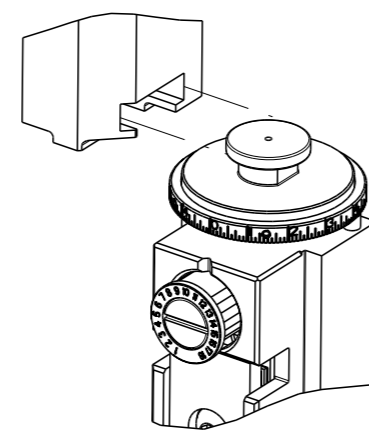


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151853-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151853-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151853-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	6.10 mm [.240]	OV

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: PRONER TERMINAL PRONER CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 8mm NG1 CAPACITE 3 A 6mm	
WIRE STRIP LENGTH 5.95-5.97 mm [.234-.235 IN]	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION	PRONER SPEC

TE TERMINAL	PRONER TERMINAL	TE SEAL	PRONER SEAL	SEAL INSULATION DIAMETER RANGE
1544227-1	2398-D-001	1544316-1		Ø3.20-4.10

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.10 +/- 0.05 [.122 +/- .002]	5.8
5.00mm2	3.00 +/- 0.05 [.118 +/- .002]	6.9
4.00mm2	2.72 +/- 0.05 [.107 +/- .002]	9.5
3.00mm2	2.54 +/- 0.05 [.100 +/- .002]	11.4

- 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 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 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.
- 8 GRIND TO LENGTH AT ASSEMBLY.

***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	REV	DATE	BY	CHK
		C	10MAR2017	MZ	KZ
		D	16NOV2018	TB	CT
		E	01MAR2021	JAH	RR
		F	29MAR2021	JWC	TE

-	1	1	1803078-1	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2844940-2	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1-690438-0	FRONT STRIP GUIDE	96	
-	1	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1	455888-8	SPACER, CRIMPER	82	
8	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-6	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	
-	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	
7	-	1	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
-	1	1	1338683-8	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1803583-3	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33	
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-4	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-4	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
1	-	1	1	2119805-2	SHEAR HOLDER, FRONT	10
1	-	1	1	318059-4	FLOATING SHEAR, FRONT	9
1	1	2	1	6-1633620-4	ANVIL, COMBINATION	8
-	1	1	240641-1	SPACER	7	
-	-	-	-	-	6	
-	1	1	2-2119781-7	DEPRESSOR, SHEAR	5	
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4	
1	1	2	1	1803209-7	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1-455888-7	SPACER, CRIMPER	2	
1	1	2	1	1-1633738-7	CRIMPER, WIRE	1
-	77	-72	-2	PART NO	ITEM NO	

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

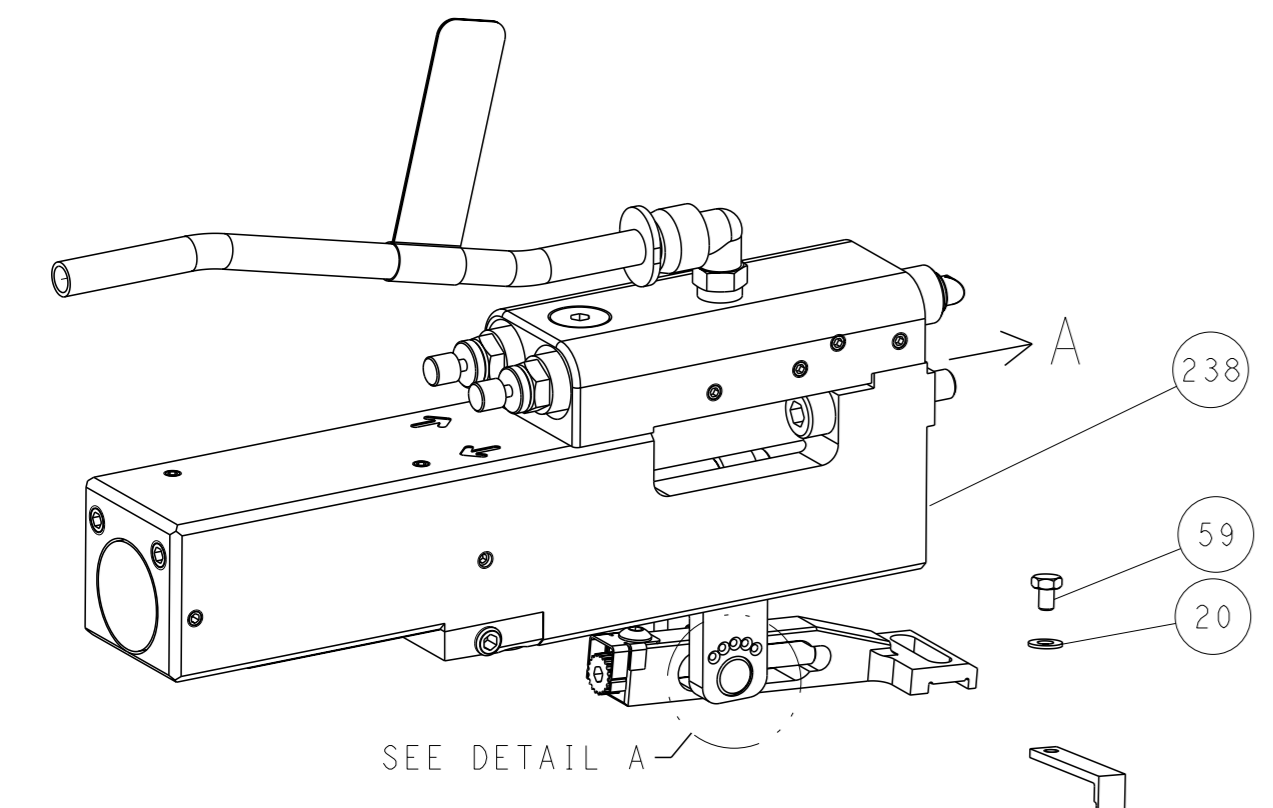
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL		WEIGHT		SCALE	

