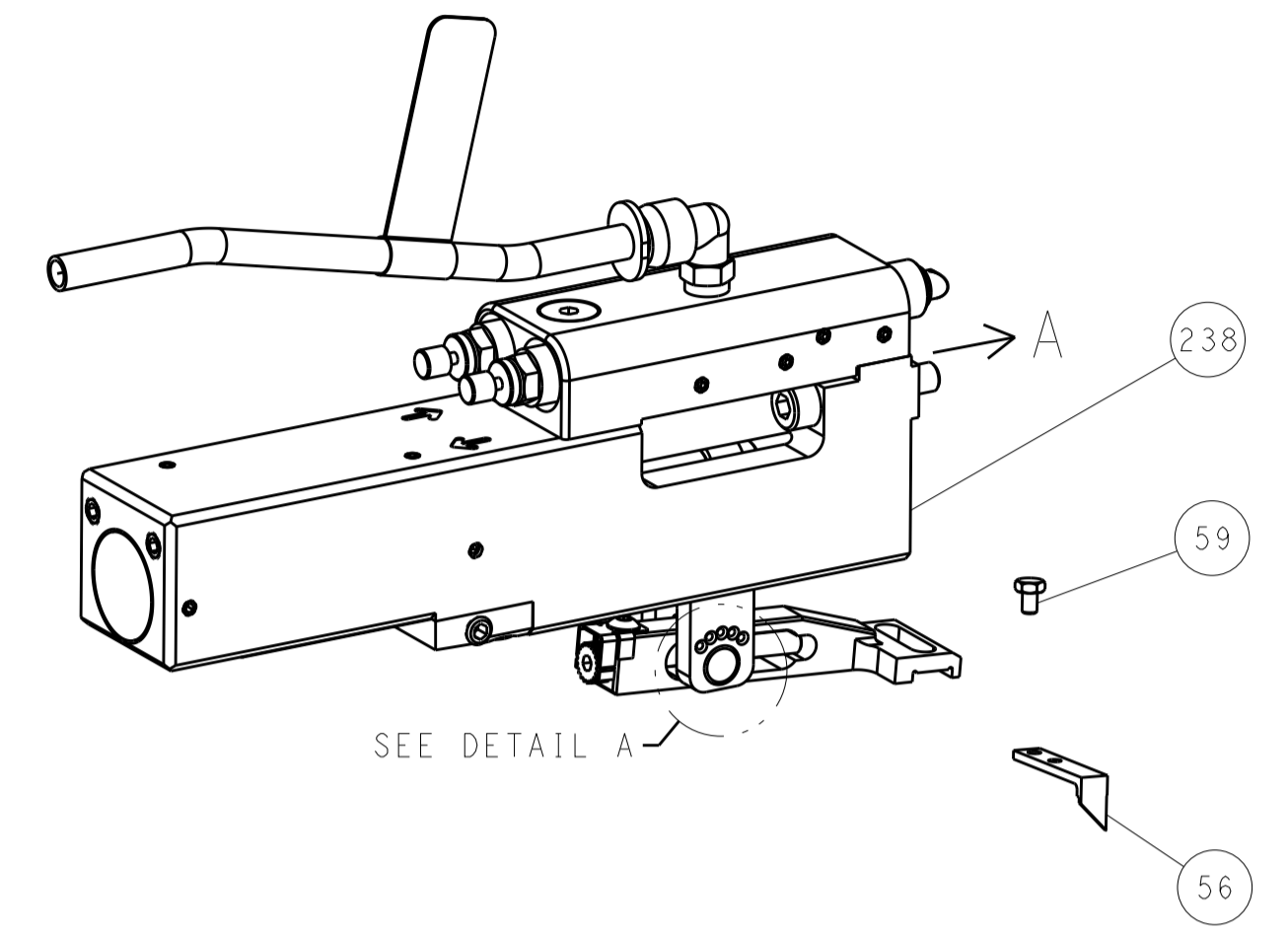
Ocean Side Feed Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151487

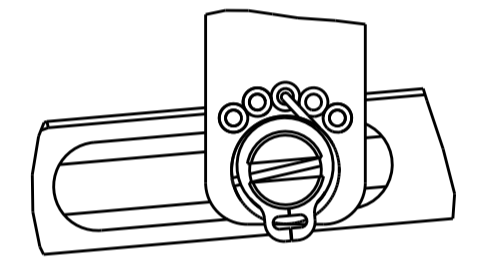
Customer Accessible Production Drawing SCALE: 1:2 SHEET: 1 OF 4 REV: D