OWN	Y. YIN	14JAN2013	TE Connectivity Harrisburg, PA 17105-3608
CHK	G. BAILEY	14JAN2013	
APVD	S. YI	14JAN2013	NAME
PRODUCT SPEC			Ocean Side Feed Applicator
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151853	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV F

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

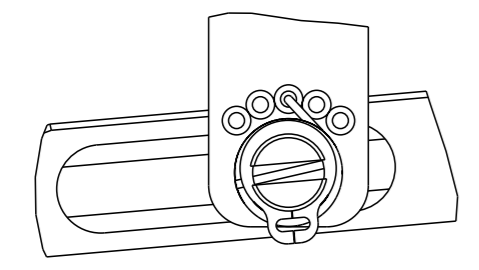
FEED TYPE

PNEUMATIC



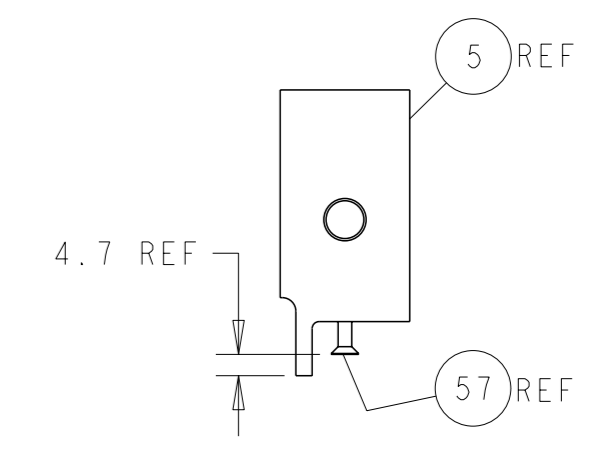
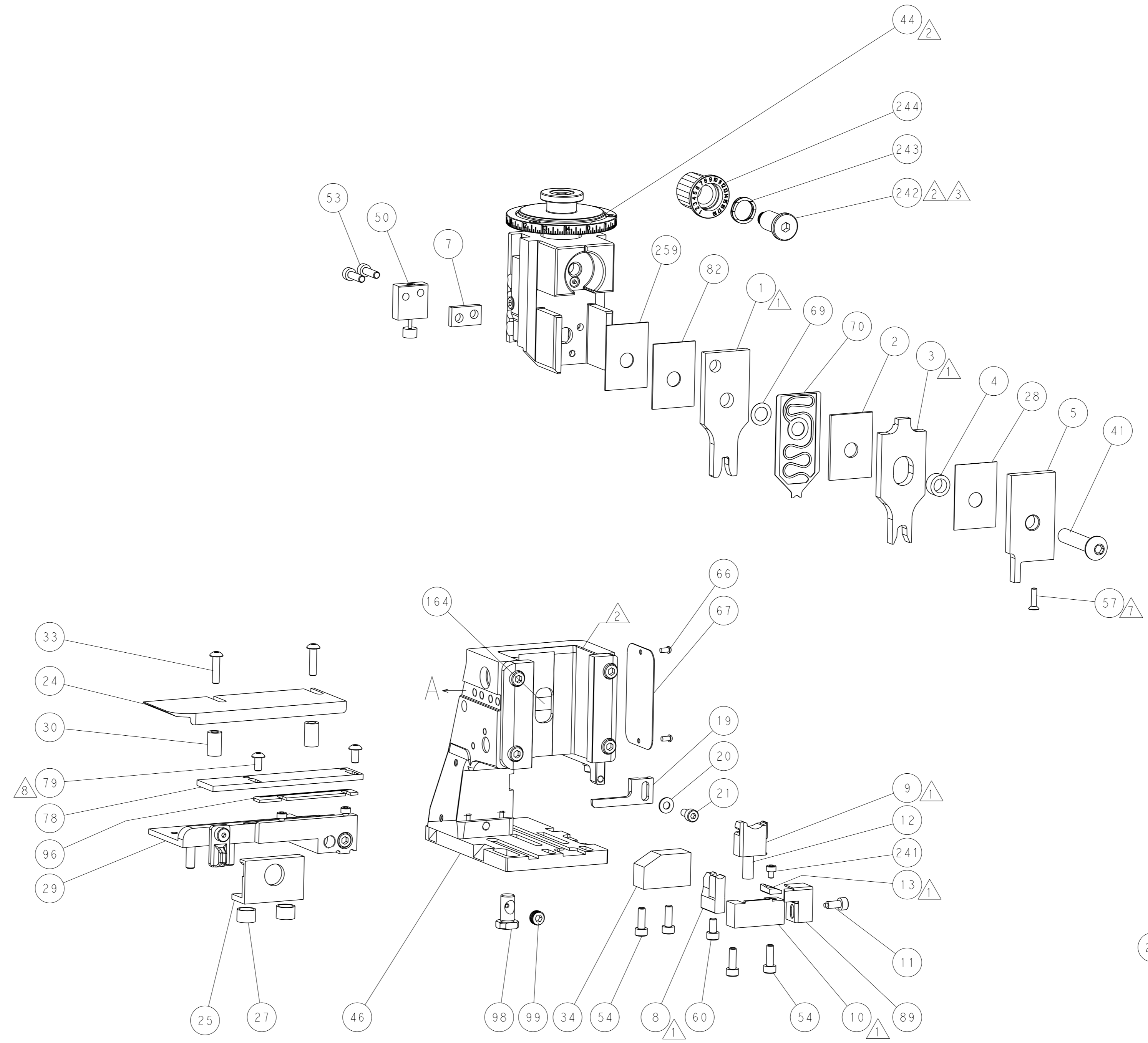
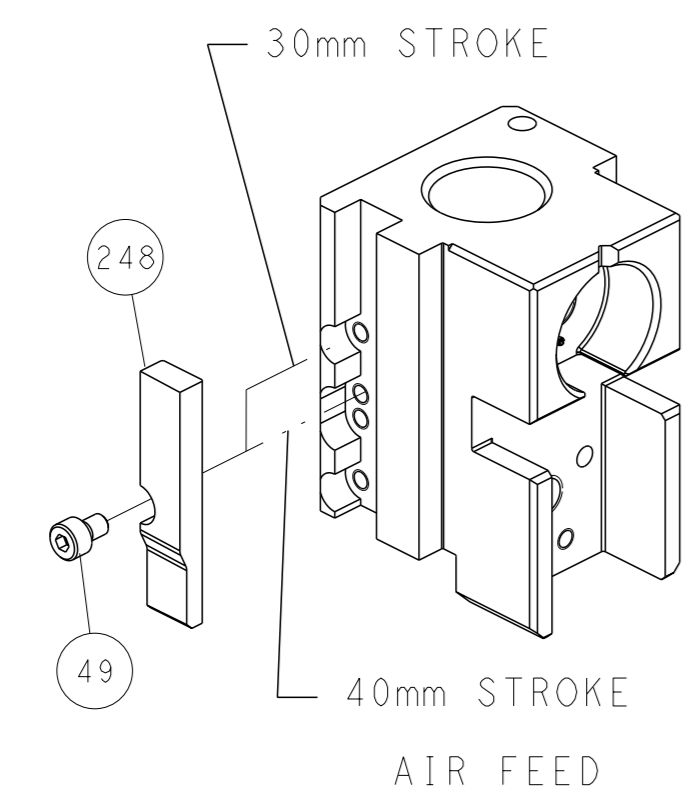
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