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

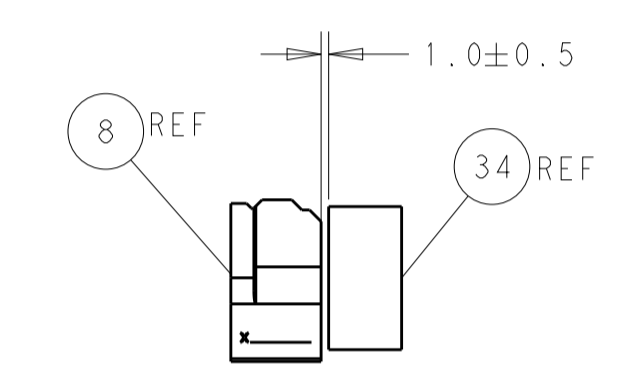
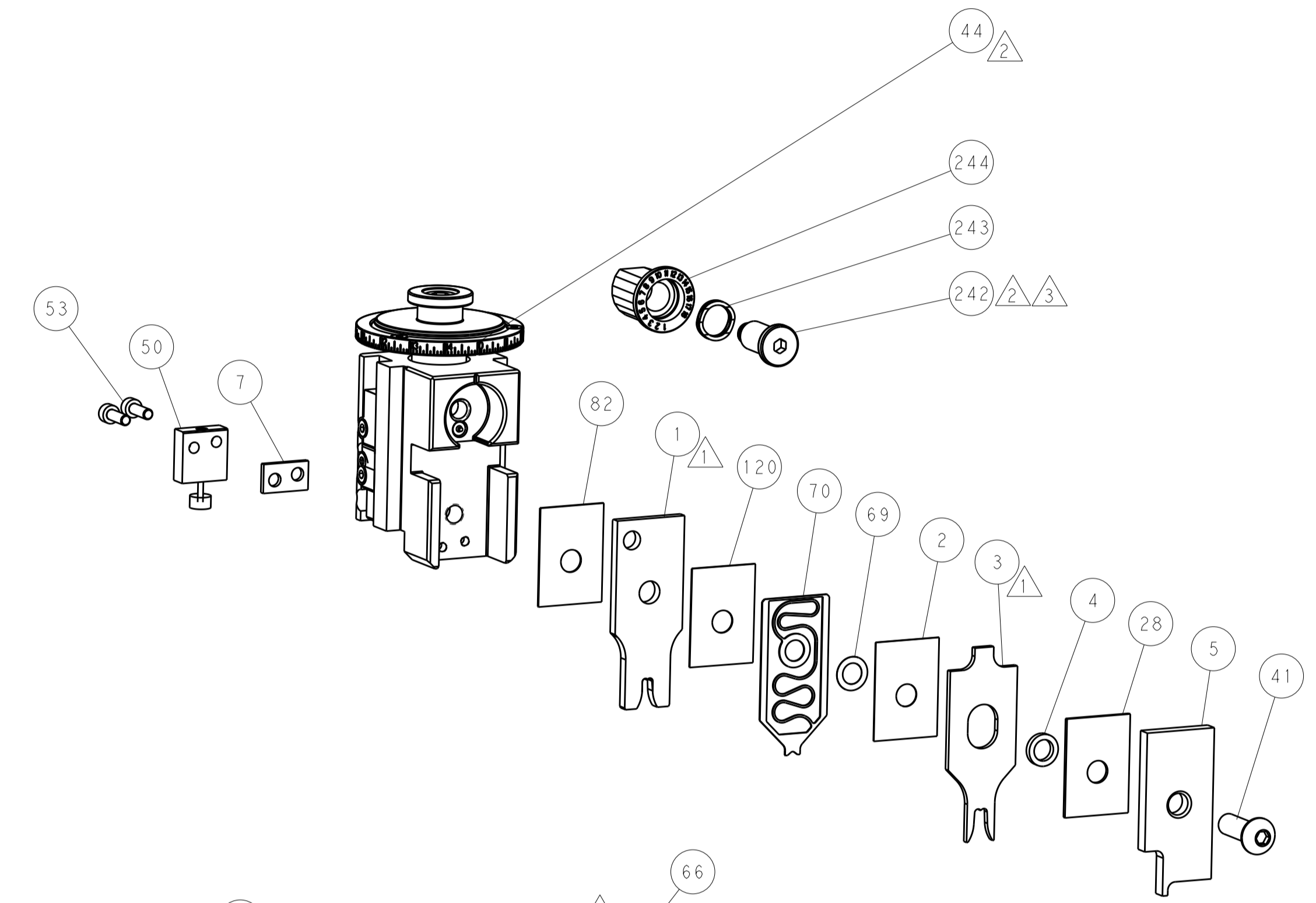
FEED TYPE PNEUMATIC



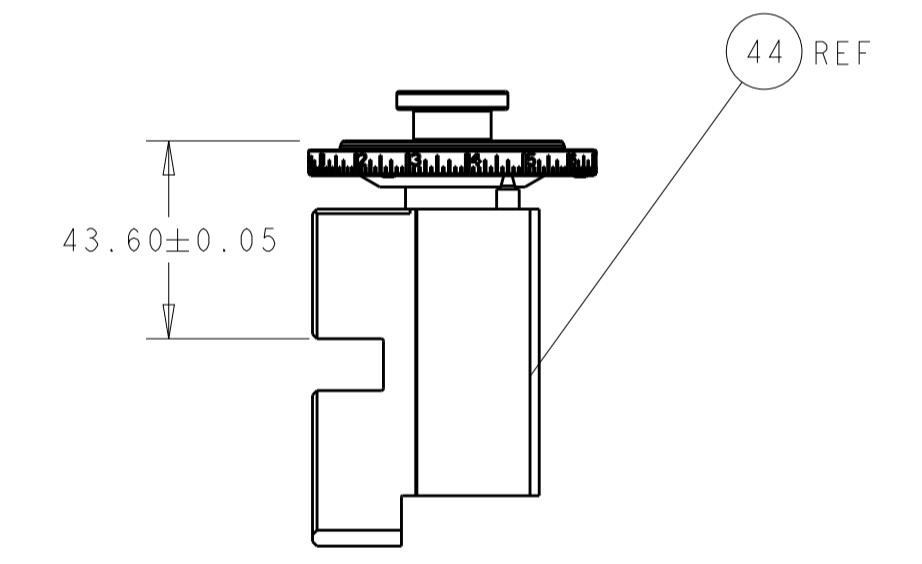
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



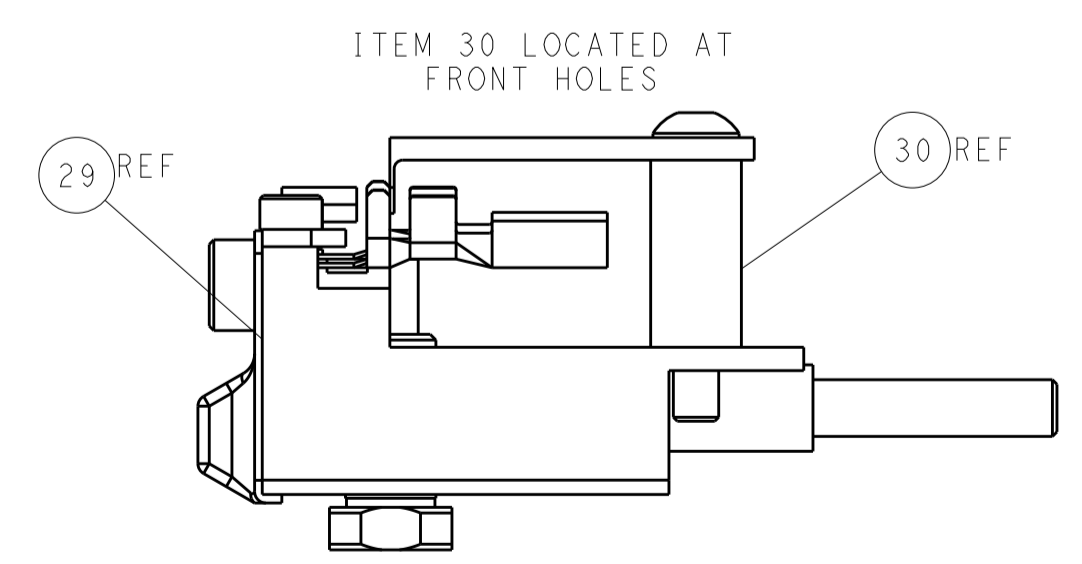
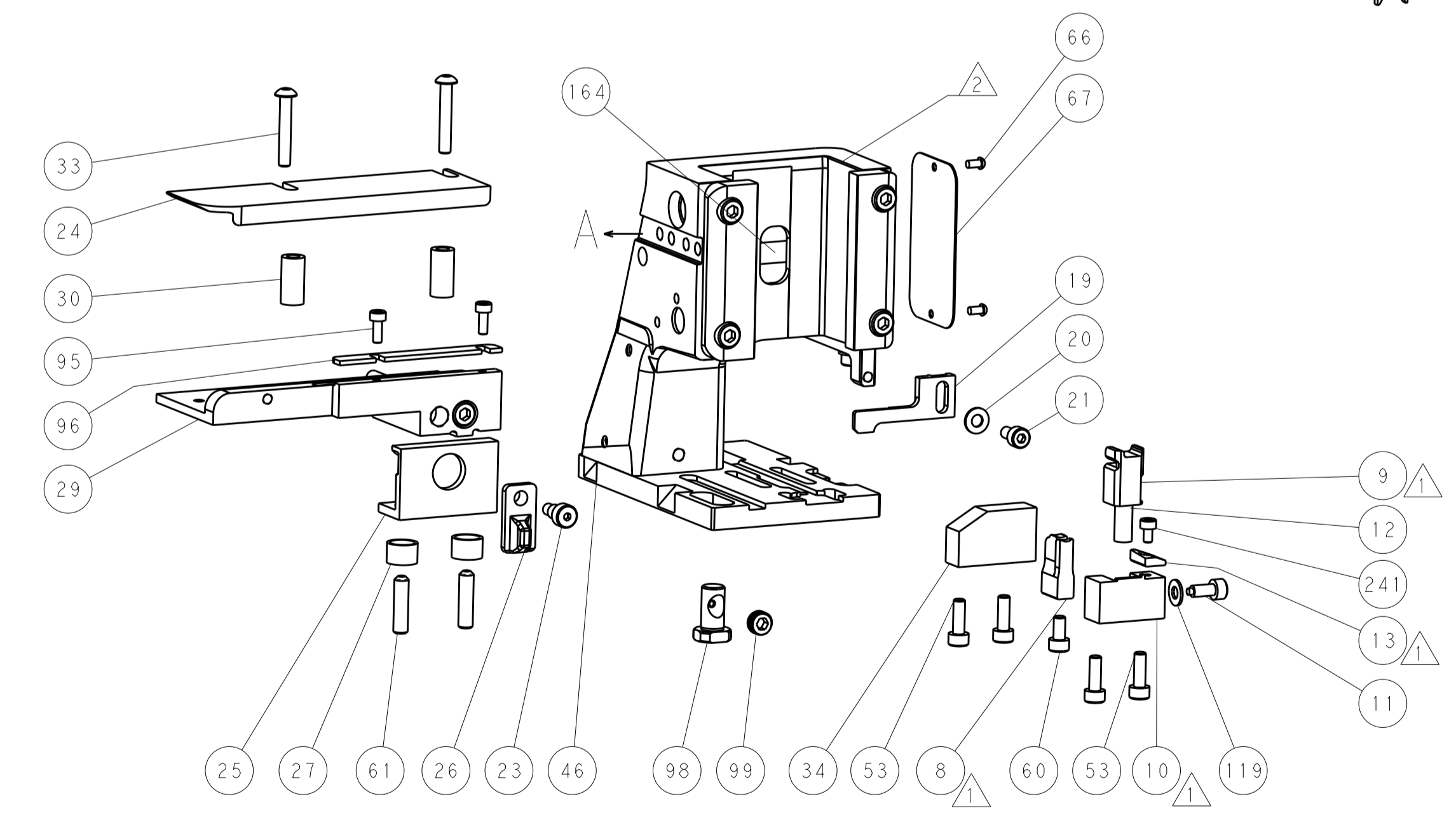
DETAIL A