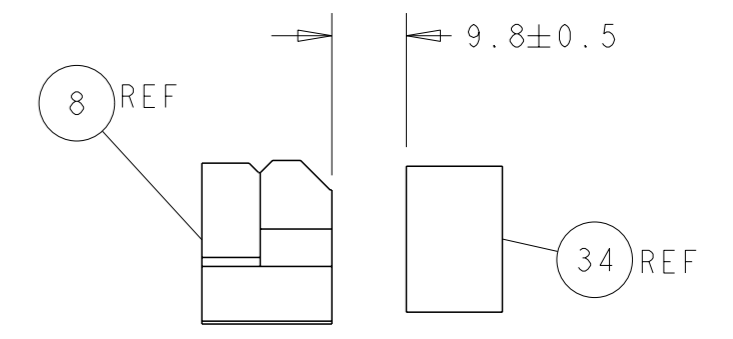


DETAIL A

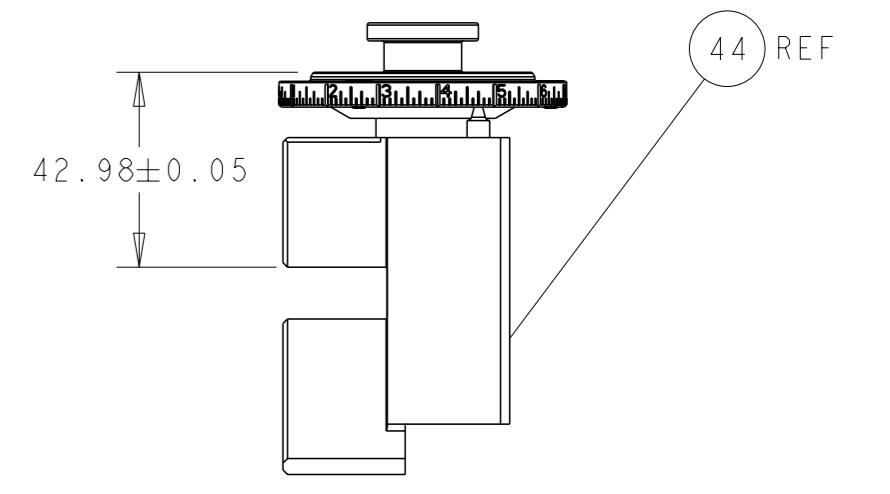
CAM POSITION



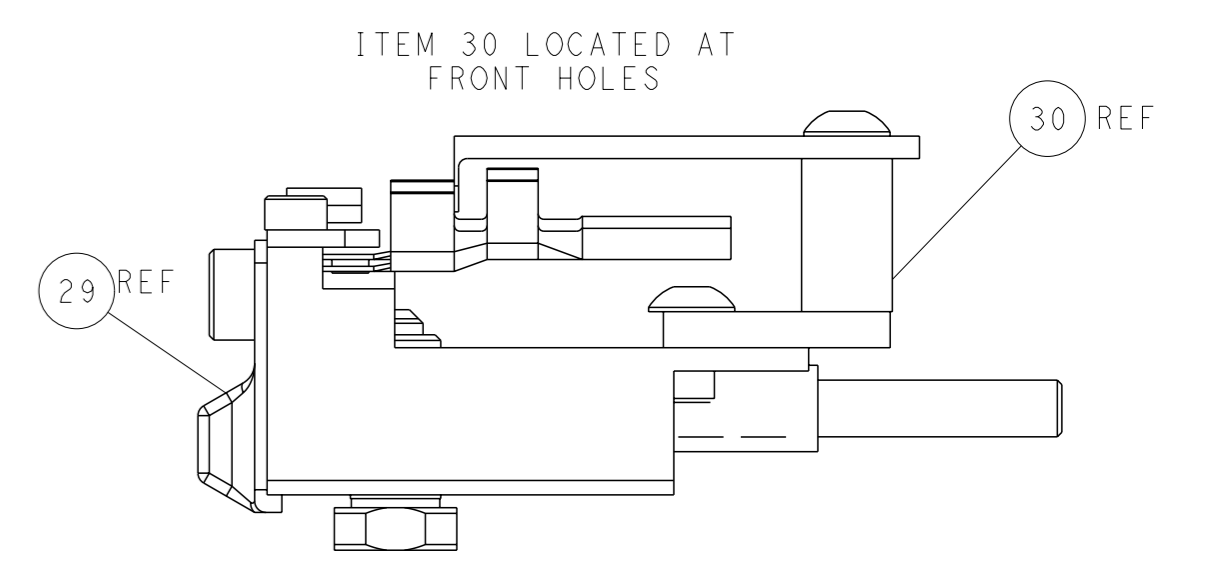
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



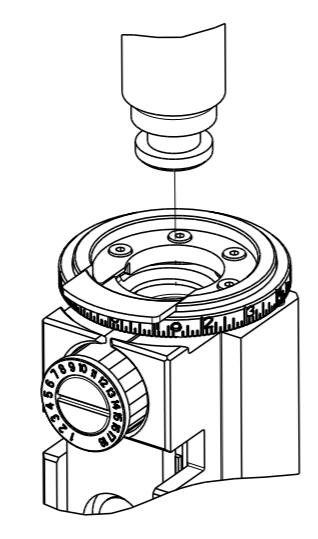
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN 14JAN2013 CHK: G. BAILEY 14JAN2013 APVD: S. YI 14JAN2013	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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151853	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: F
MATERIAL: - FINISH: -		WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: F	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151853-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151853-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	6.10 mm [.240]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: PRONER TERMINAL PRONER CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 8mm NG1	CAPACITE 3 A 6mm
WIRE STRIP LENGTH 5.95-5.97 mm [.234-.235 IN]	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION	PRONER SPEC

TE TERMINAL	PRONER TERMINAL	TE SEAL	PRONER SEAL	SEAL INSULATION DIAMETER RANGE
1544227-1	2398-D-001	1544316-1		Ø3.20-4.10

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.10+/-0.05 [.122+/- .002]	5.8
5.00mm2	3.00+/-0.05 [.118+/- .002]	6.9
4.00mm2	2.72+/-0.05 [.107+/- .002]	9.5
3.00mm2	2.54+/-0.05 [.100+/- .002]	11.4

- 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.
- 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.
- GRIND TO LENGTH AT ASSEMBLY.

***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	REV	DESCRIPTION	DATE	OWN	APVD
A	66	-	SEE SHEET 1	-	-	-

-	1	1803078-1	SPACER, PRECISION	259
-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-2	AIR FEED MODULE	238
-	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
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1803583-4	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	318563-1	GUARD, FRONT CHIP	89
-	1	455888-8	SPACER, CRIMPER	82
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1803096-1	EXTENSION PLATE	78
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119791-6	DEPRESSOR, WIRE	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
-	1	1338683-8	FEED PAWL	56
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	455888-4	SPACER, CRIMPER	28
-	2	22283-1	SPRING, COMPRESSION	27
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-4	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-2	SHEAR HOLDER, FRONT	10
-	1	318059-4	FLOATING SHEAR, FRONT	9
-	1	6-1633620-4	ANVIL, COMBINATION	8
-	1	240641-1	SPACER	7
-	-	-	-	6
-	1	2-2119781-7	DEPRESSOR, SHEAR	5
-	1	4-238011-4	BLOCK, CRIMPER SPACER	4
-	1	1803209-7	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1-455888-7	SPACER, CRIMPER	2
-	1	1-1633738-7	CRIMPER, WIRE	1
-	77	-22	PART NO	ITEM NO

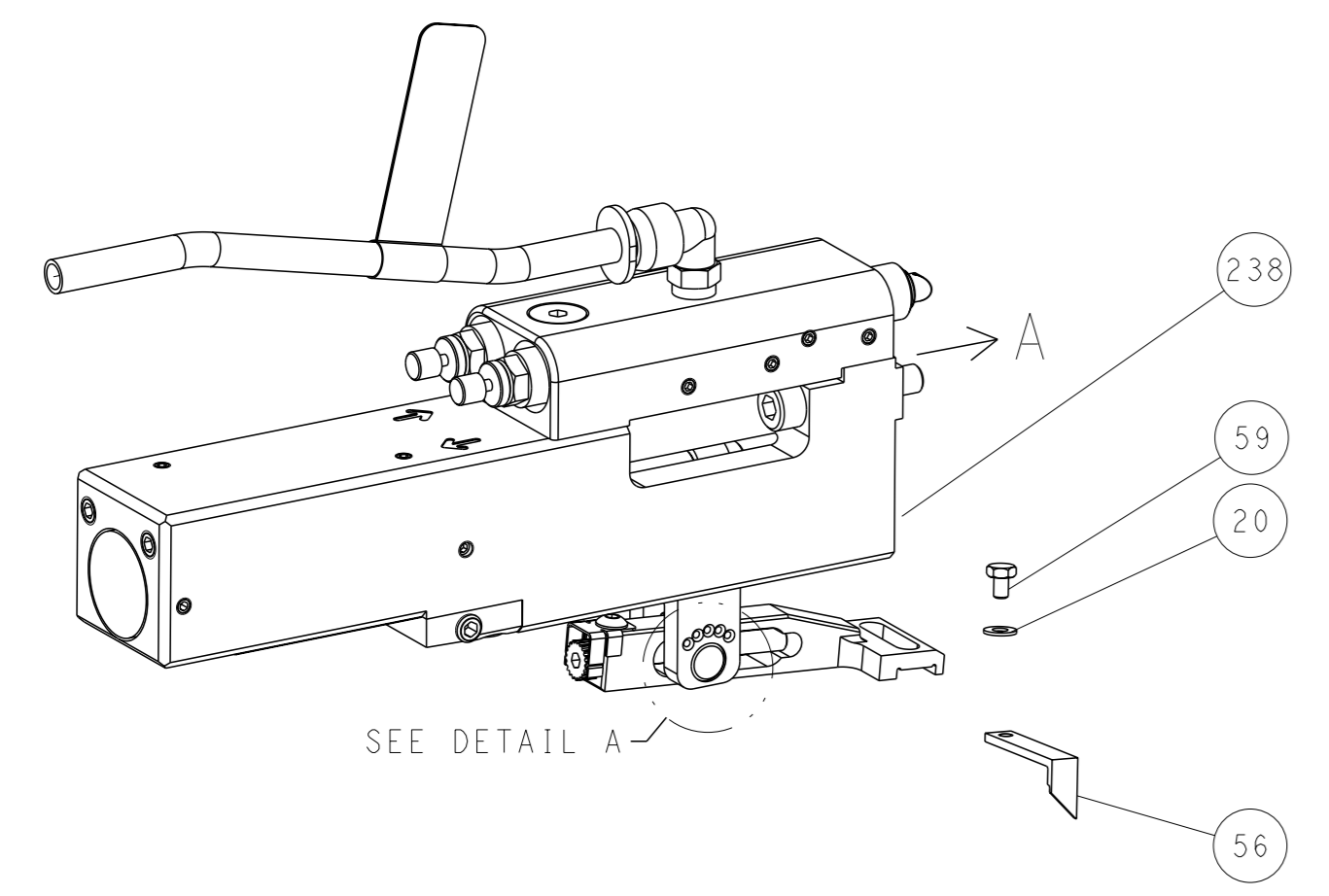
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: Y. YIN 14JAN2013 CHK: G. BAILEY 14JAN2013 APVD: S. YI 14JAN2013		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151853 RESTRICTED TO:	
MATERIAL:				WEIGHT:		SCALE: 1:2 SHEET 3 OF 4 REV F	