TERMINAL SUPPORT LOCATION

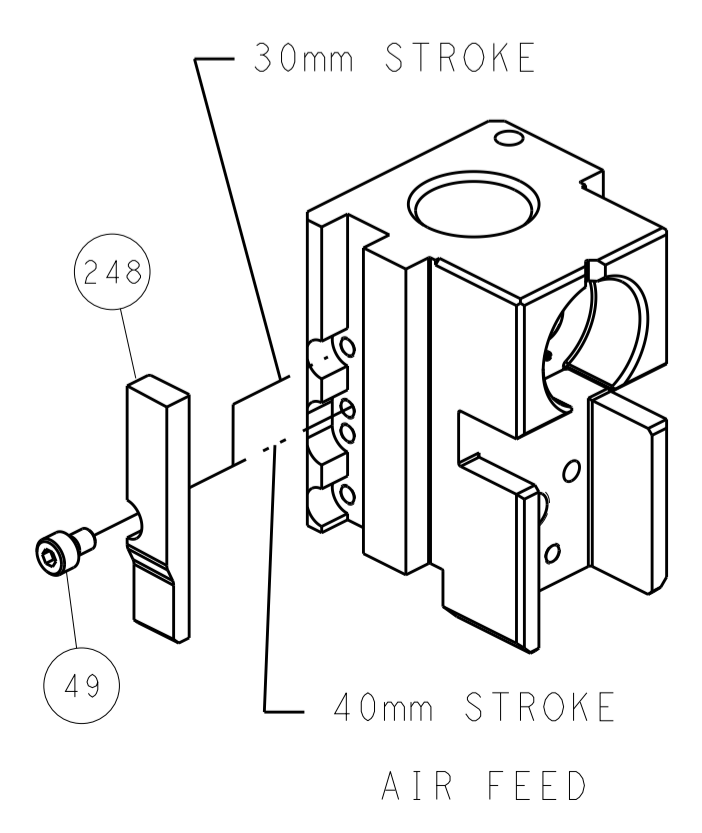


RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS

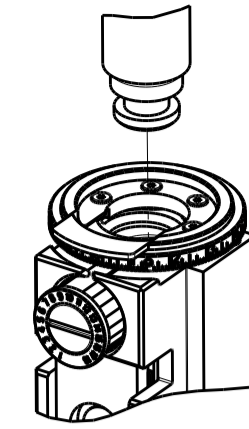


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | | | | |
|-------------|--------|--|--|-------------------------------|------------------|---|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN T. YIN 12AUG2011 | | TE Connectivity Harrisburg, PA 17105-3608 | |
| mm | 0 PLC | ± | | CHK G. BAILEY 12AUG2011 | NAME | Ocean Side Feed Applicator | |
| | 1 PLC | ± | | APVD S. XI 12AUG2011 | PRODUCT SPEC | SIZE CAGE CODE DRAWING NO RESTRICTED TO | |
| | 2 PLC | ± | | | APPLICATION SPEC | A1 00779 ©=2151487 | |
| | 3 PLC | ± | | | WEIGHT | Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV D | |
| | 4 PLC | ± | | | ANGLES | | |
| MATERIAL | FINISH | | | | | | |

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|--|--------------------------|--------------------------|-----------|
| COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. | | | |
| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
| 2-2151487-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151487-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 4.06 mm [1.60] | F |
| INSUL | 5.33 mm [2.10] | F |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| | | | |
|--|---------------|---|-------------|
| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
| TERMINAL NAME: POSITIVE LOCK RECEPTACLE | | | |
| WIRE STRIP LENGTH .189-.213 IN [4.80-5.41 mm] | | INSULATION DIAMETER RANGE Ø.134-.200 IN [3.40-5.08 mm] | |
| TERMINAL APPLICATION SPECIFICATION | (A) 114-20036 | - | - |
| | (B) 114-20029 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| (A) 790319-3 | (A) 790319-5 | (B) 281829-2 | |
| (A) 790319-4 | (B) 281829-1 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|---------------------------|--------------------------------|
| 6.00mm2 | 2.62+/-0.05 [1.03+/-0.02] | 3.7 |
| 4.00mm2 | 2.16+/-0.05 [0.85+/-0.02] | 8.9 |

- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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 | APPD |
|-----|------|-----|------|----|------|------|
| A | 66 | | | | | |

| REVISIONS | | | | | | |
|-----------|------|-------------|---------|-------------|---------|------|
| REV | DATE | DESCRIPTION | DATE | BY | CHKD | APPD |
| - | 1 | 2119082-9 | | | | 244 |
| - | 1 | 2079764-1 | | | | 243 |
| - | 1 | 2119083-1 | | | | 242 |
| - | 1 | 18023-1 | | | | 241 |
| - | 1 | 2844940-2 | | | | 238 |
| - | REF | 994970-2 | | | | 164 |
| - | 1 | 2119641-2 | | | | 151 |
| - | 1 | 2168083-8 | | | | 144 |
| - | 4 | 2168083-9 | | | | 143 |
| - | - | 2119653-2 | | | | 142 |
| - | 1 | 1-1803583-0 | | | | 141 |
| - | 1 | 1803516-1 | | | | 140 |
| - | 1 | 455888-4 | | | | 120 |
| - | 1 | 1-18028-2 | | | | 119 |
| - | 1 | 2844908-1 | | | | 99 |
| - | 1 | 2844907-1 | | | | 98 |
| - | 1 | 693855-8 | | | | 96 |
| - | 2 | 2168083-1 | | | | 95 |
| - | 1 | 455888-5 | | | | 82 |
| - | 1 | 1803607-3 | | | | 71 |
| - | 1 | 2119791-5 | | | | 70 |
| - | 1 | 2119943-1 | | | | 69 |
| - | 1 | 2119740-1 | | | | 67 |
| - | 2 | 2168078-1 | | | | 66 |
| - | 2 | 2-18032-5 | | | | 61 |
| - | 1 | 5-18022-5 | | | | 59 |
| - | 1 | 1338685-1 | | | | 56 |
| - | 2 | 2168083-3 | | | | 53 |
| - | 1 | 1803382-6 | | | | 50 |
| - | 1 | 18023-9 | | | | 49 |
| - | - | 2119652-1 | | | | 48 |
| - | 1 | 1803602-1 | | | | 41 |
| - | 1 | 3-1752356-3 | | | | 34 |
| - | 2 | 1-2079383-3 | | | | 33 |
| - | 2 | 3-2844962-5 | | | | 30 |
| - | 1 | 2844992-3 | | | | 29 |
| - | 1 | 1-455888-0 | | | | 28 |
| - | 2 | 22283-1 | | | | 27 |
| - | 1 | 356835-1 | | | | 26 |
| - | 1 | 240792-1 | | | | 25 |
| - | 1 | 1320928-2 | | | | 24 |
| - | 1 | 980371-4 | | | | 23 |
| - | 1 | 2168083-2 | | | | 21 |
| - | 1 | 1-18028-2 | | | | 20 |
| - | 1 | 2119533-1 | | | | 19 |
| - | 1 | 2119806-1 | | | | 13 |
| - | 1 | 3-22280-3 | | | | 12 |
| - | 1 | 1-356885-4 | | | | 11 |
| - | 1 | 2119805-1 | | | | 10 |
| - | 1 | 454276-5 | | | | 9 |
| 1 | 1 | 1333211-1 | | | | 8 |
| - | 1 | 1-240641-1 | | | | 7 |
| - | 1 | 1-2119757-0 | | | | 5 |
| - | 1 | 1-238011-7 | | | | 4 |
| 1 | 1 | 1-1633961-6 | | | | 3 |
| - | 1 | 455888-3 | | | | 2 |
| 1 | 1 | 456414-9 | | | | 1 |
| - | - | -77 -22 | PART NO | DESCRIPTION | ITEM NO | |