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

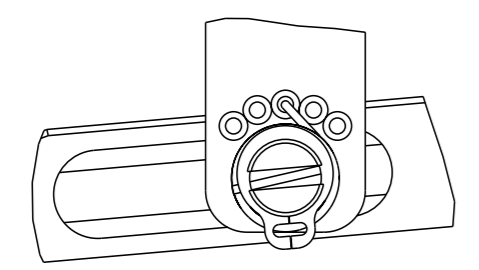
FEED TYPE

PNEUMATIC



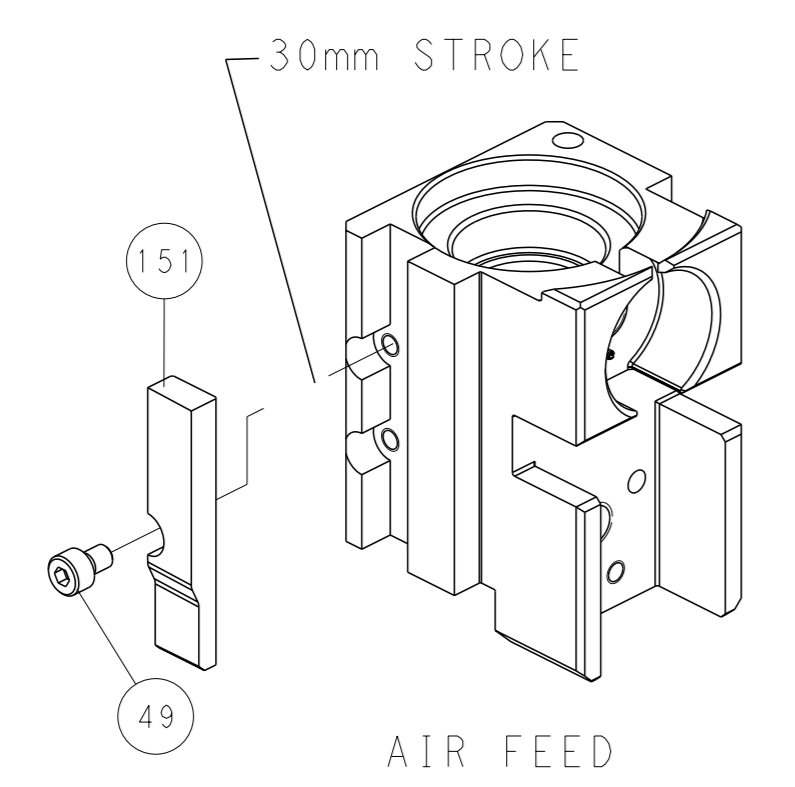
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