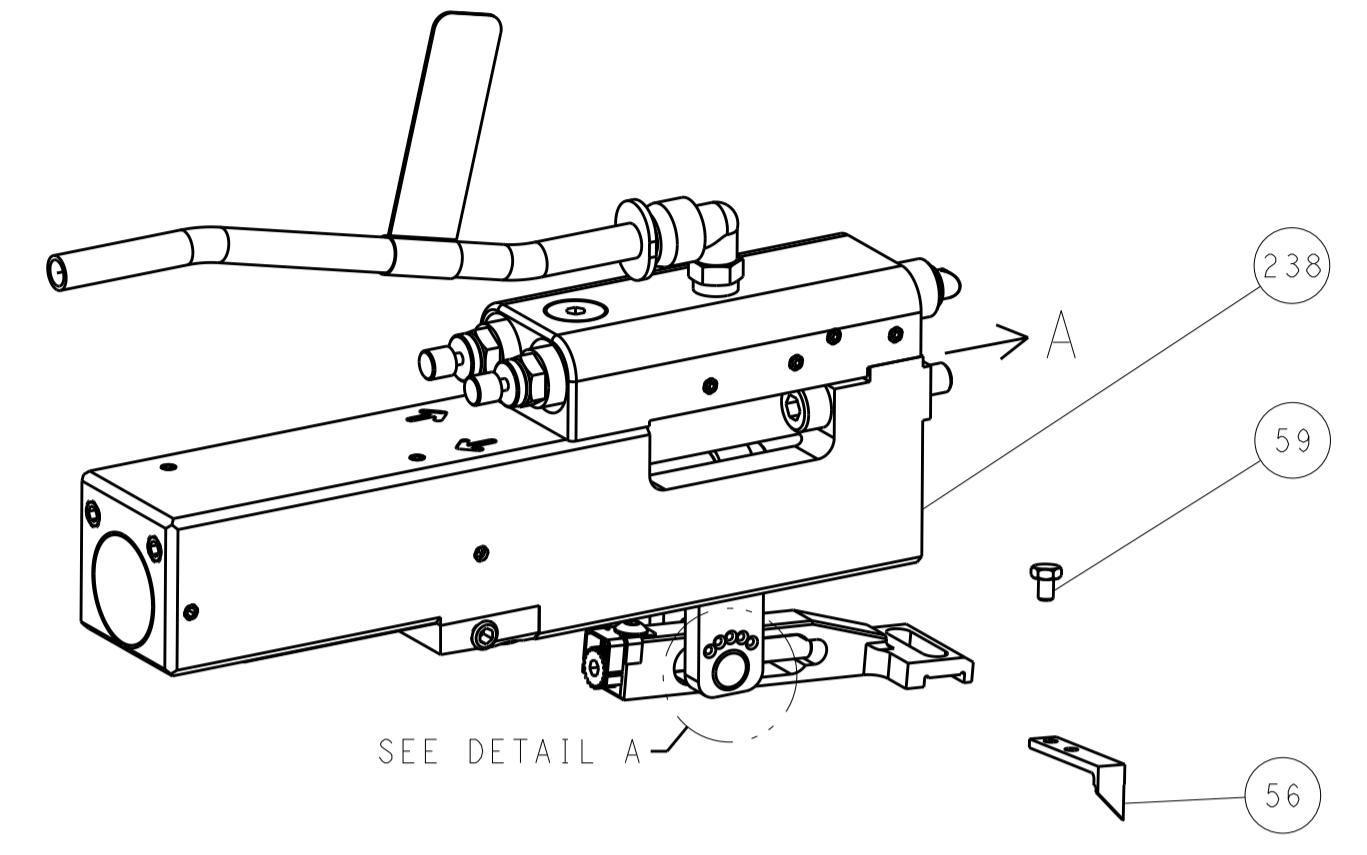
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|-------------|--|--|--|--|--|-----------|--|---------------------------|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG | | 12AUG2011 | | TE Connectivity | |
| mm | | 0 PLC ± | | CHK | | 12AUG2011 | | Harrisburg, PA 17105-3608 | |
| Ø | | 2 PLC ± | | G. BAILEY | | | | NAME | |
| H | | 3 PLC ± | | S. XI | | 12AUG2011 | | Ocean Side Feed | |
| A | | 4 PLC ± | | APVD | | | | Applicator | |
| ANGLES | | FINISH | | PRODUCT SPEC | | | | SIZE | |
| | | | | APPLICATION SPEC | | | | CAGE CODE | |
| | | | | WEIGHT | | | | DRAWING NO | |
| | | | | MATERIAL | | | | RESTRICTED TO | |
| | | | | FINISH | | | | SCALE | |
| | | | | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | | | SHEET 3 OF 4 | |
| | | | | SCALE | | 1:2 | | REV D | |

| LOC | DIST | REV | DATE | BY | APPV |
|-----|------|-----|------|----|------|
| A | 66 | | | | |

| REVISIONS | | | |
|-----------|------|-------------|----|
| REV | DATE | DESCRIPTION | BY |
| - | - | SEE SHEET 1 | - |