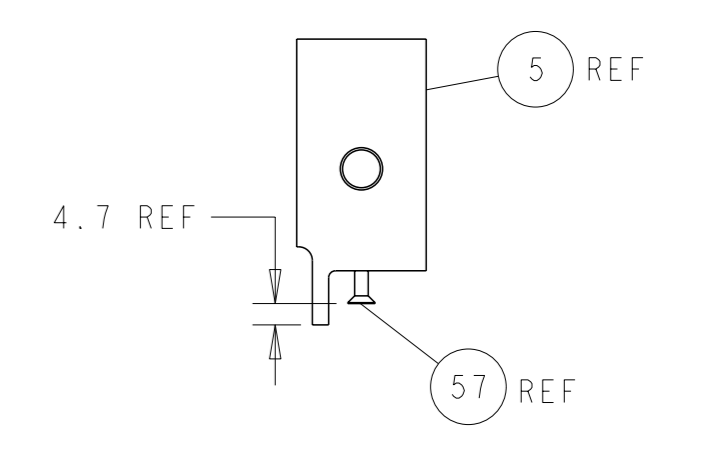
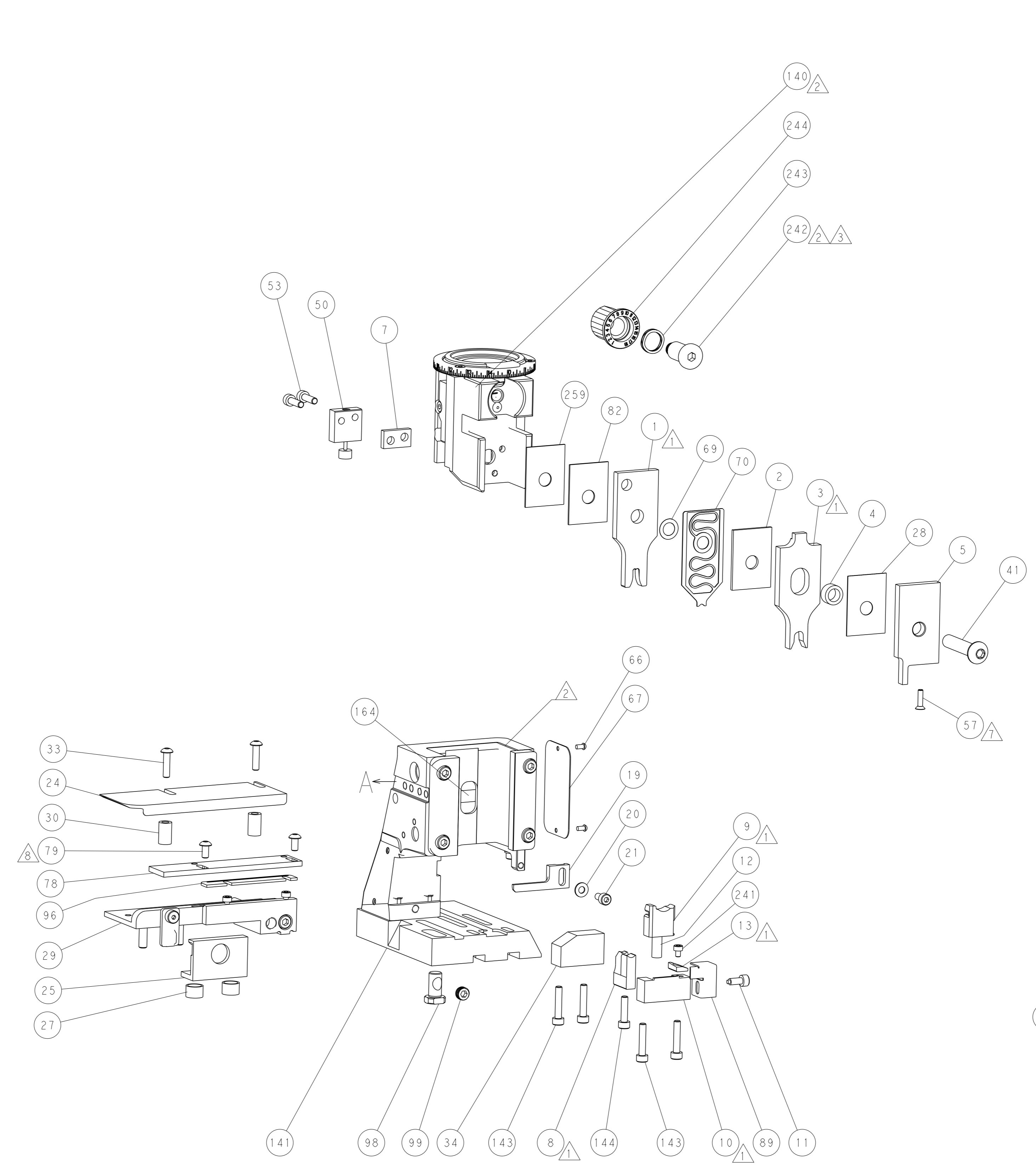