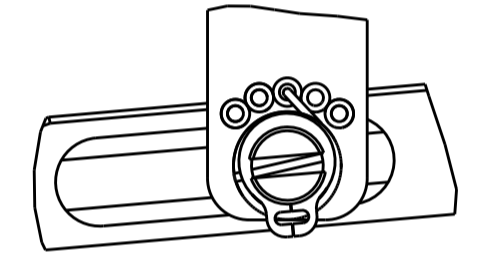
FEED TYPE

PNEUMATIC

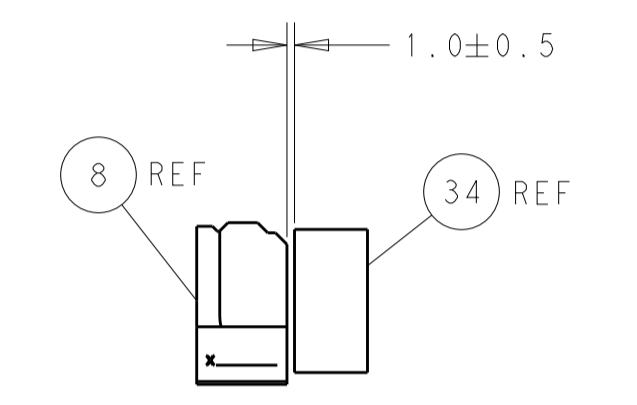
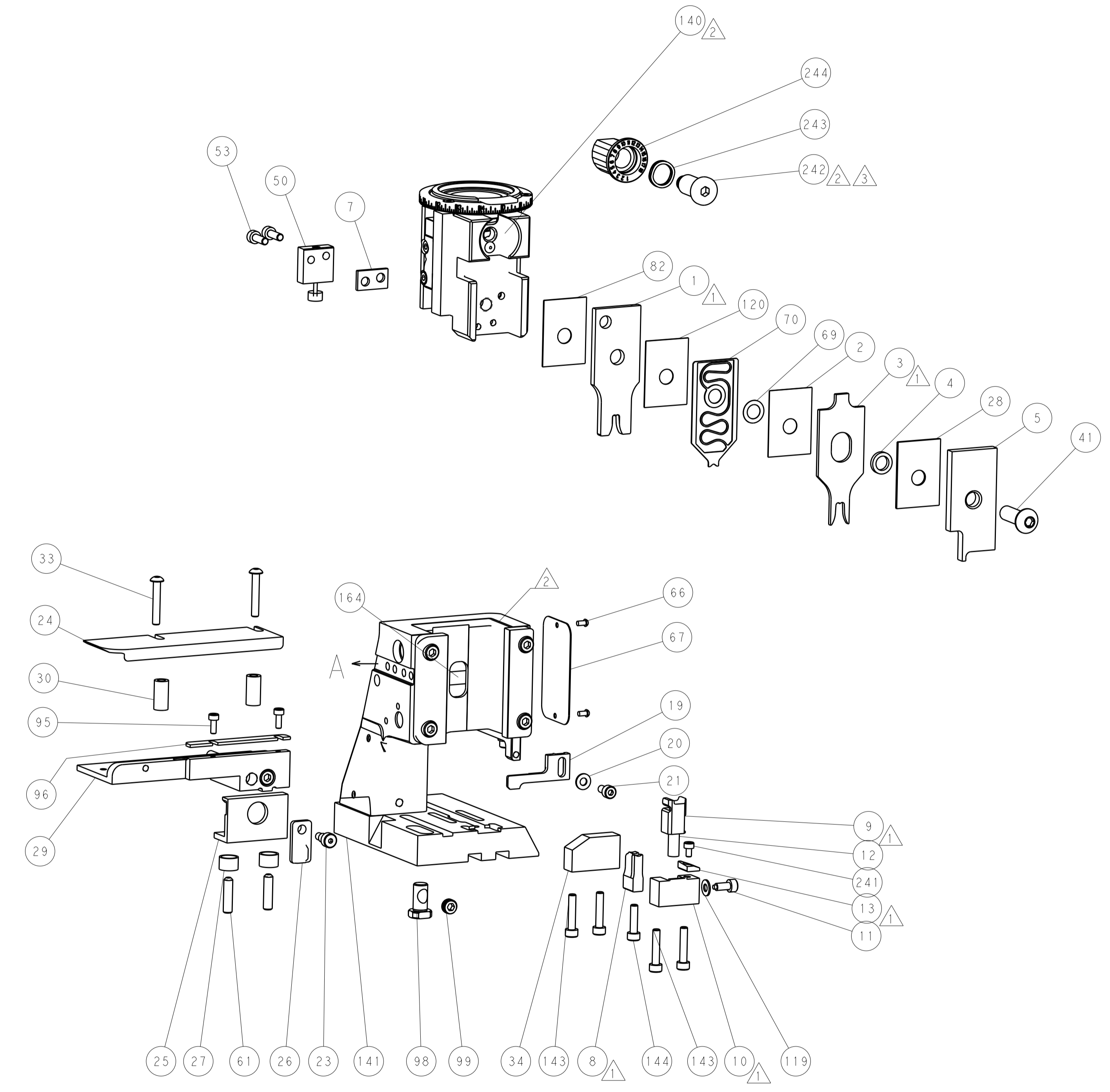


SEE DETAIL A

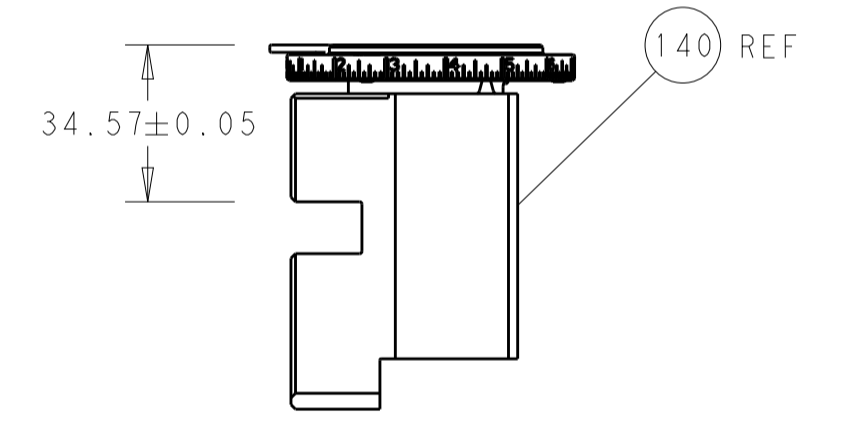
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

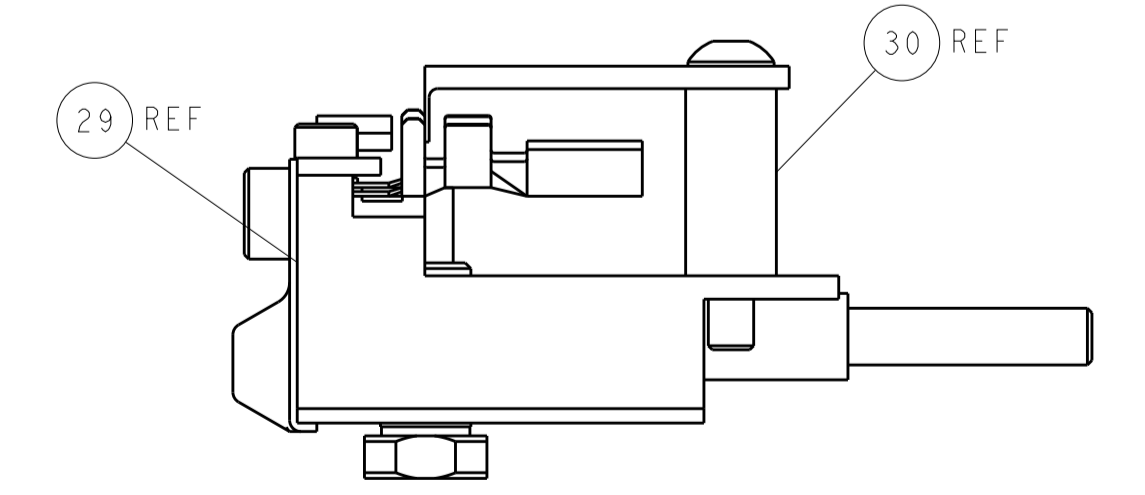


TERMINAL SUPPORT LOCATION



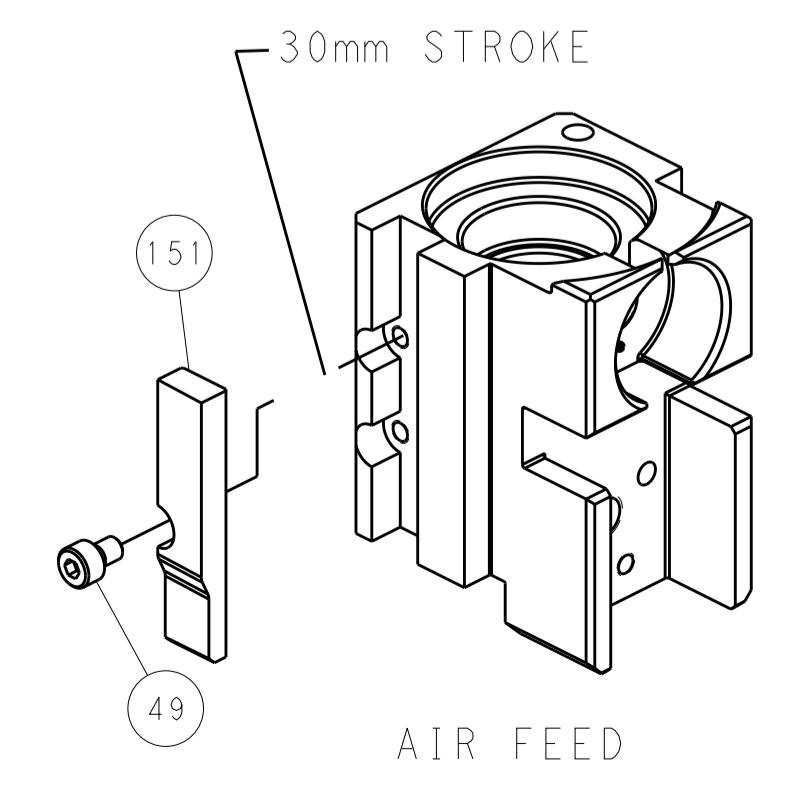
RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



AIR FEED

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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN: Y. YIN 12AUG2011 CHK: G. BAILEY 12AUG2011 APVD: S. XI 12AUG2011 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:2 | RESTRICTED TO: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151487 SHEET 4 OF 4 REV D |