DETAIL A

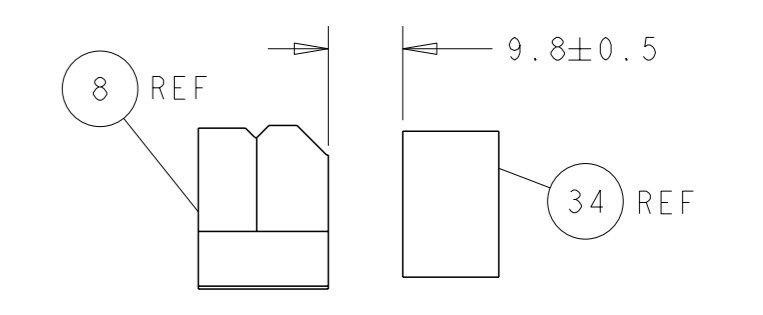
CAM POSITION



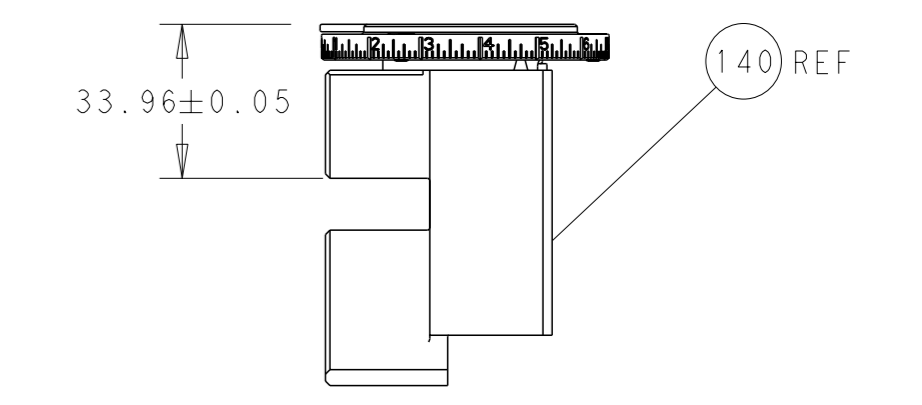
AIR FEED



SHEAR DEPRESSOR DETAIL

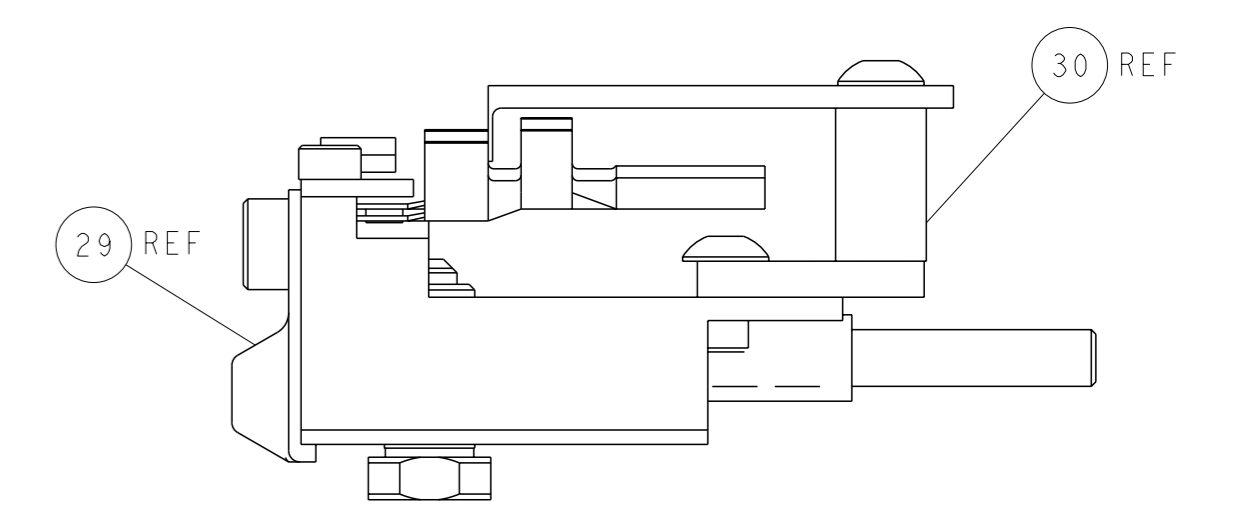


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN Y. YIN 14JAN2013 CHK G. BAILEY 14JAN2013 APVD S. XI 14JAN2013	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 PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2151853 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV F